

MIL-T-2423L(NU)

30 September 1988

~~SUPERSEDING~~

MIL-T-2423K

17 September 1984

MILITARY SPECIFICATION

TROUSERS, MEN'S (WHITE)

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 white polyester/cotton trousers.

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

Sizes: 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37,
38, 40, 42, 44, 46, 48 and 50

Lengths: Short, Regular, Long and Extra Long

2. APPLICABLE DOCUMENTS

2.1 Government documents.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, Natick, MA 01760-2490 by using the self addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8405

DISTRIBUTION STATEMENT A. Approved for public release, distribution is unlimited.

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

SPECIFICATIONS

FEDERAL

- V-B-871 - Button, Sewing Hole, and Button, Staple (Plastic)
- V-F-106 - Fasteners, Slide, Interlocking
- V-T-276 - Thread, Cotton
- V-T-280 - Thread, Cotton, Gimp, Buttonhole
- *NN-P-71 - Pallet, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way (Partial)
- CCC-C-438 - Cloth, Buckram, Cotton
- DDD-L-20 - Label; For Clothing, Equipage and Tentage (General Use)

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- MIL-P-15011 - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry
- MIL-B-17757 - Boxes, Shipping, Fiberboard (Modular Sizes)
- MIL-C-29127 - Cloth, Twill, Polyester/Cotton (Crease-Resistant Finish)
- MIL-T-43548 - Thread, Polyester Core: Cotton-, Rayon-, or Polyester-Covered
- MIL-C-43718 - Cloth, Twill, Polyester; Polyester and Cotton, Polyester and Rayon for Pockets
- MIL-C-43920 - Cloth, Interlining, Cotton or Synthetic, and Nylon

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-1488 - Provisions for Evaluating Quality of Trousers

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

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

LAWS AND REGULATIONS

US POSTAL SERVICE MANUAL

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

2.2 Other publications. The following document(s) form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issue of the nongovernment 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 American Trucking Association, Inc., ATIN: Traffic Department, 1616 P Street, NW, Washington, DC 20036-1404).

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

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

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense Standard Shades for Buttons

Department of Defense Standard Shades for Sewing Threads

(Application for copies of color cards should be addressed to the Color Association of the U.S. Inc., 343 Lexington Avenue, New York, NY 10016).

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

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3. REQUIREMENTS

3.1 Guide sample. Guide samples, when furnished, are solely for guidance and information to the contractor (see 6.3). Variation 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 Materials.

3.3.1 Basic cloth. The basic cloth shall be a polyester/cotton crease-resistant finish twill, shade White 3053, conforming to class 2 of MIL-C-29127.

3.3.2 lining. The material for the waistband lining and right fly lining shall be twill cloth conforming to class 1 of MIL-C-43718. The material for the left fly interlining may be the same as above or as an alternate the material stated in 3.3.1. The materials shall be bleached white.

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

3.3.4 Waistband stabilizer. The material for the waistband stabilizer shall be interlining cloth conforming to MIL-C-43920.

3.3.5 Pocketing. The material for the pockets shall be made of twill cloth conforming to class 1 of MIL-C-43718. The materials shall be bleached white.

3.3.6 Thread.

3.3.6.1 Thread, polyester, covered. The thread used for stitching and seaming shall be a cotton or rayon covered, polyester core, matching shade White AH, Cable No. 66050 in accordance with DOD Standard Shades for Sewing Thread, and shall conform to MIL-T-43548 as follows except that the polyester core, polyester covered thread is not allowed:

Use	Ticket No.	Ply
Seaming and tacking	50, 70	2 or 3
Overedging	70	2 or 3
Button sewing	50	2 or 3

3.3.6.2 Thread, cotton. As an alternate, a cotton thread may be used. When this option is exercised, the thread shall match shade White, Cable No. 66050 in accordance with DOD Standard Shade for Sewing Threads, and shall conform to V-T-276 as follows:

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Use	Type	Ticket No.	Ply
Seaming	IA2	40, 50	2 or 3
Overedging	IA2	70	2
Bartacking	ICI	A, B	3
Button sewing	IB2	20	4

* 3.3.6.3 Automatic pocket machine. When an automatic pocket machine using a 101 stitch type is used, the thread shall be type IC2, Ticket No. A, 3 ply conforming to V-T-276. When an automatic pocket machine using a 301 stitch type is used, the thread shall be Ticket No. 50, 2 or 3 ply conforming to MIL-T-43548. The color shall be as stated in 3.3.6.1 or 3.3.6.2.

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

3.3.7 Gimp. The gimp for reinforcing the hip pocket buttonhole shall be cotton, bleached white AH, Cable No. 66050 in accordance with DOD Standard Shade for Sewing Threads, conforming to type I or II, No. 8 of V-T-280.

3.3.7.1 Colorfastness. The gimp shall show colorfastness to laundering equal to or better than the standard sample when tested as specified in V-T-280. As a limit of acceptability, or when no standard is available, the gimp shall show a minimum of "good" colorfastness to laundering when tested as specified in V-T-280.

3.3.8 Button. The button for the left hip pocket shall be plastic type II, class D, style 4, 22-line conforming to V-B-871. The button shall be shade White BA, Cable No. 62031 in accordance with DOD Standard Shade for Buttons.

* 3.3.9 Slide fastener. The slide fastener for closing the fly shall conform to type I, style 1, cam lock, size LS, short-tab pull of V-F-106, except that all metal components of the slide fastener shall be fabricated of brass and purchased from the same supplier (see 4.4.1). A staple bottom stop is required.

3.3.9.1 Slide fastener tape. The tape for the slide fastener shall be cotton or synthetic or a combination. The tape shall show good fastness to laundering as specified in V-F-106. The tape shall approximate the shade of the basic material.

3.3.10 Hook and eye. The hook and eye for the trouser waistband shall be nickle plated finish, North and Judd (Hook Flex H49, and E50); Universal Fastener Inc. (#8 hook with #8 or #85 eye); Akim Co. (Junior Series - type JB, Slim-Slak with MB eye and Slik-Slak) or functionally interchangeable equivalent (see 4.4.1 and 6.4).

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3.3.11 Labels.

3.3.11.1 Combination Label. Each pair of trousers shall have a combination personal, identification and instruction label conforming to types III, IV, or VI, classes 10 and 15 of DDD-L-20. The inscription shall show fastness to laundering. The label or marking shall be centered on the right hip pocketing so that on the finished trousers it will face the wearer. The inscription shall be as follows:

NAME:
 SERVICE NO.:
 TROUSERS, MEN'S (WHITE)
 FIBER CONTENT: Polyester(50%)/Cotton(50%)
 CONTRACT NO: DLA 100-00-0-0000 (Example)
 NAME OF CONTRACTOR
 NAME OF MANUFACTURER (If other than contractor)

LAUNDERING INSTRUCTION

Machine Wash - Hot Water
 DO NOT USE CHLORINE BLEACH
 Tumble Dry - Medium Heat, Remove Promptly

or

USE NAVEDTR 414-01-45-81 - Formula II

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

SIZE: 34R (EXAMPLE)
 STOCK NUMBER: 8405-00-000-0000 (EXAMPLE)

NOTE: Abbreviations for applicable lengths shall be as follows:

S - Short R - Regular L - Long XL - Extra Long

* 3.3.11.3 Removable size ticket. Each trouser shall have a commercial type size ticket attached to the outside of the waistband above the left back pocket. 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 (34R - Example) shall be printed or stamped on the upper left hand corner in black or blue ink. The lettering for the size shall be 1/4 inch in height. Abbreviations for lengths shall be allowed in accordance with 3.3.11.2.

3.4 Design. The trousers shall be of single needle construction, with two straight side front pockets, two double welt hip pockets, seven belt loops, hook and eye waistband, slide fastener fly closure, and bell bottoms. Leg bottoms shall be unhemmed (see Figure 1).

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3.4.1 Figures. The figures are furnished for information purposes only. When inconsistencies exist between the specification and the figures, the 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 allow 3/8 inch seam allowance for all seams except 1/2 inch seam allowance for seat seam, inseams and outseams, and 7/8 inch outlets at top of seat seam, except as otherwise indicated in Table I.

3.5.1 List of pattern parts. The component parts of the trousers shall be cut from materials as specified and in accordance with the pattern parts required for the manufacturing process as follows:

MATERIAL	NOMENCLATURE OF PATTERN PARTS	CUT PARTS
Basic Material	Front	2
	Back	2
	Waistband	2
	Right fly	1
	Left fly facing	1
	Side pocket facing	2
	Side pocket bearer	2
	Hip pocket facing	2
	Hip pocket bearer	2
Twill cloth	Side pocket	2
	Hip pocket	2
	Right fly lining	1
	Left fly interlining ^{1/}	1
	Waistband lining	2

^{1/} Pattern part may be cut from basic material.

3.6 Construction.

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* 3.6.1 Stitches, seams, and stitchings. Stitch, seam, and stitching types specified in Table I shall conform to FED-STD-751. Whenever two or more methods for seam or stitch types are given for the same part of the operation any one may be used. Seam allowances shall be maintained with seams sewn so that no raw edges, runoffs, twists, pleats, puckers, or open seams result. All seams shall start and finish evenly. Thread tension shall be maintained so that there is not tight or loose stitching. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the trousers. Ends of all seams produced by stitch type 401, shall be caught in other seams of stitchings except for the bottom of legs where a chain of 1/4 to 3/8 inch shall be left untrimmed. Topstitching and edgestitching shall be 1/16 inch to 1/8 inch from the edge. The bight of the overedge stitching shall be 3/16 inch. The guide and knife shall be set to trim only the ravelled ends of the fabric. The use of a trimming knife in the overedging of the right fly in operations 4d and 7b is prohibited.

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

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

3.6.4 Buttonholes. The buttonholes specified in Table I shall be clean cut, and correctly positioned. The stitching shall be caught in the fabric with the purling on the outside. Buttonholes shall be of the eyelet end, taper bar type, with ends tacked, and worked over gimp. The cut length shall be 5/8 to 3/4 inch. The bar end of buttonhole shall have a minimum of 4 stitches not counting the first cross-over in that it is part of the buttonhole not the bar. Ends of gimp finishing on top of buttonhole shall be pulled through to the underside.

* 3.7 Manufacturing operations requirements. The trousers shall be manufactured in accordance with all operation requirements specified in Table I. The contractor is not required to follow the exact sequence of operations listed provided that the finished trouser is identical to that produced by following the sequence of operations.

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

- (a) Corrosive metal fastening devices
- (b) Sew on type tickets
- (c) Adhesive type tickets which show discoloration and the adhesive mass adheres to the material upon removal of the tickets.

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

3.7.3 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
Btrhl	-	Buttonhole
incl	-	including
dbl	-	double

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TABLE I - CONSTRUCTION OF TROUSERS

D.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread	
					Ndl	Bob/ Lpr

5. Cutting trousers.

a. Cut trousers in strict accordance with patterns furnished which show size, placement of pockets, directional lines and notches for proper assembling of cut parts. Lay fronts and back so that the directional line is in the warp direction. The directional line on the fronts and backs may vary from the warp direction by not more than 1 inch. Measurement shall be taken from the top and bottom of the directional line on pattern to the selvage edge of the fabric and the difference between the two measurements shall not exceed the tolerance specified.

b. Cut all parts of the trousers out of one piece of material, except right fly and left fly facing, left fly interlining (as applicable), side pocket narrow facing, hip pocket bearer, and belt loops, which may be cut from ends. Parts cut from ends shall approximate the shade of the trousers. Cut stripping for belt loops of sufficient width to comply with operation 5. Cut side pocket, hip pocket and right fly lining, left fly interlining (as applicable), and waistband lining from twill cloth.

c. Cut the right fly lining, waistband lining and waistband interlining parts on the bias and wide enough to comply with operation 13.a.

OR

d. The waistband lining may be the preassembled commercial type using the twill cloth and buckram materials specified.

OR

e. (When applicable) cut waistband stabilizer of sufficient length to comply with operation 13.a.

OR

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread Ndl Bob/ Lpr
	f. (When applicable) The waistband lining may be commercial type using the lining, interlining and waistband stabilizer materials specified.				
2.	<u>Replacement of defective components.</u>				
	During the spreading, cutting and manufacturing process, components having material defects or damages that are classified as defects in MIL-STD-1488 shall be removed from production and replaced with non-defective and properly matched components.				
3.	<u>Shade and size marking (see 3.7.1).</u>				
	a. All parts shall be marked, or ticketed to insure a uniform shade, size and proper assembly throughout the garment, except those parts cut from ends which shall closely match the trousers.				
	b. The use of ink pad numbering machine, rubber stamp or pencil is acceptable provided the numbers do not show through the outside of the trousers and numbers shall be covered by the seam allowance.				
4.	<u>Overedge stitching.</u>				
	Finished appearance - When a knife is used on overedging machine, set guide so that the edge of fabric is not cut off but only the raw edge is trimmed when overedged.				
	a. Overedge stitch the top, bottom, inseam and outseam of fronts of trousers. The overedge stitching on the inseam of left front shall extend to fly notch. The overedge stitching on outseams of front shall extend from bottom notch of side pocket to bottom of trouser leg.	502 or 503 or 504	EFd-1	8-10	70 70
	b. Overedge stitch top, bottom, inseams, outseams, crotch and seat seam of the backs of the trousers.	502 or 503 or 504	EFd-1	8-10	70 70
	c. Overedge stitch the raw edge at left fly and left end of waistband.	502 or 503 or 504	EFd-1	8-10	70 70

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TABLE I - CONSTRUCTION OF TROUSERS

No	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread Ndl Bob/ Lpr
	d. The back edge of the right fly may be overedged to the slide fastener tape (see operation 7b.). This operation is to be performed without the use of a trimming knife.				
5.	<u>Make stripping for belt loops.</u>				
	a. Fold stripping with the edges abutted at center and stitch with each row of stitching not less than 1/16 inch from edge and the covering stitch on the underside. The finished stripping shall measure 5/16 to 3/8 inches in width.	406	EFh-1	10-12	50 50
	OR				
	Fold stripping with the edges abutted at center and the covering stitch on the underside.	105	EFae-1	10-12	50
	OR				
	c. Seam stripping pieces, turn, smooth out and flatten. The seam shall not be exposed on the side edge of the formed loops.	301	EFu-1	10-12	50 50
5.	<u>Make and attach side pockets.</u>				
	The edges of the pocket openings shall finish smooth and flat without distortion. Care shall be taken to avoid notching the pocket on underside beyond the width of the side seam allowance. Pocket openings shall finish not less than 5-3/4 nor more than 6-1/4 inches between bartacks.				
	a. Place facing and bearer on pocket and stitch along the inner edge with the raw edge turned in, and across the lower end. Selvage need not be turned in. (Fig. 2, Ill A).	301 or 401	LSd-1 and LSbj-1	10-12	50 50 50 70
	b. Stitch side pockets to fronts as indicated by marks on pattern between notches for pocket opening. Turn pocket seam to finished position and stitch 3/16 to 1/4 inch from edge of pocket openings (Fig. 2, Ill B & C).	301	SSe-2(a) and SSe-2(b)	10-12	50 50

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread	
					Ndl	Bob/ Lpr
	c. Fold pocket right side out. Stitch from step to folded edge of pocket. Notch pocket and facing at top of step and turn. (Fig. 2, Ill. D & E).	301 or 401	SSe-2(a)	10-12 10-12	50 50	50 70
	d. Tack the ends of opening through bearer with a 1/4 to 3/8 inch tack. The right and left pocket openings shall not be out of alignment by more than 1/2 inch. (Fig. 2, Ill. F).	301		10-12	50	50
7.	<u>Make flies.</u>					
	a. Double stitch back edge of fastener tape 3/16 to 1/4 inch gauge, to the left fly facing through left fly interlining. The edge of the chain shall be 3/8 to 5/8 inch from front edge of the finished fly at the top, tapering to 1/4 to 3/8 inch at bottom, with the bottom ends of scoops not more than 1/4 to 3/8 inch above the fly notch, when fasteners are cut and scoops removed. (Fig. 3, Ill. A).	301 or 401	SSau-2	10-12	50 50	50 70
	b. Seam fastener tape to back edge of right fly, with the bottom end of scoops not more than 1/4 to 3/8 inch above the fly notch, after fasteners are cut and scoops removed. (Fig. 3, Ill. B). As an alternate, it may be overedged (see operation 4d.). This operation is to be performed without the use of a trimming knife.	301	SSa-1	10-12	50	50
	c. The right fly shall be one thickness of the basic cloth and lined with twill cloth.					
	d. Seam right fly lining to the front edge of the right fly to within 1 (+1/4) inch from top of fly; turn and stitch 1/16 to 1/8 inch from edge. (Fig. 3, Ill. C and D).	301 or 401 and 301	SSe-2(a) and SSe-2(b)	10-12 10-12	50 50 50	50 70 50
	e. Overedge the back edge of the left fly facing and left fly interlining together. (Fig. 3, Ill. E).	502 or 503 or 504	EFd-1	8-10	70	70

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TABLE I - CONSTRUCTION OF TROUSERS

No	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread	
					Ndl	Bob/ Lpr
<u>8. Sew on right and left flies.</u>						
Finished appearance - The flies shall be even in length where they join the crotch seam. In the finished trousers the upper end of the lining shall extend to the top of the waistband over the waistband lining and the lower end shall extend not less than 1/2 inch beyond the inseam.						
a.	Sew on right fly (slide fastener attached) with notches matching, catching fastener tape in the seam. (Fig. 3, Ill. F).	301 or 401	SSa-1	10-12	50 50	50 70
b.	Sew on left fly (slide fastener attached) with notches matching. (Fig. 3, Ill. G).	301 or 401	SSa-1	10-12	50 50	50 70
c.	Turn left fly on the seam to the inside with seam 1/16 to 1/8 inch back of folded edge and press front edge. (Fig. 3, Ill. H).					
<u>9. Make hip pockets.</u>						
Finished appearance - The pockets shall be in alignment and shall finish 5-3/4 (+1/4) inches deep. The top of the pocketing shall extend not less than 1/2 inch into the waistband and shall be caught in the bottom stitching of the waistband. The width of the finished pocket openings shall measure 5 1/4 (+1/8 inches).						
a.	Stamp or stitch on four sides of label centered on pocket. Label shall face wearer when pocket is finished.	301	LSbj-1	10-12	50	50
	Turn in lower raw edge of pocket bearer piece and seam to pocket according to marks on pattern. When bearer piece is cut on selvage, the edge need not be turned in. (Fig. 4, Ill. A).	301 or 401	LSd-1	10-12	50 50	50 70
c.	Position welt facing piece on outside as indicated by pattern and seam to trouser through pocket on under side with two rows of stitching. (Fig. 4, Ill. B).	301	SSv-2	10-12	50	50

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread Ndl/Bob/ Lpr
	d. Cut opening between the parallel rows of stitching and notch diagonally to the ends of each row of stitching through facing, trousers and pocket. Turn lower part of facing and pocket through cut opening and topstitch, forming a 1/8 to 3/16 inch welt edge. (Fig. 4, Ill. C, D and E).	301	SSbe-2(b)	10-12	50 50
	e. Turn in raw edge of welt facing piece and seam to pocket. When welt facing piece is cut with selvage, the edge need not be turned in. (Fig. 4, Ill. E).	301 or 401	LSd-1	10-12	50 50 50 70
	f. Fold pocket, seam the sides and turn to finished position. (Fig. 4, Ill. F).	301 or 401	SSae-2(a)	10-12	50 50 50 70
	g. Smooth out pocket and stitch sides 3/16 to 1/4 inch from edge. Stitching may extend across the bottom folded edge. The ends of the bearer and welt facing piece shall be caught in the edge stitching only. (Fig. 4, Ill. G).	301	SSae-2(b) and OSf-1	10-12	50 50
	h. Form a 1/8 to 3/16 inch welt of the facing on the upper edge of pocket opening, and topstitch the seam through trouser, welt facing pieces, pocket bearer and pocket, closing top of pocket. (Fig. 4, Ill. H).	301	LScc-2(b)	10-12	50 50
	i. Tack ends of pocket opening 1/4 to 3/8 inch through welt, bearer, and pocket.	301		10-12	50 50
	OR				
	j. Operations c and d above may be accomplished with a double welt pocket machine which stitches, cuts, and turns welt edges in one operation. When this machine is used, the welt piece may be trimmed to permit insertion into the machine. The interlining shall be of a suitable material as recommended by the machines manufacturer.	101		10-12	50

AND

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread	
					Ndl	Bob/ Lpr
	h. Topstitch the joining seam of lower welting piece through back of trousers and welting piece only. Topstitch the joining seam of the top welting piece through all plies closing the top of pocket. The ends of the pocket openings shall be securely tacked.	301		10-12	50	50
0.	<u>Join outseams.</u>					
	a. Stitch the outseams with notches matching.	301 or 401	SSa-1	10-12	50 50	50 70
	b. Press outseams open and flat from bottom to top of trousers.					
	OR					
	The outseams may be stitched by turning back the edge of one part and single stitching to the other part 1/16 to 1/8 inch from edge.	301 or 401	SSr-1	10-12	50 50	50 70
11.	<u>Finish side pockets.</u>					
	a. Turn in back edge of pocket and stitch to seam allowance of back parts and continue stitching along side to folded edge at bottom of pocket 3/16 to 1/4 inch from edge.	301	SSc-1 & SSe-2(b)	10-12	50	50
	b. Upper portion of pockets shall extend into the waistband, finish smooth, flat and be sewn to the seam allowance of waistband and trousers.					
12.	<u>Seam waistband and set belt loops.</u>					
	Finished appearance - The waistband shall have the belt loops positioned with the ends (except the back center loop) inserted not less than 1/2 inch at bottom of waistband, and caught in the stitching. The waistband shall be uniform in width and finish 1-3/4 (+1/8) inches wide.					
	a. The waistband shall be made of one ply of basic material.					

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread Ndl Bob/ Lpr
	b. There shall be seven loops for sizes up to and including size 37 and eight loops for size 38 and above. The loops shall be positioned as follows:				
	(1) One loop in center of right and left fronts according to notches on patterns.				
	(2) One adjacent to each side seam on backs of trousers.				
	(3) One centered on each back part of trousers.				
	(4) One on seat seam.				
	(5) The extra loop for size 38 and up shall be positioned on the right front 1-1/4 to 1-3/4 inches from edge of left fly when closed.				
	c. Seam bottom edge of waistband to top edge of trousers, catching ends of belt loops in their proper position, except center back loop. Left end of waistband shall be overedge stitched and even with the back edge of left fly.	301 or 401 and 502 or 503 or 504	SSa-1	10-12 8-10	50 50 70 70
	d. Press waistband seams open and flat.				
	e. Drop belt loops and securely stitch or bartack the loops 1/4 (+1/8) inch below waistband seam.	301 Bartack or automatic loop tacker		10-12 21-28 per bartack 24-28	50 50 50 50
	NOTE: The waistband lining may be attached to the waistband (operation 13) prior to setting to trousers.				
13.	<u>Make and join waistband lining.</u>				
*	The waistband lining shall be made of twill cloth interlined with buckram and waistband stabilizer. The waistband lining shall measure 1-7/8 to 2 inches wide in the finished trousers.				
	a. Overlap lining on interlining (buckram) 3/4 inch and stitch 1/8 to 3/16 inch from raw edge of lining. Position waistband stabilizer to opposite remaining edge of interlining and stitch 1/2 inch from edge. Fold lining over edge of interlining and press.	101 or 301 or 401	LSa-1	6-10	50 50 50 70

OR

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread Ndl Bob/ Lpr	
	b. The waistband stabilizer may be inserted during stitching of the waistband lining to the waistband (operation 13 f).					
	OR					
	c. As an alternate, a commercial buckram interlined waistband lining conforming to the specified requirements may be used (see operation 1. d).					
	d. Stitch twill cloth waistband lining, face to face, to top edge of waistband, with raw edges even.	301 or 401	LSq-2(a)	10-12	50 50	50 70
	e. Turn seam allowance upwards and stitch through lining, interlining, stabilizer (when used) and seam allowance, 1/16 inch from folded edge.	301	LSq-2(b)	10-12	50	50
	OR					
	f. Stitch waistband lining to waistband by inserting the top edge of waistband between the waistband lining and the buckram with the top edge of the lining turned in and seam with a row of imitation hand felled stitchings.	404	LSb-1 except buckram shall be on the underside	10-12	50	70
	OR					
	g. Stitch twill cloth waistband lining to top edge of waistband. The waistband lining shall finish 1/8 inch below finished top edge of waistband.	301	SSa-1	10-12	50	50

14 Attach hook and eye.

a. Position the hook in the center of the left waistband with the rolled edge of the hook aligned with the slide fastener scoops. Attach through a suitable reinforcement.

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread	
					Ndl	Bob/ Lpr
	b. Position the eye on the center of the right waistband, aligned with the slide fastener scoops, to correspond with the hook on the left waistband. Attach through a suitable reinforcement.					
	NOTE: A machine that automatically attaches the hooks and eyes, and feeds reinforcement pieces may be used.					
15.	<u>Finish right and left flies.</u>					
	Finished appearance - the top corner of the right fly shall be neatly and completely forced out. The joining seam of left fly to forepart shall not be exposed on outside of trousers.					
	a. Continue seaming the front edge of the right fly and fly lining to top edge of waistband across to back edge of fly lining. Trim, turn and work out corner and single stitch 1/16 to 1/8 inch from edge. The edge stitching shall conform to stitching on edge of fly. (Fig. 5, Ill. A).	301 or 401and 301	SSe-2(a) SSe-2(b)	10-12	50 50 50	50 70 50
	b. Turn in back edge of right fly lining and top stitch seam of fly through front, fastener tape and fly lining and continue stitching to top of waistband. The finished edge stitching shall be 1/8 to 3/16 inch from the back edge of the slide fastener scoops. (Fig. 5, Ill. A).	301	LSq-2(b)	10-12	50	50
	c. Turn back end of left waistband in line with the vertical fly joining seam and stitch across top edge of waistband the width of the fly. Trim, turn and work out point. (Fig. 5, Ill. B).	301	SSa-1	10-12	50	50
	d. Insert end of waistband lining under the left fly and seam back edge of left fly through front and interlining from top of waistband and curved to fly notch. The "J" stitching shall be 1-1/2 (+1/8) inches from front edge of fly (see operation 4.c). (Fig. 5, Ill. B).	301	LSbj-1	10-12	50	50
	OR					
	e. As an alternate a Union Special Left Trouser Fly topstitcher may be used.					

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread	
					Ndl	Bob/ Lpr
16.	<u>Join inseams.</u>					
	Finished appearance - The crotch and seat seams shall not be staggered by more than 3/8 inch.					
	a. Stitch inseams 3/8 to 1/2 inch from raw edge with notches matching as indicated on patterns.	301 or 401	SSa-1	10-12	50 50	50 70
	b. Press inseams open and flat.					
	OR					
	c. The inseams may be stitched by turning back the edge of one part and single stitching to the other part 1/16 to 1/8 inch from turned edge.	301 or 401	SSr-1	10-12	50 50	50 70
17	<u>Join seat seam.</u>					
	Finished appearance - The seat seam shall be stitched with stitch tension of sufficient elasticity to meet strain encountered in sitting or stooping. The waist shall be measured before the seat seam is stitched to assure correct waist size. In the stitching of the seat seam the inseams shall meet. The base of the left fly shall cover the right fly on outside of the finished trousers.					
	a. 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	50	70
	b. Press crotch and seat seam open and flat.					
18.	<u>Finished waistband and attach size label.</u>					
	Finished appearance - The waistband shall be uniform in width and the lining shall not be exposed beyond the top of waistband.					

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread Ndl - Bob/ Lpr	
	a. Fold waistband lining to finished position with ends at seat seam folded in. Topstitch 1/16 inch below the joining seam on the trouser, simultaneously catching the waistband lining (with the ends at center back folded in) and the top of pockets in the stitching.	301	LSq-2 Shows finished seam	10-12	50	50
	b. Pockets may be stitched or basted to the waistband seam allowance and the bottom edge of the waistband lining may be flat hemmed prior to the topstitching. The topstitching shall extend to, but not beyond, the back edge of right and left flies.					
	c. Stitch the top edge of the size label to the lower edge of waistband lining above the right hip pocket. The end of the stitching need not be tacked, providing the stitching extends a least 1/2 inch beyond each end of the label. The stitching shall not be through the printing.	301	LSbj-1	10-12	50	50
19.	<u>Assemble slide fasteners.</u> Finished appearance - The fasteners shall be so assembled that the ends of the chain are even. a. Attach slider and staple bottom of fastener together.					
20.	<u>Stitch right fly extension piece.</u> a. Turn under the raw edges of the right fly lining extension piece. Stitch by machine or hand the extension to each side of the open crotch and seat seam. Extension piece shall extend not less than 1/2 inch beyond the inseam.	301 or Hand	SSac-3(d)	10-12 6-8	50 50	50
21.	<u>Finish belt loops.</u> Finished appearance - All belt loops shall measure 1-3/4 (+1/8) inches from bartack at top of loop to the bottom folded edge. Bartacks shall extend the width of the loop, not beyond.					

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TABLE I - CONSTRUCTION OF TROUSERS

No	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread	
					Ndl	Bob/ Lpr
	a. Fold top of loop under (except center back loop) with the folded edge positioned 1/8 (+1/16) inch from the top edge of waistband and bartack through the waistband.	Bartack or Automatic Loop Tacker		21-28 per bartack 24-28	50 50	50 50
	b. Bartack the center back loop over the seat seam with the unfinished side up and the bottom raw edge adjacent to the waistband seam.	Bartack or Automatic Loop Tacker		21-18 per bartack 24-28	50 50	50 50
	c. Turn up the center back loop, fold top of loop under so the folded edge is positioned 1/8 (+1/16) inch from the top edge of the waistband and bartack through the waistband.	Bartack or Automatic Loop Tacker		21-28 per bartack 24-28	50 50	50 50
	<u>Make buttonhole.</u>					
	Make a vertical buttonhole in the center of the left hip pocket with the inside edge of eyelet 3/16 to 5/16 inch below the joining seam of welt edge.	Button hole		52-54 per buttonhole including tack	50	50
2-	<u>Sew on button.</u>					
	Finished appearance - Button position shall be marked or gauged and properly aligned with buttonhole.					
	a. Attach button on the bearer of the left hip pocket through all plies to correspond with buttonhole in pocket.	101 or 301		14-16 per button 14-16 per button	50 50	50 50
	<u>Bartacking.</u>					
	Finished appearance - All bartacks on pockets and at base of fly shall be made by machine and shall be 3/8 to 1/2 inch long.					
	a. Bartack both ends of all pocket openings. Bartacks for the side pockets shall be horizontal and shall extend 1/16 to 1/8 inch beyond the outseams. Bartacks for the back pockets shall be vertical.	Bartack		21-28 per bartack	50	50

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TABLE I - CONSTRUCTION OF TROUSERS

No.	Operation	Stch Type	Seam/ Stch type	Stch/ in	Thread No. of Lpr
b.	Bartack base of fly at the junction of the crotch seam and fly. The bartack shall be diagonal, in line with the left stitching or may be horizontal and shall extend 1/16 to 1/8 inch beyond the crotch seam.	Bartack		21-28 per bartack	50 50
c.	Bartack on inside of the trousers through the left and right fly assembly adjacent to the "J" portion of the fly. Position the bartack to relieve the tension placed upon the bottom stop (approximately 3/4 inch from the base of the fly bartack at 30 to 45 degrees from the horizontal).	Bartack		21-28 per bartack	50 50
25.	<u>Cleaning and attach size label.</u>				
a.	Trim ends of all stitching to within 1/4 inch and remove loose thread from the trousers inside and outside.				
b.	Trim ends of center back belt loop to a length of 1/16 to 1/4 inch.				
	Note: Caution shall be made so not to harm the material when trimming.				
c.	Remove all shade tickets.				
d.	Close fly, waistband and hip pocket.				
e.	Tack removable size ticket on all four corners to the outside of waistband above the back left hip pocket.	Hand or machine		2-4 per tack 6-8 per tack	

26. Pressing.

Press the top of trousers, including fly, smooth and crease the legs in the center with the seams matching at the bottom and in the crotch; the inseam in the crotch may be slightly back of the outside seam.

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

Table II - Sizes and measurements

Size	Waist Seat		Inseam - unhemmed (C)				Knee (D)	Leg Bottom (E)
	(A)	(B)	Short	Regular	Long	X-Long		
26	26	34	31	33	35-1/2	38-1/2	19-3/4	21-1/4
27	27	35	31	33	35-1/2	38-1/2	20-1/4	21-3/4
28	28	36	31	33	35-1/2	38-1/2	20-1/4	21-3/4
29	29	37	31	33	35-1/2	38-1/2	20-3/4	22-1/4
30	30	38	31	33	35-1/2	38-1/2	20-3/4	22-1/4
31	31	39	31	33	35-1/2	38-1/2	20-3/4	22-1/4
32	32	40	31	33	35-1/2	38-1/2	21-1/4	22-3/4
33	33	41	31	33	35-1/2	38-1/2	21-1/4	22-3/4
34	34	42	31	33	35-1/2	38-1/2	21-3/4	23-1/4
35	35	43	31	33	35-1/2	38-1/2	21-3/4	23-1/4
36	36	44	31	33	35-1/2	38-1/2	22	23-1/2
37	37	45	31	33	35-1/2	38-1/2	22-1/4	23-3/4
38	38	46	31	33	35-1/2	38-1/2	22-1/2	24
40	40	47	31	33	35-1/2	38-1/2	23	24-1/2
42	42	48	31	33	35-1/2	38-1/2	23	24-1/2
44	44	49	31	33	35-1/2	38-1/2	23-1/2	25
46	46	51	31	33	35-1/2	38-1/2	23-1/2	25
48	48	52	31	33	35-1/2	38-1/2	24	25-1/2
50	50	54	31	33	35-1/2	38-1/2	24	25-1/2
Tolerance	+1/2	+1	+3/4	+3/4	+3/4	+3/4	+1/2	+1/2

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NOTE: Measurements for waist and seat shall be taken with slide fastener and waistband closed. Refer to Figure 1 for A, B, C, D, and E measurements. All measurements shall be taken with trousers laid out smooth and flat.

- A. Waist - Twice the measurement taken from folded edge to folded edge across the top edge of waistband.
- B. Seat - Twice the measurement taken from folded edge to folded edge one inch above fly bartack.
- C. Inseam - Length measurement taken along inseam from crotch seam to unfinished bottom of legs.
- D. Knee - Twice the measurement taken from folded edge to folded edge across the width of trouser leg. Location of knee measurements shall be taken from bottom of trousers as follows:

Short - 16-3/4 inches	Long - 20 inches
Regular - 18 inches	X-Long - 22-1/4 inches
- E. Bottom - Twice the measurement taken from folded edge to folded edge across unfinished bottom of leg.

3.9 Workmanship. The finished trousers shall conform to the quality and grade of product established by this specification. As a final step in the contractor's product control plan before formation of a lot, each dress trouser shall be examined after pressing and prior to folding for packaging, and a trouser containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in MIL-STD-1488 indicated by an asterisk (*). The occurrence of defects shall not exceed the applicable acceptable point value of 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, 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 assure supplies and services conform to the prescribed requirements.

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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 for compliance with design, construction, workmanship, appearance, and dimensional requirements.

4.4 Quality conformance inspection. Inspection shall be performed in accordance with MIL-STD-1488, except where otherwise indicated.

4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be inspected and tested in accordance with the requirements of referenced specifications, drawings, and standards unless otherwise amended, excluded, modified or qualified in this specification or applicable purchase document. In addition, the contractor shall furnish a certificate of compliance stating that the hooks and eyes conform to the requirements in 3.3.10 and all components of slide fastener shall be furnished by the same supplier (see 3.3.9).

4.4.2 End item examination. Sampling and examination of the end item shall be performed in accordance with the provisions of MIL-STD-1488 and the following defects listed. The trousers shall be classified as dress (D) trousers.

Defect	Point Value
<u>Waistband</u>	
Waistband not uniformly topstitched below the joining seam on trousers	2
<u>Label</u>	
Removable size ticket missing, incorrect or illegible	1

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4.4.3 Packaging inspection. Packaging inspection will be in accordance with MIL-STD-1488.

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

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

5. PACKAGING

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

5.1.1 Level A. Each pair of fastened trousers shall be folded as follows:

- (a) Fold trousers in half lengthwise with the fly inside the fold and the inseams and outseams matching.
- (b) Fold trousers in quarters across the length. The folded trousers shall measure approximately 11-1/2 by 15-1/4 inches.

NOTE 1: For the longer trouser lengths it may be necessary to fold up the bottom of the trousers 2 to 4 inches before folding the trousers into quarters.

NOTE 2: For larger sizes the waistband may have to be tucked in to conform with the folded measurements.

- (c) Each folded pair of trousers shall be individually packaged in a snug-fitting, clear, polyethylene bag. The polyethylene film shall be 0.00125 (+20 percent tolerance) inch thick. All seams and closures shall be formed by heat sealing. A 1/4 inch maximum diameter hole shall be made at one corner of each bag to allow excess air to escape.

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5.1.2 Level C. Trousers shall be packaged to afford adequate protection against physical damage during shipment from the supply source 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. Packaing shall be level A, B or C as specified (see 6.2).

5.2.1 Level A. Sixteen (16) pairs of trousers, of one size and length only, packaged as specified in 5.1.1, shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to type CF, class weather resistant, grade VI5c, variety DW, size 2A of MIL-B-17757. The fiberboard for the box liner shall conform to type CF, class domestic of MIL-B-17757. Level A folded trousers shall be packed flat, waistband alternated end to end, two (2) in length, one (1) in width and eight (8) in depth, with the length of the trousers parallel to the end panels of the shipping container. The contents shall be completely covered on the top and bottom with a sheet of comercial grade kraft paper.

5.2.2 Level B. Sixteen (16) pairs of trousers, of one size and length only, packaged as specified in 5.1.1, shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to type CF, class domestic, grade 200, variety DW, size 2A OR MIL-B-17757. The fiberboard for the box liner shall conform to type CF, class domestic of MIL-B-17757. Level A folded trousers shall be stacked flat in the container, two (2) in length, one (1) in width and eight (8) in depth with the waistband alternated end to end and the length of the trousers parallel to the end panels of the box. The contents shall be completely covered on the top and bottom with a sheet of comercial grade kraft paper.

5.2.3 Level C. Trousers, 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 U.S. Postal Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules as applicable.

5.3 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.

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

5.4.1 Polyethylene bagged packages. Polyethylene bagged packages shall have the required information legibly printed or stamped in black directly on the bag across the center face or on a white paper label inserted within the bag so as to permit ready identification. The bag or label shall indicate the following information:

STOCK NUMBER
NOMENCLATURE
SIZE
QUANTITY

6. NOTES

6.1 Intended use. The trousers are intended for use as part of the summer white uniform worn by enlisted male personnel of the Navy.

6.2 Ordering data. Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) Sizes and lengths required (see 1.2).
- (c) When first article is required (see 3.2 and 4.3), the item will be tested and should be a first article sample. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examinations, quantity and testing and approval of the first article.
- (d) Selection for applicable levels of packaging and packing (see 5.1 and 5.2).
- (e) When palletization is required (see 5.3).

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

6.4 Equal item. Prior to the use of an "interchangeable" item, the contractor shall submit the item with supporting data to the contracting officer for subsequent approval or disapproval by the responsible Military Agency.

6.5 Changes from previous issue. The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notation. 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.

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6.6 Subject terms (key words) listing.

Fabric, crease resistant

Pants

Polyester/cotton

Uniform, trousers

White twill

Custodian:

Navy - NU

Review Activity:

DLA - CT

Preparing Activity:

Navy - NU

Project No. 8405-N074

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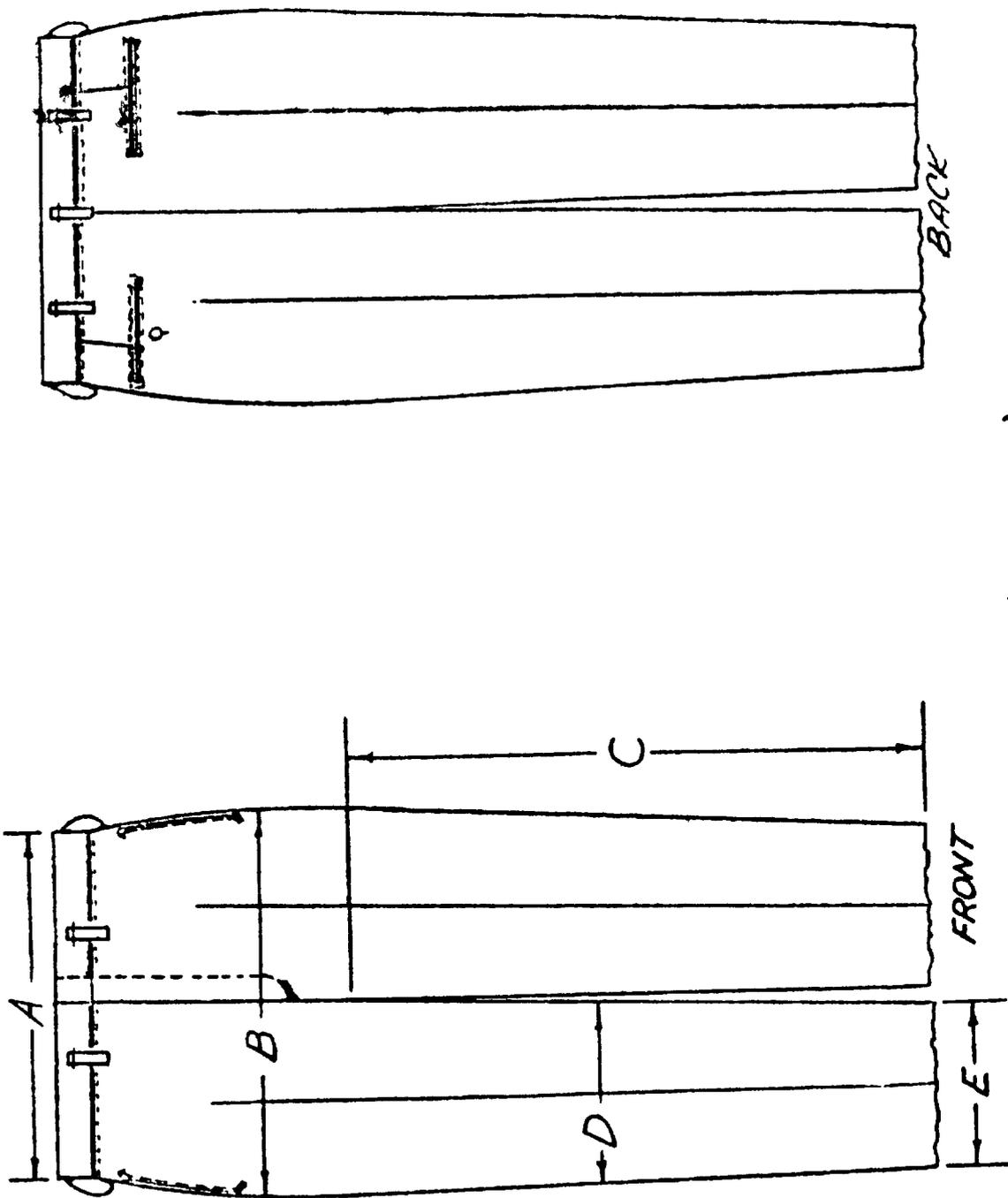
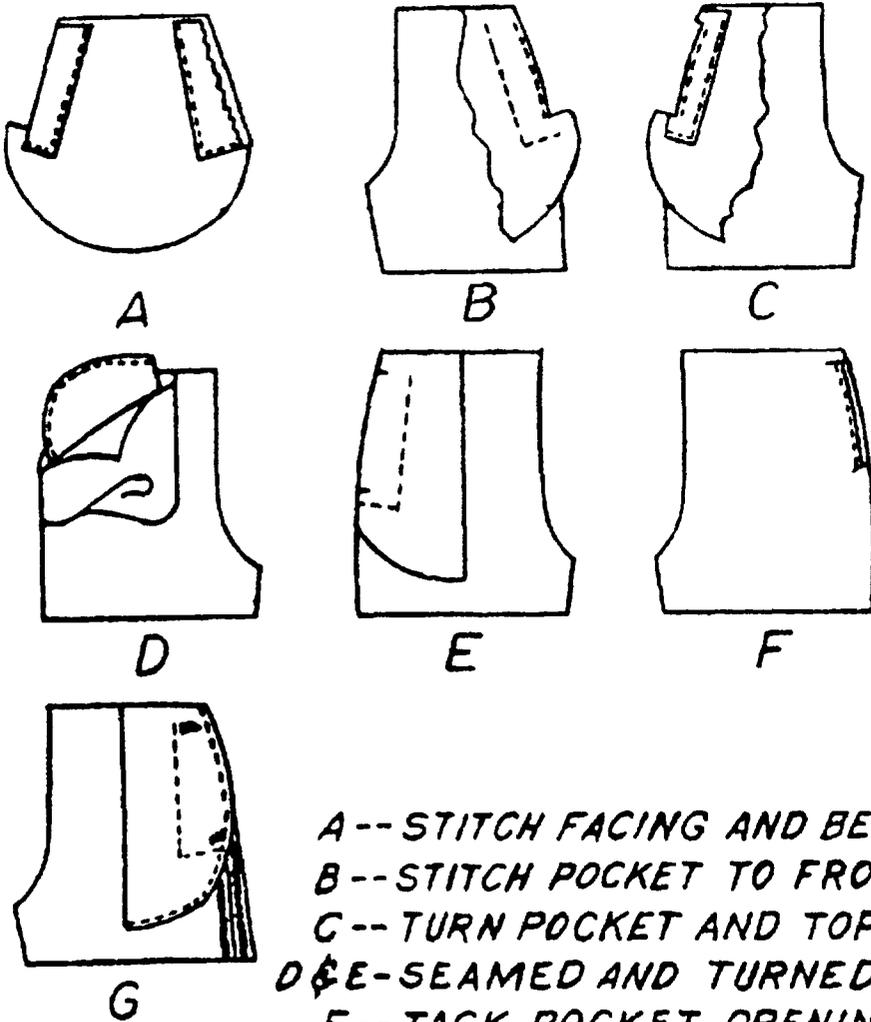


FIGURE 1 TROUSERS, MEN'S (WHITE)

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A--STITCH FACING AND BEARER TO POCKET
B--STITCH POCKET TO FRONT
C--TURN POCKET AND TOP STITCH
D&E--SEAMED AND TURNED
F--TACK POCKET OPENING TO BEARER
G--FINISHED POCKET

FIGURE 2 - SIDE POCKET

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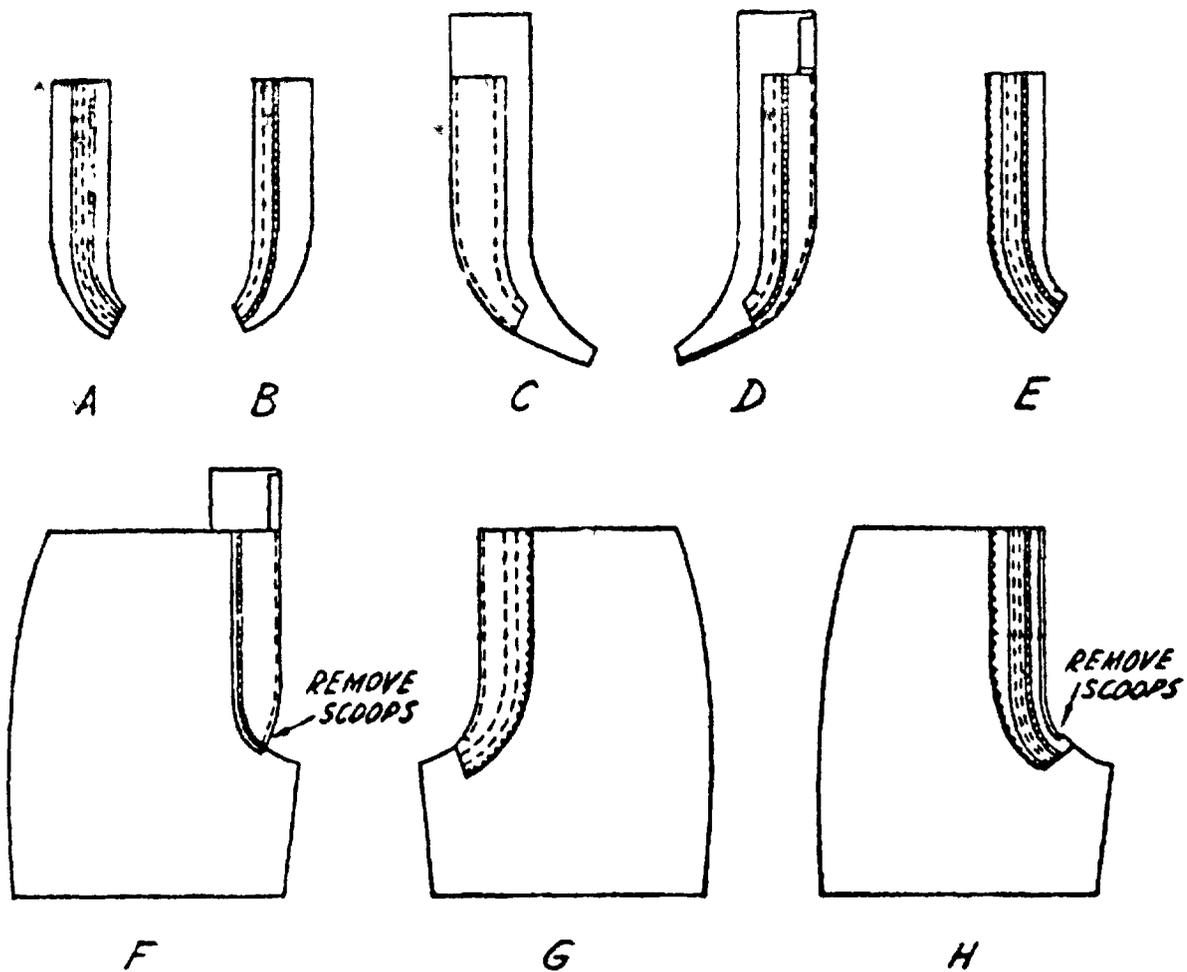


FIG. 3 FLY (RIGHT AND LEFT)

- A - DOUBLE STITCH FASTENER TAPE TO LEFT FLY THROUGH LINING
 B - SEAM FASTENER TAPE TO RIGHT FLY
 C & D - SEAM LINING TO RIGHT FLY, TURN AND TOP STITCH
 E - OVEREDGE LEFT FLY
 F - JOIN RIGHT FLY TO TROUSERS
 G & H - JOIN LEFT FLY TO TROUSERS AND PRESS

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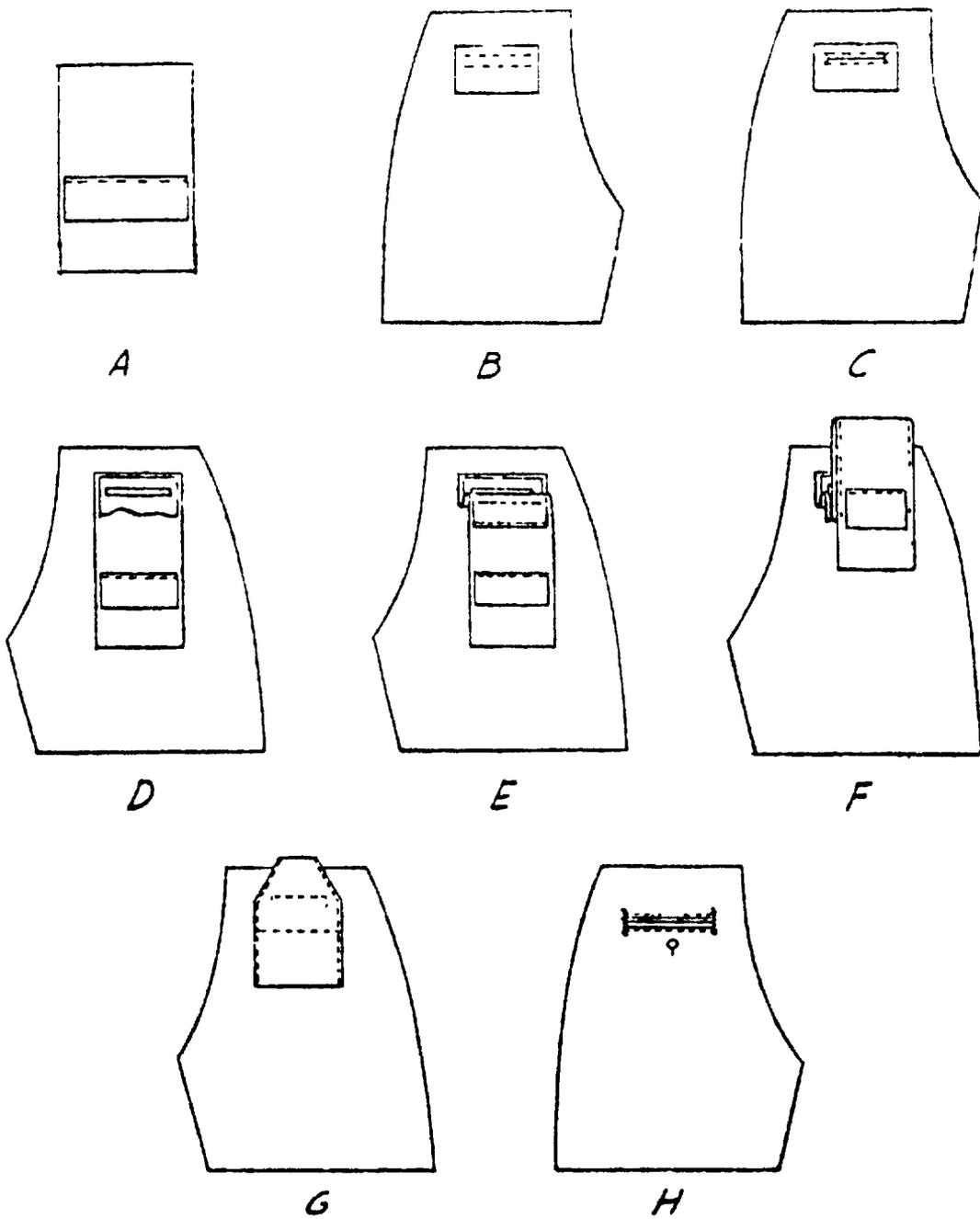
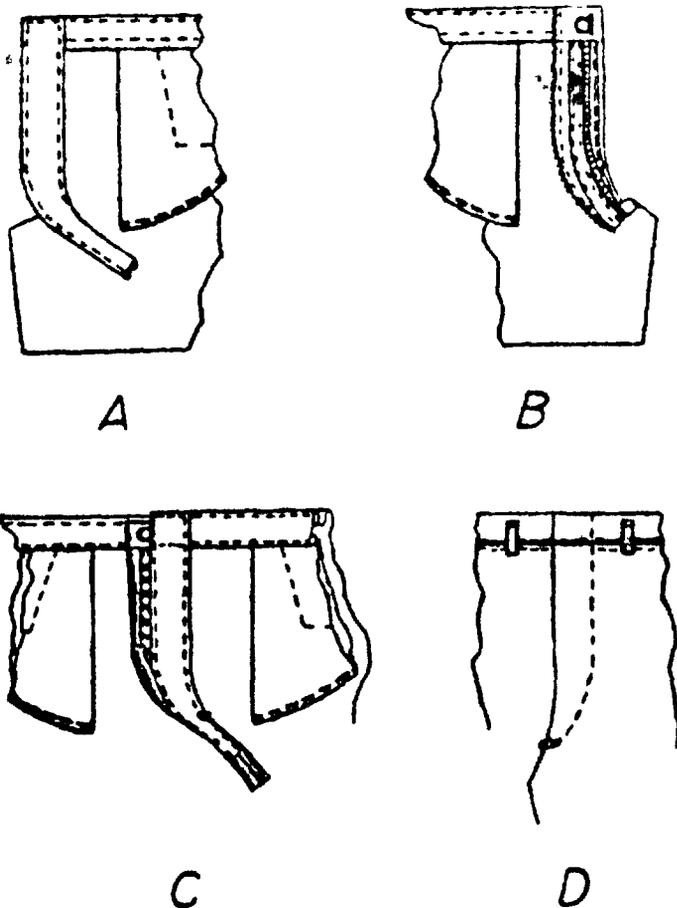


FIG. 4 HIP POCKET

- A - BEARER ON POCKET
- B - WALT FACING PIECE ON OUTSIDE OF TROUSERS
- C - CUT THROUGH OPENING AND NOTCH
- D - WALT PIECE TURNED INSIDE
- E - MAKE WALT
- F - POCKET PULLED THROUGH AND CLOSED
- G - POCKET PULLED THROUGH TO INSIDE & TOP STITCHED ON SIDES
- H - TOP POCKET OPENING STITCHED THROUGH POCKET AND FACING PIECE

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A- TOP STITCH RIGHT FLY CATCHING LINING

B- TOP STITCH BACK EDGE OF LEFT FLY
THROUGH TROUSERS

C-FINISHED FLY INSIDE

D-FINISHED FLY OUTSIDE

FIGURE 5 FINISH FLY (RIGHT AND LEFT)

INSTRUCTIONS: In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, filled along the lines indicated, taped along the loose edge (DO NOT STAPLE) and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

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

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1 DOCUMENT NUMBER MIL-T-2423L(NU)		2 DOCUMENT TITLE TROUSERS, MEN'S (WHITE)	
3a. NAME OF SUBMITTING ORGANIZATION		4 TYPE OF ORGANIZATION <i>(Mark one)</i>	
3b. ADDRESS <i>(Street, City, State, ZIP Code)</i>		<input type="checkbox"/> VENDOR <input type="checkbox"/> USER <input type="checkbox"/> MANUFACTURER <input type="checkbox"/> OTHER <i>(Specify)</i> _____	
5 PROBLEM AREAS			
a. Paragraph Number and Wording			
b. Recommended Wording			
c. Reason/Rationale for Recommendation			
6 REMARKS			
7a. NAME OF SUBMITTER <i>(Last, First, MI) - Optional</i>		b WORK TELEPHONE NUMBER <i>(Include Area Code) - Optional</i>	
c MAILING ADDRESS <i>(Street, City, State, ZIP Code) - Optional</i>		8. DATE OF SUBMISSION (YYMMDD)	