

MIL-T-41828H
22 October 1987
SUPERSEDING
MIL-T-41828G
20 May 1982

MILITARY SPECIFICATION

TROUSERS, MEN'S, POLYESTER/WOOL

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the requirements for polyester and polyester/wool trousers in different colors as specified.

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

* 1.2.1 Classes.

Class 5 - Trousers, Polyester/Wool, Tropical AF Blue 1578 (AF)
Class 10 - Trousers, Polyester Serge, AF Blue 1598 (AF)
Class 12 - Trousers, Polyester/Wool, Tropical, Navy Blue 3346 (Navy)
Class 14 - Trousers, Polyester/Wool, Tropical, AF Blue 1608 (AF)
Class 15 - Trousers, Polyester/Wool, Tropical (Washable) Navy Blue 3346 (Navy)

1.2.2 Sizes and lengths.

Sizes: 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, and 46

Lengths: X-Short, Short, Regular, Long, and X-Long

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

AMSC N/A

FSC 8405

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1.3 Uniform. When coat and trousers are procured as a uniform (see 6.2), the coat and trousers shall be cut from the same piece of material and the shades shall match.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

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

SPECIFICATIONS

FEDERAL

V-B-871	- Button, Sewing Hole, and Button, Staple, (Plastic)
V-F-106	- Fasteners, Slide, Interlocking
V-T-276	- Thread, Cotton
V-T-280	- Thread, Gimp, Cotton, Buttonhole
V-T-295	- Thread, Nylon
*NN-P-71	- Pallets, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way (Partial)
CCC-C-438	- Cloth, Buckram, Woven and Nonwoven
DDD-L-20	- Label, For Clothing, Equipage, and Tentage, (General Use)

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MIL-P-15011	- Pallets, Material Handling, Wood Post Construction, 4 Way Entry
MIL-B-17757	- Box, Shipping, Fiberboard (Modular Sizes)
MIL-C-21115	- Cloth, Tropical: Wool, Polyester/Wool
*MIL-C-24910	- Cloth, Tropical, Polyester and Wool
MIL-T-43548	- Thread, Polyester Core Cotton-, Rayon-, or Polyester-Covered
MIL-C-43718	- Cloth, Polyester, Polyester and Cotton; Polyester and Rayon, For Pockets
MIL-C-43920	- Cloth Interlining, Cotton or Synthetic, and Nylon
MIL-E-50011	- Ethanolamines (Monoethanolamine, Diethanolamine, and Triethanolamine), Technical
MIL-C-83448	- Cloth, Serge, Polyester, Texturized

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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-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.)

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

(Applications for copies should be addressed to the American Trucking Association, ATTN: Traffic Department, 1616 P Street, N.W., Washington, DC 20036-1404).

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

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

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*THE COLOR ASSOCIATION OF THE UNITED STATES
Standard Shades for Buttons - 1966
Standard Shades for Threads - 1968

(Application for copies of color cards should be addressed to The Color Association of the United States, 343 Lexington Ave., 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.

3. REQUIREMENTS

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

3.2 First article. When specified, the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.3 and 6.2).

3.3 Material.

3.3.1 Basic material.

* 3.3.1.1 Class 10. The material for class 10 trousers shall be polyester serge, AF Blue Shade No. 1598 conforming to MIL-C-83448.

* 3.3.1.2 Classes 5, 12, and 14. The material for classes 5 and 12 trousers shall be polyester/wool tropical, 10 ounce, conforming to type III, class 3 of MIL-C-21115. The material for class 14 trousers shall be polyester/wool tropical, 10.25 ounce, conforming to type III, class 4 of MIL-C-21115. The colors shall be AF Blue Shade No. 1578 for class 5 trousers, Navy Blue Shade No. 3346 for class 12 trousers, and AF Blue Shade No. 1608 for class 14 trousers. The piece number for class 12 trousers is Standard Sample 4-001369.

* 3.3.1.3 Class 15. The material for class 15 trousers shall be washable polyester/wool tropical conforming to MIL-C-24910, Blue Shade 3346, piece number 85084.

* 3.3.2 Lining and interlining. The material for left fly interlining (when applicable), right fly lining, waistband lining, crotch piece, side pocket stays, and pocketing shall be twill cloth conforming to class 1 of MIL-C-43718.

3.3.2.1 Color. The color shall be Black Shade No. 423 or blue to match the basic material for classes 5, 10, and 14 trousers, and Black Shade No. 423 for classes 12 and 15 trousers.

* 3.3.3 Waistband assembly. The waistband assembly for classes 5, 10, and 14 shall be a commercial band using the material stated in 3.3.2, 3.3.4, 3.3.5, and 3.3.6. The waistband assembly for class 12 shall use the material stated in 3.3.2, 3.3.4, and 3.3.5.

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3.3.4 Buckram. The material for interlining waistband shall be bleached or unbleached cotton buckram conforming to type II, class 1 of CCC-C-438 except the chlorine degradation requirement is not required. As an alternate, the material for interlining the waistband may be non-woven material conforming to type IV, class 1 of CCC-C-438.

3.3.5 Waistband stabilizer. The material for the waistband stabilizer shall be interlining cloth conforming to type I of MIL-C-43920.

* 3.3.6 Tape, waistband, non-slip. The woven non-slip tape for the waistband lining assembly for the class 5, 10, and 14 trousers shall be constructed of either polyester or polyester/nylon, natural or white in color, with two rows of chloroprene or nitrile rubber threads woven or stitched to the tape. The width of the completed tape shall be 7/8 inch and shall not shrink more than 2% in the length direction when subjected to the manufacturer's standard procedures for determining dimensional stability to laundering and dry-cleaning as appropriate for the end item.

* 3.3.7 Labels.

* 3.3.7.1 Combination label. The combination label for all classes except class 15 shall conform to Type VI classes 10 and 15 of DDD-L-20. The label shall show fastness to dry cleaning and the inscription shall read as follows:

NAME:

SERVICE NO:

TROUSERS, MEN'S, POLYESTER/WOOL (Example)

FIBER CONTENT. 55% Polyester/45% Wool (Example) 1/

CONTRACT NO: DLA-100-00-0-0000 (Example)

NAME OF CONTRACTOR:

INSTRUCTIONS

Treated for permanent creasing. 2/

Press on same crease line.

Undesired crease lines may be removed by steam.

DRY CLEAN ONLY

1/ The fiber content shall be the same as the basic material.

2/ Except for class 10, which is not treated.

For class 15 trousers, the combination label shall be in accordance with Type VI, class 10 and 15 of DDD-L-20. The label shall show colorfastness to laundering. The inscription and format shall be as follow:

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NAME:

SERVICE NO:

TROUSERS, MEN'S, WASHABLE, CLASS 15 (EXAMPLE)

FIBER CONTENT: 75% POLYESTER AND 25% WOOL

CONTRACT NO: DLA-100-00-0-0000 (EXAMPLE)

LAUNDERING

MACHINE WASH, PERMANENT PRESS CYCLE
 WARM WATER (120° MAXIMUM) DO NOT BLEACH
 TUMBLE DRY - MEDIUM HEAT, REMOVE PROMPTLY
 MAY ALSO BE DRY CLEANED

OR

FOLLOW NAVEDTRA MANUAL 414-01-45-81 FORMULA III

NOTE Abbreviation for applicable lengths shall be as follows

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

3.3.7.2 Size label. The size label for all classes shall conform to type VI, class 2 of DDD-L-20.

3.3.7.3 Removable size ticket. Each class 12 and 15 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 (38R - 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.

3.3.8 Thread.

3.3.8.1 Thread, polyester core. The polyester core thread used for seaming and stitching the trousers shall conform to MIL-T-43548 in the following sizes.

<u>Use</u>	<u>Ticket No.</u>	<u>Ply</u>
Seaming and stitching	50, 70	2 or 3
Bartacks, buttonholes	50	2 or 3
Button sewing	50	2 or 3
Overedging	70	2 or 3

The polyester core, polyester-covered thread is not allowed.

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* 3.3.8.1.1 Thread, cotton. As an alternate to the polyester core thread, a cotton thread conforming to V-T-276, type I, may be used. The color shall be the same as specified in 3.3.8.4 in the following types and sizes.

<u>Operation</u>	<u>Type</u>	<u>Ticket No.</u>	<u>Ply</u>
Seaming and stitching	IA3	30, 50	3
Bartacks, buttonhole	IC2	0	3
Overedging	IA3	70	2
Button sewing	IB2	50	2 or 3

3.3.8.2 Automatic button sewing. If an automatic machine which sews and shanks (wraps) the buttons in one operation is used, the thread shall be waxed nylon monocord special No. 5, having a minimum breaking strength of 16 pounds and a minimum length per pound of 2150 yards, and shall be tested for these requirements and for colorfastness (3.3.8.5) in accordance with test methods in V-T-295. The color shall be as stated in 3.3.8.4.

* 3.3.8.3 Automatic pocket machine. When automatic pocket machine using a 101 stitch type is used, 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 3.3.8.4.

* 3.3.8.4 Color. The color of the thread for classes 5, 10, and 14 trousers shall be Blue AT, C.A. 66060; and for classes 12 and 15 trousers, Black AA, C.A. 66043 in accordance with the standard shades for threads.

* 3.3.8.5 Colorfastness. The colored thread shall show fastness to light and wet dry-cleaning equal to or better than the standard sample when tested as specified in MIL-T-43548. When no standard sample is available, the colored thread shall show a minimum of "good" fastness to light and wet dry-cleaning when tested as specified in MIL-T-43548 or V-T-276.

3.3.9 Gimp. The gimp for reinforcing buttonholes shall be cotton, No. 8, conforming to type I or II of V-T-280.

3.3.9.1 Color. The color of gimp for each class shall be the same as indicated for thread in 3.3.8.4 in accordance with standard shades for threads.

* 3.3.9.2 Colorfastness. The colored gimp shall show fastness to wet dry-cleaning equal to or better than the standard sample. When no standard sample is available, the colored gimp shall show a minimum of "good" colorfastness to wet dry-cleaning when tested as specified in V-T-280.

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* 3.3.10 Buttons. The button for the left hip pocket shall be type II, class D, style 4, 22-line, glossy finish, conforming to V-B-871. The color of the buttons shall be Black, Shade BT, Cable No. 62001 for classes 12 and 15 trousers and Blue Shade BV Cable No. 62003 for classes 5, 10, and 14 trousers in accordance with standard shades for buttons.

* 3.3.11 Slide fastener. For classes 5, 10, and 14 trousers, the slide fastener shall be type I, style 1, cam lock, size LS, short tab pull, brass or zinc chain, conforming to V-F-106, except that the salt spray test shall not apply. For classes 12 and 15 trousers, the slide fastener shall be the same except the salt spray test applies, size shall be LMS, all metal components shall be of brass and from the same supplier (see 4.4.1). A staple bottom stop is required. The tape shall show fastness to wet dry-cleaning equal to or better than the standard sample. When no standard sample is available, the tape shall show "good" colorfastness to wet dry-cleaning when tested as specified in V-F-106. The tape shall match Blue Shade 1578, 1598, or 1608 for classes 5, 10, and 14 trousers; and Black Shade G, Cable No. 66507 for classes 12 and 15 trousers.

* 3.3.12 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 eye or #85 eye), Akim Co (Junior Series, type JB, Slim-Slak or Slik-Slak with MB eye), Stimpson Co, Inc., (P536 and D4086 or D4457 and D4228) or functionally interchangeable equivalent (see 4.4.1).

* 3.4 Design. The trousers are dress type with a sewn-on waistband with hook and eye closure, a French fly with slide fastener, straight side pockets and double cord nip pockets. The left nip pocket shall have a buttonhole tab and button. An outlet is provided at seat seam and from crotch to knee at inseam. The trousers shall have a sharp permanent leg crease except class 10, which shall not have treatment.

* 3.4.1 Figures. Figures are furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figures, the specification shall control.

3.5 Patterns. Standard patterns to be used to cut working patterns will be furnished by the Government. Except as allowed by footnote to table 1, the working patterns shall be identical to the Government patterns which shall not be altered in any way. The patterns provide a 1/4 inch seam allowance for bagging pockets and a 3/8 inch seam allowance for all other seams except seat seam and inseam of back part; 7/8 inch has been added to the seat seam allowances (total 1-1/4 inches at top) to allow for tapering the seat outlet and 3/4 inch has been added to the inseam of back part (total 1-1/8 inches at top) to allow for tapering the inseam outlet of back part.

3.5.1 Pattern parts. The component parts of the trousers shall be cut from materials as specified in accordance with the number of parts required as shown in table 1.

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TABLE I. List of pattern parts

Material	Pattern nomenclature	Cut parts
Basic material (as specified)	Front	2
	Back	2
	Fly (one right and one left)	2
	Right fly with integrated tab	
	(optional) 1/	1
	Side pocket wide bearer	2
	Side pocket narrow facing	2
	Hip pocket bearer	2
	Hip pocket cord	2
	Waistband (one right and one left)	2
	Right waistband for use with integrated tab (optional)	1
	Fly tab	2
Twill cloth	Right fly lining 1/	1
	Right fly lining with integrated tab	
	(optional) 1/	1
	Crotch lining	2
	Side pocket stay	2
	Left fly interlining (optional)	1
	Side pocket	2
	Hip pocket	2

NOTE: Patterns are not furnished for belt loops, buttonhole tab, waistband lining and waistband interlining (buckram). See table II, operations 1 and 2 for their requirements.

1/ The right front end of the waistband lining may extend to the front opening. When this optional construction is used, the right fly lining shall be shortened at the top. The altered right fly lining must be sufficiently long to extend under the waistband lining and be caught by the waistband top stitching (see operations 19d, 21c, and 24a).

3.6 Construction.

* 3.6.1 Stitches, seams, and stitching. Stitch, seam, and stitching types specified in table II shall conform to FED-STD-751. Whenever two or more methods for seam or stitch types are given for the same part of the operation, any one of them may be used. Where stitch type 401 is used, the looper (under thread), shall be on the inside of the trousers. Seam allowances shall be maintained with seam sewn so that no raw edges, runoffs, twists, pleats, puckers, or open seams will result. All seams shall start and finish evenly. Thread tension shall be maintained so that there will be no tight or loose tension. Buttonholes shall be clean cut and the stitching shall be securely caught in the fabric. The use of a trimming knife in the overedging of the right fly in operations 6e and 10b is prohibited.

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

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3.6.3 Thread breaks and ends of seam. The ends of all seams and stitching, when not caught in other seams and stitching, shall be backtacked not less than 1/4 inch. The ends of a continuous line of stitching (except labels) shall be overlapped not less than 1/2 inch. The ends of the label stitching shall be overlapped not less than three stitches. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches or thread breaks on 401 seaming (except for seat seam) may be repaired using 301 stitch type. A seat seam break shall be completely resewn. Bartacks shall be not more than 1/16 inch wide.

3.6.4 Buttonholes. Buttonholes shall be the eyelet-end, taper-bar, or eyelet-end, square-bar type, worked over gimp with the end securely tacked. The finished cut length shall be 5/8 inch. The square-bar type shall have 48-50 stitches per buttonhole and shall have a 21 stitch bartack as a separate operation. The taper-bar type shall have 52-54 stitches per buttonhole including a minimum of four tacks, but not including the first cross-over stitch.

3.7 Manufacturing operations requirements. The trousers shall be manufactured in accordance with all operation requirements specified in table II. The contractor is not required to follow the exact sequence of operations. Any additional basting or holding stitching used to facilitate manufacture is permissible provided that the thread is removed or does not show on the finished trousers.

3.7.1 Pressing. Pressing as required in table II shall be accomplished with a heated pressing iron or machine.

* 3.7.2 Permanent creasing. Permanent creasing is required for trousers in classes 5, 12, 14, and 15 (see 6.2). The trousers shall be sprayed, prior to pressing, with a monoethanolamine solution (see 6.4 and 6.5). The monoethanolamine solution shall conform to Type I of MIL-E-50011. The permanency of crease shall be equal to or better than the standard sample when tested as specified in 4.4.5.

3.8 Marking. The component parts shall be marked to insure a uniform shade and size throughout the trousers (or uniform). Any method of shade marking may be used except.

- (a) Corrosive metal fastening devices
- (b) Sew-on shade tickets
- (c) Adhesive type tickets, which leave traces of paper or adhesive on material after removal of the tickets

NOTE: 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 the numbers shall be covered by the seam allowance.

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3.9 Abbreviations in table of operations. The abbreviations used in table I are as follows.

Stch	-	Stitch
in	-	inch
Ndl	-	Needle
Bob	-	Bobbin
Lpr	-	Looper
Mchne	-	Machine
Brck	-	Bartack
Comrc	-	Commercial
smlr	-	similar
Btnhl	-	Buttonhole
incl	-	including
dbl	-	double
chnstch	-	chainstitch

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
1.	<u>Cut trousers.</u>						
	a. Spread the material without tension in a suitable number of plies for the applicable fabric. The cut parts from the top and bottom ply shall match and correspond to the pattern.						
	b. Cut trousers in accordance with patterns furnished which show directional lines, size, placement of pockets and notches for the proper assembly of all parts. Directional lines shall be placed in the warp direction.						
	c. The directional lines on the fronts and backs may vary from the warp direction by not more than 1 inch. Measurements shall be taken at the top and bottom edges of the pattern from the directional line to the selvage edge of the fabric (even side of lay) and the difference between the two measurements shall not exceed 1 inch.						
*	d. Cut all parts of the trousers out of the same piece of material except narrow facings for side pockets, hip pocket bearers, belt loops, fly tab pieces, fly pieces (right and left), and right fly with integrated tab (optional) which may be cut from ends. The parts cut from ends shall approximate the shade of the trousers.						
	e. When the trousers are cut as a part of the uniform, the trousers and the coat shall be cut from the same piece of material, except those parts which may be cut from ends.						
	f. Cut the stripping for belt loops and buttonhole tabs of sufficient width to comply with operation 7.						
	g. The selvage shall not appear on the outside of trousers.						

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TABLE II - CONSTRUCTION OF TROUSERS

10.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
2.	<u>Cut linings and interlinings.</u> a. Cut the right fly lining on the straight or on the bias. b. Cut left fly interlining (when applicable) and stays for side pockets in the warp or filling direction. c. Cut crotch lining pieces so that the fold will be on the bias and one of the inseam sides is in the direction of the warp. d. For all classes, cut waistband lining and waistband interlining on the bias of sufficient length and width to comply with operation 19. For classes 5, 10, and 14 trousers, cut non-slip tape of sufficient length and width to comply with operation 19. e. Cut waistband stabilizer of sufficient length to comply with operation 19. f. (When applicable) the waistband lining for class 12 may be a commercial type using the lining, interlining and waistband stabilizer material as specified in 3.3.3.				
3.	<u>Cut pockets.</u> Cut pocketing in the warp or filling direction.				
4.	<u>Marking (see 3.8).</u> Mark or ticket all component parts of trousers except parts cut from ends, to insure a correct size and uniform shade throughout the trousers (or uniform).				
5.	<u>Replacement of defective components.</u> During the spreading, cutting, and manufacturing process, components having material defects or damages that are classified in MIL-STD-1488 shall be removed from production and replaced with nondefective and properly matched components.				

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
6.	<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 the seam allowance of inseam, outseam from lower side pocket notch to bottom of trousers, crotch seam, and right front edge of foreparts. The crotch linings folded in half lengthwise shall be caught in the overedge stitching of the front inseam.	503 or 504 or 602	EFd-1	8-10	70	70
	b. The folded crotch lining may be stitched to the front inseam in a separate operation.	301	SSa-1	8-10	50	50
	c. Overedge the seam allowance of inseam, outseam and seat seam of back parts. The side pocket stay pieces, with the bottom ends turned under, may be caught in the overedging of the outseams (see operation 17).	503 or 504 or 602	EFd-1	8-10	70	70
	*d. Overedge the left end of the waistband and raw edge of the left fly.	503 or 504 or 602	EFd-1	8-10	70	70
	*e. The back edges of the right fly may be overedged to the slide fastener tape (see operation 10b). This operation is to be performed without the use of a trimming knife.	503 or 504 or 602	EFd-1	8-10	70	70
7.	<u>Make stripping (see 1f) for buttonhole tab and 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 inch wide.	406	EFh-1	12-14	50	50

or

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	b. Fold stripping with both edges turned in and the turned-in edges abutted at center and stitch with a covering stitch.	105	EFae-1	12-14	50	50
	or					
	c. Turn in one side of stripping, fold stripping with the turned-in edge overlapped on the raw edges at center and stitch with a covering stitch.	105	-	12-14	50	50
8.	<u>Make hip pocket buttonhole tab.</u>					
	a. Cut a piece of stripping (see operation 7) of sufficient length to comply with operation b. below and to measure 1-1/2 (+ 1/8) inches long when attached to the left hip pocket seam.					
	*b. Fold the piece in half and abut the side edges forming a point. Center a bartack across the abutted edges at pointed end catching the base of the triangle. Center a second bartack across the abutted edges 5/8 (+ 1/16) inch from the first tack, forming a slit buttonhole. The bartacks shall be 3/8 to 1/2 inch long and centered over the slit of buttonhole.	Bar-tack or auto- matic loop tacker	-	21-28 per tack 24-28 per tack	50	50 50
9.	<u>Make fly tab (applicable if separate tab piece is used.</u>					
	a. Stitch the two fly tab pieces together along the sides and the pointed end; trim corners and point, turn, force out points and edges and edge stitch 1/16 to 1/8 inch from edge.	301 or 401 and 301	SSe-2	12-14	50 50 50	50 70 50
	*b. Make buttonhole at pointed end of tab as indicated by pattern, with the inside edge of the eyelet 5/8 to 3/4 inch from point. The purling shall face the wearer on the finished trousers.	Button-hole		(see 3.6.4)	50	50

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
10.	<u>Make flies.</u>					
	a. Superimpose left fly on left fly interlining (when applicable). Stitch back edge of fastener tape to left fly (through interlining when applicable) with two rows of stitching. The end of the scoops shall be 1/4 to 1/2 inch above the fly notch when fasteners are cut and scoops removed. When the trousers are finished the edge of the chain shall be 1/2 to 5/8 inch from edge to top, tapering to 1/4 to 3/8 inch from edge at bottom (Ill. A, Fig. 2).	301 or 401	LSbj-2	12-14	50 50	50 70
	*b. After fastener is cut and the scoops removed, stitch the fastener tape to back edge of right fly, with bottom end of scoops 1/4 to 1/2 inch above the fly notch (Ill. B, Fig. 2). When stitch type 503 or 504 is used, a trimming knife shall not be used.	301 or 503 or 504	SSa-1	12-14 8-10 8-10	50 70 70	50 70 70
	c. (Applicable if separate tab piece is used.) With the fly tab positioned 3/8 to 3/4 inch from the top raw edge of right fly, seam the fly lining to the front edge of the right fly to within 1 (+ 1/4) inches from top of fly inclosing the fly tab between the two plies. On the finished trousers the fly, fly tab, and waistband shall lie smooth and flat when fly tab is buttoned (Ill. C and D, Fig. 2).	301 or 401	SSe-2(a)	12-14	50 50	50 70
	or					
	d. If option to use front fly with integrated fly tab is exercised, seam lining to the front edge of right fly to within 1 (+ 1/4) inches from top of fly.	301 or 401	SSe-2(a)	12-14	50 50	50 70
	e. Overedge the back edge of the left fly and interlining (when applicable) (Ill. E, Fig. 2).	503 or 504	SSa-1	8-10	70 70	70 70

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
11.	<u>Make darts in back.</u>					
	a. Fold the backs matching the cut edges of waist darts. Seam lengthwise along the entire length of the dart, starting 3/8 inch from cut edges at the top end and tapering to a point at the back hip pocket line as indicated on pattern.	301	SSa-1	12-14	50	50
	b. Spread open and press darts smooth and flat with heated pressing iron or machine.					
12.	<u>Make hip pockets and attach label(s).</u>					
	Finished appearance. The pockets shall be in alignment, uniform in width and depth and shall finish 5-3/4 to 6-1/4 inches deep. There shall be no raw edges or pleats at the end of the openings. The finished width of the pocket opening shall measure 5-1/4 (+ 1/8) inches long.					
	a. Position the combination personal-identification-instruction label 1/2 inch from the bottom and right edge of the right hip pocketing (the label shall face the wearer on the finished trousers). Stitch on all four sides (the bottom and right side of label may be caught in the pocket edge stitching). Stitching shall not be through the printing.	301	LSbj-1	12-14	50	50
	b. Turn in lower raw edge of bearer and seam to pocket at notches. When the bearer piece is cut on the selvage, the edge need not be turned in (Ill. A, Fig. 3).	301	LSd-1	12-14	50	50
	c. Position cord facing piece on outside of trousers as indicated on pattern with the pocketing placed on the underside (as indicated by solid line on pattern) and stitch to trousers through pocketing with two rows of stitching (Ill. B, Fig. 3).	301	-	12-14	50	50

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
	d. Cut opening between the rows of stitching through all plies simultaneously, turn lower part of facing through the cut opening and raise stitch forming a 1/8 to 3/16 inch cord edge (Ill. C, D, and E, Fig. 3).	301	-	12-14	50	50
	e. Turn in lower raw edge of cord facing piece and seam to pocketing. When cord facing piece is cut on the selvage, the edge need not be turned in (Ill. E, Fig. 3).	301	LSd-1	12-14	50	50
	f. Fold pocketing, seam the sides and turn to finished position (Ill. F, Fig. 3).	301 or 401	SSae-2(a)	12-14	50 50	50 70
	g. Smooth cut pocketing and single stitch 1/4 to 3/8 inch from edge. The stitching may extend across the bottom folded edge. The ends of the bearer and cord facing piece shall be caught by the edge stitching only (Ill. G, Fig. 3).	301	SSae-2(b) and OSf-1	12-14	50	50
	h. Form a 1/8 to 3/16 inch cord of the facing on the upper edge of pocket opening, insert buttonhole tab at center (+ 1/8 inch off center tolerance) on left hip pocket and raise stitch the seam through the trousers, cord facing piece, pocket bearer and pocketing, closing the top pocket (Ill. H, Fig. 3).	301		12-14	50	50
	i. Tack ends of pocket opening 1/4 to 3/8 inch through cord, bearer, and pocketing.	301		12-14	50	50
	or					
	j. Operations d and e above may be accomplished with a double piped pocket machine which stitches, cuts, and turns piped edges in one operation. When this machine is used, the welt piece may be trimmed to permit insertion into the machine and the machine manufacturer's recommended pocket-stay material may be used.	101 or 301	-	12-14	A 50	 50

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TABLE II - CONSTRUCTION OF TROUSERS

OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
				NDL	BOB/ LPR
k. Raise stitch the joining seam of lower piping piece through back of trousers and piping piece only, raise stitch the joining seam of the top piping piece through all plies closing the top of pockets. The ends of the pocket opening shall be securely tacked.	301	-	12-14	50	50
13. <u>Make side pockets.</u> Place facing and bearer on pocketing and stitch along the inner side, with the raw edge turned in, and across the lower end (Ill. A, Fig. 4). A selvage edge need not be turned in.	301	LSd-1 and LSbj-1	12-14	50	50
14. <u>Attach side pockets.</u> Finished appearance. The edges of the pocket openings shall not be distorted. The openings shall be aligned, uniform in length, and shall measure not less than 5-3/4 nor more than 6-1/2 inches between tacks. Avoid notching the pocket on underside beyond the width of the side seam allowance.					
a. Seam side pocket to front, as indicated by marks on pattern. Notch for pocket opening, turn to finished position with the seam to the back of the front edge and stitch 3/16 to 1/4 inch from edge of pocket opening. (Ill. B and C, Fig. 4).	301	SSe-2	12-14	50	50
b. Fold pocket right side out. Stitch raw edges from step to folded edge of pocketing. Notch pocket and facing at top of step and turn pocket (Ill. D and E, Fig. 4).	301 or 401	SSae-2(a)	12-14	50 50	50 70
c. Tack ends of the openings to the bearer with a 1/4 to 3/8 inch tack. The right and left pocket opening shall not be out of alignment by more than 1/2 inch (Ill. F, Fig. 4).	301	-	12-14	50	50

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
15.	<u>Sew on flies.</u> Finished appearance. The ends of the flies shall be even where they join the crotch seam. The fly shall lie flat without twists or puckers when fastener is closed.					
	a. Sew on right fly (slide fastener and fly tab, if separate piece, attached) with notches matched (Ill. F, Fig. 2).	301	SSa-1	12-14	50	50
	b. Sew on left fly (slide fastener attached) with notches matched. Turn fly to inside with the seam 1/16 to 1/8 inch back of folded edge and press front edge without damage to the fastener (Ill. G and H, Fig. 2).	301	SSa-1	12-14	50	50
16.	<u>Join outseams.</u>					
	a. Join outseams with the notches matched, catching the pocket stay piece with the bottom ends turned under (if not previously caught in overedge operation) (see operation 6c).	301 or 401	SSa-1	12-14	50 50	50 70
	b. Press outseams open from bottom to top of trousers. The pocket stay pieces may be folded over the open seam and pressed into position for operation 17.					
17.	<u>Finish side pockets.</u>					
	Turn in back edge of side pockets and the edge of stay pieces and stitch to stay pieces 1/4 to 3/8 inch from edge along the side seam allowance. Continue the stitching around pocket to folded edge and securely backstitch end of seam (Ill. G, Fig. 4).	301	SSc-1 and SSae-2(b)	12-14	50	50

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
18.	<u>Attach waistband and set belt loops.</u> *Finished appearance. The finished waistband shall measure 1-1/2 (+ 1/8) inches wide, and shall be topstitched below the waistband from end to end (see operation 24a). There shall be seven loops for sizes up to and including 37 and eight loops for sizes 38 and up. The loops shall be positioned as follows: One at each front with center of loop positioned in accordance with notches on patterns. One at each outseam on back. One centered between outseam and seat seam. One on seat seam (see operation 28a and b). The extra loop for larger sizes shall be on the right front, 1-1/4 to 1-3/4 inches from right fly joining seam. *a. Stitch bottom edge of right and left waistbands to top edge of trousers catching the top of pockets and the ends of belt loops (except center back loop) in the stitching. b. Press waistband seam open and flat. c. Drop belt loops and securely stitch or bartack the loops 3/8 to 1/2 inch below the waistband seam. The stitching or tacking shall not extend beyond the width of the loop.	301 or SSa-1 401		12-14	50 50 50 70	
		301 - or - bartack or auto- matic loop tacker -		12-14 21-28 per bartack 24-28 per tack	50 50 50 50	

NOTE: The waistband lining may be attached to the waistband (operation 19) prior to setting to trouser.

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
19.	<u>Make and join waistband linings.</u> Finished appearance. The waistband lining for classes 5, 10, and 14 shall be a commercial type using the requirements stated in 3.3.3. The waistband lining shall measure 2(+1/8) inches wide in the finished trousers. The top row of rubber thread of the non-slip tape on the waistband lining assembly shall be 3/4 (+ 1/8) inch from the top of the waistband. No stitching shall penetrate the rubber thread of the non-slip tape. The waistband lining may be pieced providing the seam is flat and there is not more than one piecing on each trouser. The waistband stabilizer may be 1 inch shorter than the waistband lining at seat seam and may be inserted during the joining of the waistband and waistband lining. The waistband lining for classes 12 and 15 shall be the requirements as stated in 3.3.3. The waistband lining shall measure 2 (+1/8) inches wide in the finished trousers. The waistband linings may be pieced providing the seam is flat and there is no more than one piecing on each trouser. The waistband stabilizer may be 1 inch shorter than the waistband lining at seat seam and may be inserted during the joining of the waistband and waistband lining. a. Make non-slip waistband lining for class 5, 10, and 14 trousers. (1) Position the center of the non-slip tape 5/8 (+ 1/16) inch below the top edge of a 2-1/4 inch wide woven or nonwoven buckram strip. Buckram may be pieced by butting ends and joining. Not more than one seam per waistband shall be permitted. (2) Cut the waistband lining material (see operation 2d) on the bias in two portions to attach above and below the rubberized threads of the non-slip tape as follows:	503, 504 or 505	FSt-1	8-10	70 70 or comrc1
		301 or 401	SSa-1	10-14	70 70 or cmrc1

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH	SEAM/	STCH	THREAD	
		TYPE	STCH TYPE	IN	NDL BOB/	LPR
	<p>- The lower portion shall be cut wide enough to fold around the bottom edge of the buckram and extend 1/4 inch beyond the lower row of rubberized threads, front and back. The lower lining portion shall measure 1 (+ 1/16) inch wide when finished and attached to the trousers.</p> <p>- The top portion shall be cut wide enough to extend 5/8 inch beyond the top row of rubberized threads and 1/4 inch beyond the top edge of the buckram with a 1/4 inch turn under near the top row of rubberized threads. The top lining portion shall measure 5/8 (+ 1/16) inch wide when finished and attached to trousers.</p> <p>The lining may be pieced with not more than one seam per portion of waistband using a 1/4 inch seam spread open and flat.</p>					
	(3) Turn under the lower edge of the top portion of waistband lining material 1/4 inch. With fold adjacent to the top row of the rubberized threads of the non-slip tape, stitch close to fold through lining, non-slip tape and buckram.	101, 301 or 401	smlr to LSd-1	8-10	70 70 or cmrcl	
	(4) Turn under the top edge of the front of the lower portion of waistband lining material 1/4 inch. Place fold adjacent to the lower row of the rubberized threads of the non-slip tape. Stitch close to fold through lining on front, non-slip tape, buckram, and portion of lining turned to back.	101 301 or 401	smlr to BSb-1	8-10	70 70 or cmrcl	

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	b. Make waistband lining for classes 12 and 15 only.					
	(1) Overlap the lining on the interlining 1 inch and stitch 1/8 to 3/16 inch from edge of lining. Position waistband stabilizer to opposite remaining edge of interlining and stitch 1/2 inch from edge. Fold lining over interlining and press.	101 or 301 or 401	LSa-1	12-14	50 50 50	 50 70
	(2) A commercial waistband conforming to specified requirements in 3.3.3 may be used (see operation 2f).					
	or					
	(3) The waistband stabilizer may be inserted during the joining of the waistband and waistband lining (operation 19c).					
	c. Turn under top edge of waistband lining and stitch to top edge of waistband catching interlining stabilizer with a row of simulated hand felling.	304 or 404		12-14	50 50	50 70
	d. (Applicable to trousers when option to extend waistband lining to right end of waistband is exercised). Turn right end of waistband lining to the outside and stitch to front edge of waistband catching the top of the fly lining in the stitching.	301 or 401	SSe-2(a)	12-14	50 50	50 70
	e. Fold waistband lining to the inside and baste or press top edge. The lining shall not be exposed beyond the top of waistband.					
20.	<u>Attach hooks and eyes.</u>					
	a. Position the hook on the center (+ 1/8 inch off center tolerance) 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 II - 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 to the hook on left waistband. Attach through a suitable reinforcement.					
NOTE: When the hook and eye are engaged on the finished trousers, the closure shall not bulge, pucker, twist, or be distorted.						
21.	<u>Finish right and left flies.</u>					
	Finished appearance. The top corners of the right (when applicable) and left flies shall be completely forced out and shall not be bulky. The stitching of the left fly shall be uniformly spaced from edge of fly. The seam joining the left fly to the forepart shall not be exposed on outside of trousers, when fastener is closed. The right fly lining shall not be exposed on outside. The flies shall be smooth without twists or puckers or excessive fullness.					
	a. Continue the stitching of the fly lining to the top of the waistband.	301 or 401	SSe-2(a)	12-14	50 50	50 70
	b. Turn right fly lining to the inside and stitch 1/16 to 1/8 inch from front edge. Turn in fly lining at top of waistband and continue the stitching across top, turn in raw edge of fly lining and raise stitch the fly joining seam catching the fly lining in the stitching (Ill. D, Fig. 2 and Ill. J, Fig. 2). The edge stitching along front edge of fly may be accomplished in a separate operation.	301	SSe-2(b) and SSc-1 and LSq-2(b)	12-14	50	50

or

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	c. (Applicable to trousers when option to extend waistband lining to right end of waistband is exercised.) Turn right fly lining to the inside and stitch 1/16 to 1/8 inch from front edge, continue the stitching along front end of waistband, across top of waistband and down to meet back of right fly, turn in raw edge of fly lining and raise stitch the fly joining-seam catching the fly lining in the stitching.	301	SSe-2(b) and LSq-2(b)	12-14	50	50
	d. Turn back end of waistband in line with the front folded edge of left fly and stitch across top of waistband the width of the fly. Trim, turn, and work out corner (Ill. K, Fig. 2).	301	SSa-1	12-14	50	50
	e. Stitch down left fly with waistband lining smoothly inserted between fly and trouser. The "J" stitching shall be 1-3/8 (+ 1/8) inches from front edge of fly, extend from top of waistband, and curve to fly notch (Ill. K, Fig. 2).	301	EFa-1	12-14	50	50
22.	<u>Join inseams.</u>					
	a. Join inseams forming outlet tapering the seam allowance of back part from 3/4 inch at crotch to 3/8 inches at knee. The seam shall start and finish evenly and the notches shall match.	301 or 401	SSbd-1 and SSa-1	12-14 12-14	50 50	50 70
	b. Press inseams open and flat.					
23.	<u>Join seat seams.</u>					
	Finished appearance. The seat seam shall be joined with stitch tension of sufficient elasticity to meet strain encountered in sitting or stooping. The waist shall be measured before the seat seam is joined to assure correct waist size. In the joining of the seat seam, the inseams shall meet and the right and left waistband joining seams shall be aligned. The base of the left fly shall cover the right fly on outside of the finished trousers. The inseams shall not be staggered more than 3/8 inch at crotch.					

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	a. Join seat seam from base of fly to end of waistband lining with a double needle seat stamer with the rows of stitching 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.	401	SSa-2	8-10 each needle	50	70
	b. Press crotch and seat seam open.					
24.	<u>Finish waistband and attach size label.</u>					
	a. Top stitch the spread-open waistband seam 1/16 inch below the joining seam catching the waistband lining (with ends at center back folded in) and the top of the pockets in the stitching. The stitching shall not extend across the fly except when option to extend waistband lining to right end of waistband is exercised. Pockets may be stitched or basted to waistband seam allowance prior to top stitching.	301	LSbd-2(b)	12-14	50	50
	*b. Stitch top edge of the size label to the lower edge of the waistband lining above the right hip pocket. The ends of stitching need not be tacked provided the stitching extends at least 1/2 inch beyond each side of label. The stitching shall not be through the printing.	301	-	12-14	50	50
25.	<u>Assemble fasteners.</u>					
	Attach the slider, and with the scoops evenly matched, staple the bottom of the slide fastener tape. The staple shall be perpendicular to the line of the scoops and shall overlap the scoops. The stop shall be within 3/8 inch of fly notch. The end of the tape shall extend at least 1/8 inch below notch.					
26.	<u>Stitch right fly extension.</u>					
	Turn in the raw edges of the right fly extension piece and machine stitch or hand fell to each side of the spread-open crotch and seat seam (Ill. L, Fig. 2).	301 or Hand	SSac-3(b) (c) (d)	12-14 6-8	50 50	50 -

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD		
					NDL	BOB/ LPR	
27.	<u>Finish belt loop attachment.</u> Turn up belt loops, fold under top of loops and position folded edge 1/8 (+ 1/16) inch from top of waistband and bartack. The finished belt loops shall measure 1-3/4 (+ 1/8) inches from bartack at top of loop to the bottom folded edge.	301 or bar tack or auto- matic loop tacket	LSd-1 LSd-1 LSd-1	12-14 21-28 per bar- tack 24-28 per tack	50 50 50	50 50 50	
28.	<u>Attach center back belt loop.</u> Finished appearance. The tacking shall extend the width of the loop but not beyond.						
	*a. Place bottom edge of belt loop, with underside facing up, even with bottom edge of waistband and positioned over center back seam. Securely bartack the loop 3/8 to 1/2 inch below waistband seam.	301 or bar- tack or auto- matic loop tacker	LSd-1	12-14 21-28 per bartack 24-28 tack	50 50 50	50 50 50	
	*b. Turn belt loop to finished position, turn under top of loop and position folded edge 1/8 (+ 1/16) from top of waistband and bartack to trousers 1/16 to 1/8 inch from folded edge. The finished back center belt loop shall measure 1-3/4 (+ 1/8) inches from bartack at top of loop to the bottom folded edge.	301 or bar- tack or auto- matic loop tacker	LSd-1	12-14 21-28 bartack 24-28 per tack	50 50 50	50 50 50	
29.	<u>Make buttonhole (applicable to fly with integrated fly tab).</u> Make buttonhole at end of tab, as indicated by pattern, with the inside edge of eyelet 5/8 to 3/4 inch from point. The purling shall face the wearer on the finished trousers.	Button- hole		(see 3.6.4)	50	50	

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
30.	<u>Mark or gage and sew buttons.</u>					
	*Finished appearance. The buttons shall be securely sewn and properly aligned with buttonholes. Hand sewn buttons shall be shank wrapped three times and the ends of the thread shall be securely tacked with not less than two stitches. Machine sewn buttons (see 3.3.8.2) which are automatically shanked shall have a minimum of ten wraps and three locking stitches. Buttons sewn with stitch type 301 or 101 are not required to be shank wrapped.					
	a. Sew a 22-line button on the left waistband lining to correspond with the fly tab buttonhole. The stitching shall not be visible on the outside of the trousers.	301 or		14-16 per button	24 or 50	24 or 50
		101 or		14-16 per button	24 or 50	
		Hand or		4 double per button	16 or 50	
				not in- cluding shank wrapping		
		205		7 (min) 1 deep set per button not in- cluding shank wrapping	5 ny- lon	

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
b.	Sew a 22-line button on left hip pocket through pocket and facing to correspond to buttonhole tab.	301 or		14-16	24 24
				per	or or
				button	50 50
		101 or		14-16	24
				per	or
				button	50
		Hand or		4	16
				double	or
				per	50
				button	
205	not in- cluding shank wrapping				
	7 (min)	5			
	1	ny-			
	deep	lon			
	set per				
	button				
31. <u>Bartacking.</u>	Finished appearance. The bartacks shall be well made and correctly placed to reinforce points of strain as specified. The bartacks at side pocket openings shall extend beyond the outseams 1/16 to 1/8 inch.			not in- cluding shank wrapping	
a.	Bartack all pockets at ends of pocket openings. The bartacks shall be perpendicular to the openings.	Bar- tack		21-28	50 50
				per bar- tack	
*b.	Bartack at base of fly at the junction of the crotch seam and fly. A 3/8 inch bartack shall be diagonal, on the fly stitching line. (Ill. M, Fig. 2).	Bar- tack		21-28	50 50
				per bartack	

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	*c. One bartack on inside of the trouser thru 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 45 degrees from the horizontal).	Bar-tack		21-28 per bartack	50	50
32.	<u>Finish trouser bottoms.</u> For all classes of trousers overedge or pink leg bottoms.	502 or 503 or 504	EFd-1	8-10	70	70
33.	<u>Cleaning.</u> a. Trim all ends of stitching and remove loose threads. b. Trim ends of center back belt loop to a length of 1/16 to 1/4 inch. c. Remove all spots, stains, and marking tickets. *NOTE: Care shall be taken when trimming thread ends that damage to the fabric does not result. d. Tack removable size ticket to the outside of the waistband above the back left hip pocket on each class 12 and 15 trouser.	Hand or Machine		2-4 per tack 6-8 per tack		
34.	<u>Pressing.</u> a. Press and crease the legs with the seams matching at the bottoms and knees.					

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TABLE II - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH	SEAM/	STCH	THREAD
		TYPE	STCH TYPE	IN	NDL BOB/ LPR

b. When permanent creasing is specified, spray the front and back of legs along the crease area with the creasing solution (see paragraph 3.7.2). Press and crease the legs with seams matching at the bottoms and knees. The legs shall be pressed individually. There shall be no variation in the sharpness of the leg crease at front and backparts of the legs. The end of the crease shall be not more than 1 inch higher nor less than 2 inches lower than the junction of the inseams at crotch. The length of the creases shall not vary by more than 1-1/2 inches.

c. Press tops of trousers, including fly and pockets.

d. Close slide fastener, fasten waistband and button hip pocket.

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*3.10 Sizes and measurements. Unless otherwise specified, finished measurements of trousers shall be as shown in Table III.

Table IIIA. Sizes and measurements

Odd Size	Waist (A)	Seat (B)	Inseam - unhemmed (C)				
			X-Short	Short	Regular	Long	X-Long
27	27	37	30	32	34	36	38
29	29	39	30	32	34	36	38
31	31	41	30	32	34	36	38
33	33	43	30	32	34	36	38
35	35	45	30	32	34	36	38
37	37	47	30	32	34	36	38
39	39	47	30	32	34	36	38
41	41	49	30	32	34	36	38
43	43	51	30	32	34	36	38
45	45	53	30	32	34	36	38

Tolerances:

$\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$

Table IIIB - Sizes and measurements

Odd Size	Knee (D)			Leg bottom (E)		
	X-Short Short	Regular	Long X-Long	X-Short Short	Regular	Long X-Long
27	18-3/4	19-1/4	19-3/4	17-1/4	17-3/4	18-1/4
29	19-1/4	19-3/4	20-1/4	17-1/2	18	18-1/2
31	19-3/4	20-1/4	20-3/4	17-3/4	18-1/4	18-3/4
33	20-1/4	20-3/4	21-1/4	18	18-1/2	19
35	20-3/4	21-1/4	21-3/4	18-1/4	18-3/4	19-1/4
37	21-1/4	21-3/4	22-1/4	18-1/2	19	19-1/2
39	21-3/4	22-1/4	22-3/4	18-3/4	19-1/4	19-3/4
41	22-1/4	22-3/4	23-1/4	19	19-1/2	20
43	22-3/4	23-1/4	23-3/4	19-1/4	19-3/4	20-1/4
45	23-1/4	23-3/4	24-1/4	19-1/2	20	20-1/2

Tolerances:

$\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$

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Table IIIC. Sizes and measurements

Even Size	Waist (A)	Seat (B)	Inseam - unhemmed (C)				
			X-Short	Short	Regular	Long	X-Long
26	26	36	30	32	34	36	38
28	28	38	30	32	34	36	38
30	30	40	30	32	34	36	38
32	32	42	30	32	34	36	38
34	34	44	30	32	34	36	38
36	36	46	30	32	34	36	38
38	38	48	30	32	34	36	38
40	40	48	30	32	34	36	38
42	42	50	30	32	34	36	38
44	44	52	30	32	34	36	38
46	46	54	30	32	34	36	38

Tolerances.

+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2
	- 1					

Table IIID - Sizes and measurements

Even Size	Knee (D)			Leg bottom (E)		
	X-Short Short	Regular	Long X-Long	X-Short Short	Regular	Long X-Long
26	18-1/2	19	19-1/2	17	17-1/2	18
28	19	19-1/2	20	17-1/4	17-3/4	18-1/4
30	19-1/2	20	20-1/2	17-1/2	18	18-1/2
32	20	20-1/2	21	17-3/4	18-1/4	18-3/4
34	20-1/2	21	21-1/2	18	18-1/2	19
36	21	21-1/2	22	18-1/4	18-3/4	19-1/4
38	21-1/2	22	22-1/2	18-1/2	19	19-1/2
40	22	22-1/2	23	18-3/4	19-1/4	19-3/4
42	22-1/2	23	23-1/2	19	19-1/2	20
44	23	23-1/2	24	19-1/4	19-3/4	20-1/4
46	23-1/2	24	24-1/2	19-1/2	20	20-1/2

Tolerance:

+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2	+ 1/2
-------	-------	-------	-------	-------	-------

- A. Waist - With slide fastener closed and the waistband hooked, twice the measurement taken along top edge of waistband from folded edge to folded edge.
- B. Seat - With slide fastener closed twice the measurement taken across trousers, one inch above fly bartack, from folded edge to folded edge.

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- C. Inseam - Measure along inseam from crotch seam to unhemmed bottom edge. (An allowance of 3 inches for hems is included in the inseam lengths).
- D. Knee - The location of knee measurements shall be from bottom of trousers within 17-7/8 to 18-3/8 inches from bottom of trousers for X-Shorts, 18-7/8 to 19-3/8 inches for Shorts, 19-7/8 to 20-3/8 inches for Regulars, 20-7/8 to 21-3/8 inches for Longs, and 21-7/8 to 22-3/8 inches for X-Longs. Twice the measurement taken from folded edge to edge.
- E. Bottom - Twice the measurement taken along (unhemmed) bottom edge of leg from folded edge to folded edge.

3.11 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 or defect limit.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the contractor may use his own or any other facilities suitable for performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

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

4.1.2 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

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

1. First article inspection (see 4.3).
2. Quality conformance inspection (see 4.4).

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4.3 First article inspection. When required, the first article submitted in accordance with 3.2 and 6.2 shall be inspected for compliance with design, construction, workmanship, appearance, and dimensional requirements.

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-1488.

4.4.1 Component and material inspection. In accordance with 4.1 above, components and materials shall be tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable procurement documents. In addition, the contractor shall furnish a certificate of compliance stating that the hooks and eyes are one of the specified types required in 3.3.12. A certificate of compliance will also be accepted for the slide fastener requirements stating that all metal components are brass and furnished by the same supplier (see 3.3.11).

* 4.4.2 Examination of the end item. Sampling and examination of the end item shall be in accordance with the provisions for dress ("D") trousers specified in MIL-STD-1488. In addition, the following defect applies to each class 12 and 15 trouser

Label

Removable size ticket missing, incorrect, or illegible

3 points

* 4.4.3 Examination of packaging requirements. An examination shall be made to determine that packaging, 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 prepared for delivery with the exception that it need not be closed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be on 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 defects per hundred units.

Examine

Marking (exterior and interior

Defect

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, inadequate stapling, bulged or distorted container.

Content

Number of items per shipping container is more or less than required. Size shown on one or more items not as specified on shipping container. 1/

1/ For this defect, one item from each shipping container in sample shall be examined.

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* 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 inspected lot. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5 in accordance with MIL-STD-105.

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

4.4.5 Permanent creasing test. Prior to the presentation of each end item lot, a test of the results of the permanent creasing process (see 3.7.2) for the permanency of crease shall be made in accordance with test method outlined in 4.5.1. The sample unit shall be one pair of trousers selected at random from the end item lot or an 11 by 40 inch piece of fabric cut from the same lot as the end item, the long dimension being in the warp direction. The fabric sample shall be taken at least 12 inches from the selvage edge of the cloth. The fabric sample unit shall be permanently creased down the center of the long dimension in the same manner as the end item. The sample size shall be 3 and each end item lot, represented by the sample, shall be unacceptable if one or more units fail to meet the requirements specified.

4.5 Test methods.

4.5.1 Permanency of creasing test.

4.5.1.1 Test specimens. The creased test specimens shall be soaked for 30 minutes in water containing a minimum amount of a suitable wetting agent to thoroughly wet out the cloth. The temperature of the water shall be $165^{\circ} + 5^{\circ}\text{F}$. The wet out test specimens shall be removed without squeezing and shall be air dried or dried at a temperature not exceeding 180°F , while laying flat on an absorbent surface such as paper hand toweling or kitchen type tissue. The wet out and dried test specimens shall be compared with a standard sample prepared in the same manner. The sharpness of crease on the test specimens shall not be less than that of the standard sample. Results shall be reported as "pass" or "fail".

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4.5.1.2 Standard sample preparation and storage. The standard sample shall be wet out and dried in the same manner as the test specimen. Store the wet out and dried standard sample by folding along the crease and hanging it by one end with the crease in the vertical axis. This will prevent wrinkling or other distortion which will be detrimental to its future use as a reference comparison. Unless otherwise specified, the standard sample shall be wet out and dried once only. The wet out and dried standard shall be used for all specimen evaluations. Only when test results are uncertain or in dispute shall a new standard sample be wet out and dried and used for comparison. The old standard shall then be discarded and the new standard retained for future specimen evaluation.

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 half across the length. The folded trousers shall measure approximately 23 by 15-1/4 inches.

NOTE: 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. As an alternate, the polyethylene bag may be of the tuck-in or reverse flap type where a heat seal closure and corner hole are not required.

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. Packing shall be level A, B, or C (see 6.2).

* 5.2.1 Level A. Thirty (30) pairs of trousers, of one size, class and length only, packaged as specified in 5.1, shall be stacked flat in the container, two (2) in length, one (1) in width and fifteen (15) in depth with the waistband alternated end to end and the length of the packages parallel to the end panels of the box. The fiberboard shipping container shall conform to class weather-resistant, type CF, grade VI5c, variety DW, size 3A of MIL-B-17757. The fiberboard for the liner shall conform to type CF, class domestic, of MIL-B-17757. Toward the end of the contract or order, or when there is less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

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*5.2.2 Level B. Thirty (30) pairs of trousers, of one size, class and length only, packaged as specified in 5.1, shall be stacked flat in the container, two (2) in length, one (1) in width, and fifteen (15) in depth with the waistband alternated end to end and the length of the packages parallel to the end panels of the box. The fiberboard shipping container shall conform to class domestic, type CF, variety DW, grade 275, size 3A of MIL-B-17757. The fiberboard for the liner shall conform to class domestic, in accordance with MIL-B-17757. Toward the end of the contract or order, or when there is less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

* 5.2.3 Level C. Item packaged, as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. The quantity per shipping container shall be the same as that normally used by the contractor for retail distribution. Containers shall comply with the US Postal Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

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

5.3.1 Polyethylene bagged packages. The polyethylene bagged packages, specified in 5.1.1, shall have the required information legibly printed or stamped in black bold letters, 1/4 inch in height, directly on the bag across the center face or on a white paper label inserted within the bag to permit ready identification. The bag or label shall indicate the following information:

Stock Number
Nomenclature
Size and Length
Quantity

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

* 5.4 Palletization. When specified (see 6.2) item packed as specified shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means C, K, and L or O or P. Pallet pattern shall be in accordance with the appendix of MIL-STD-147.

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The pallet shall be 4-way, Type IV, Type V, Class 1, Size 2, or Type VIII, fabricated from wood group I, II, III or IV, Grade A of NN-P-71, or 4-way, Style 1, Size A, Type I, Class 1 fabricated from wood groups specified of MIL-P-15011. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall be approved by the contracting officer.

6. NOTES

6.1 Intended use. The trousers are for wear by male personnel of the military services as part of the dress or semi-dress uniform.

6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number and date of this specification.
- b. Class, length, and sizes required (see 1.2).
- c. When coat and trousers are procured as a uniform (see 1.3).
- * d. When a first article inspection is required (see 3.2). The item will be tested and should be a first article sample. The contracting officer should include specific instructions, quantity, and testing and approval of the first article.
- e. When permanent creasing is required (see 3.7.2).
- f. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- * g. When palletization is required (see 5.4).

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

6.4 Permanent creasing. A guide for the permanent creasing procedure is as follows. Spray the crease area with a 2-1/2 percent solution of monoethanolamine being careful to maintain greater wetting in the area to be creased and gradually tapering to each side (approximately 60 percent wet pick-up or when the fabric is damp to the touch on the inside). Both back and front crease areas are to be sprayed. The sprayed trousers are steamed on a leg presser, 30 seconds steam, 30 seconds bake. This is accomplished with the press head locked. The press head should be carefully balanced so that uniform creases in both legs will result. After the trousers are pressed, they should be hung in a heated room or chamber until dry using the following drying conditions:

(1) In drying room or chambers having no arrangement for exhausting the moisture laden atmosphere, the drying temperature shall not exceed 140 degrees Fahrenheit.

(2) In drying room or chambers containing circulating and exhausting system for the removal of moisture laden atmosphere, the drying temperature used may range from 140 to 180 degrees Fahrenheit.

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Materials required for the process are obtainable from Allied Chemical Corp., 40 Rector Street, New York 6, NY; Dow Chemical Co., Midland, MI; Olin Mathieson Chemical Corp., Chemical Division, Mathieson Building, Baltimore, MD. The monoethanolamine solution is prepared as follows: 16 (2-1/2 percent) fluid ounces monoethanolamine; 0.32 (0.05 percent) fluid ounces non-ionic surfactant, 624 ounces of water. Suitable surfactants are Triton X100, Rohm Hass Co., Philadelphia, PA; Igepal Co., 710 Antara Chemical Division of General Aniline and Film Corp, 435 Hudson Street, New York, NY, or their equal. The spraying is accomplished in a booth by means of spray nozzles riding on a traverse rod located about 3 feet above the surface of the spray table. The solution is applied to the entire length of the trouser leg starting at the bottom and traveling to the crotch. The trousers are turned over and sprayed during the return to the spray nozzles.

6.4.1 Caution regarding condition of press pads and covers. In processing and pressing the monoethanolamine treated trouser legs, there is a tendency for an accelerated build-up of rust, soil, scorch products, and chemical adulteration on the pads and covers of the presses. Accordingly, frequent replacement is recommended in order to eliminate the transfer of discoloration, soils, and stains to the trouser legs during the permanent creasing operation.

6.5 Permanent creasing solutions. Monoethanolamine solution has been approved for permanently creasing the trousers. No other solution is allowed except by specific approval of the contracting officer. Approval of such components is the responsibility of the US Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5000, and is based on extensive tests, including toxicity, which are not set forth in this specification. Because of the time necessary to conduct full evaluation only those chemical treatments already approved are acceptable for the related procurement.

6.5.1 Storage and stability (Shelf Life) of monoethanolamine, type I of MIL-E-50011, used in permanent creasing

- a. A six month storage life can be expected if stored in the original, unopened container at a temperature of 50 to 80°F.
- b. Care should be taken not to introduce contaminants during storage or while withdrawing the chemical for use.
- c. Discard monoethanolamine when color is distinctly amber and has a strong ammonia or fishy odor.
- d. Monoethanolamine on hand for six months or more should be tested to determine compliance with requirements of the type I compound under MIL-E-50011.

* 6.6 Navy officer's trousers of 65% polyester and 35% cotton twill material (Shade Navy Khaki 3729 and Navy White 3053); 75% polyester and 25% wool tropical material (Shade Navy Blue 3346), 100% wool serge material (Shade Navy Blue 3346), and 55% polyester and 45% wool gabardine (Shade Navy Blue 3346) are available as part of the US Navy officer's uniform and shall meet the requirements specified through the NCTR Certification Program.

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

* 6.8 Subject term (key word) listing.

Trousers, poly/wool tropical
Trousers, polyester serge
Trousers, unhemmed
Waistband, non-slip

Custodian:

Navy - NU
Air Force - 11

Preparing Activity:

Navy - NU

Review Activity.

DLA - CT
Air Force - 82
Air Force - 99

Project No. 8405-0964

User Activity:

Air Force - 45

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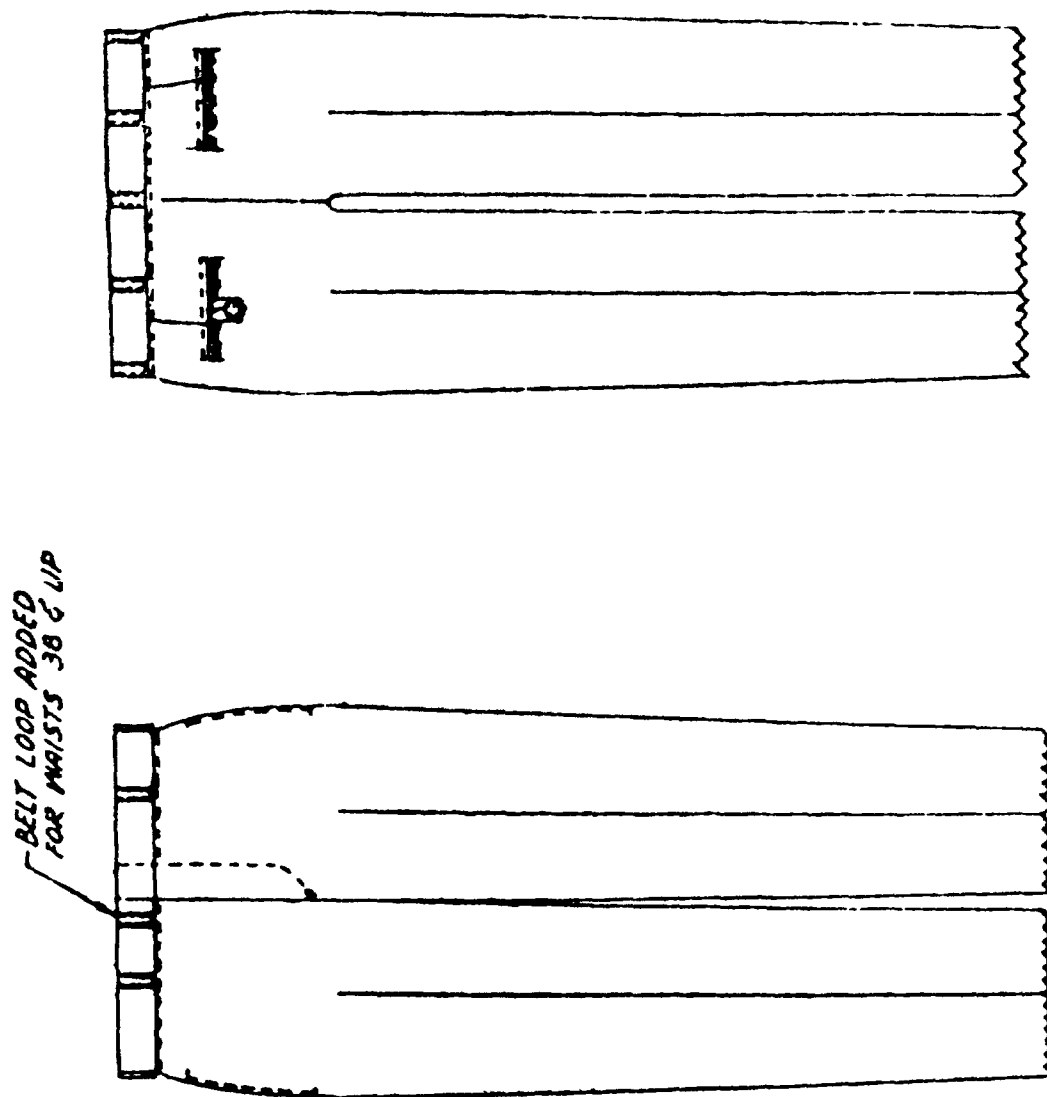


FIG. 1 - TROUSERS, MEN'S, WOOL AND POLYESTER/WOOL,

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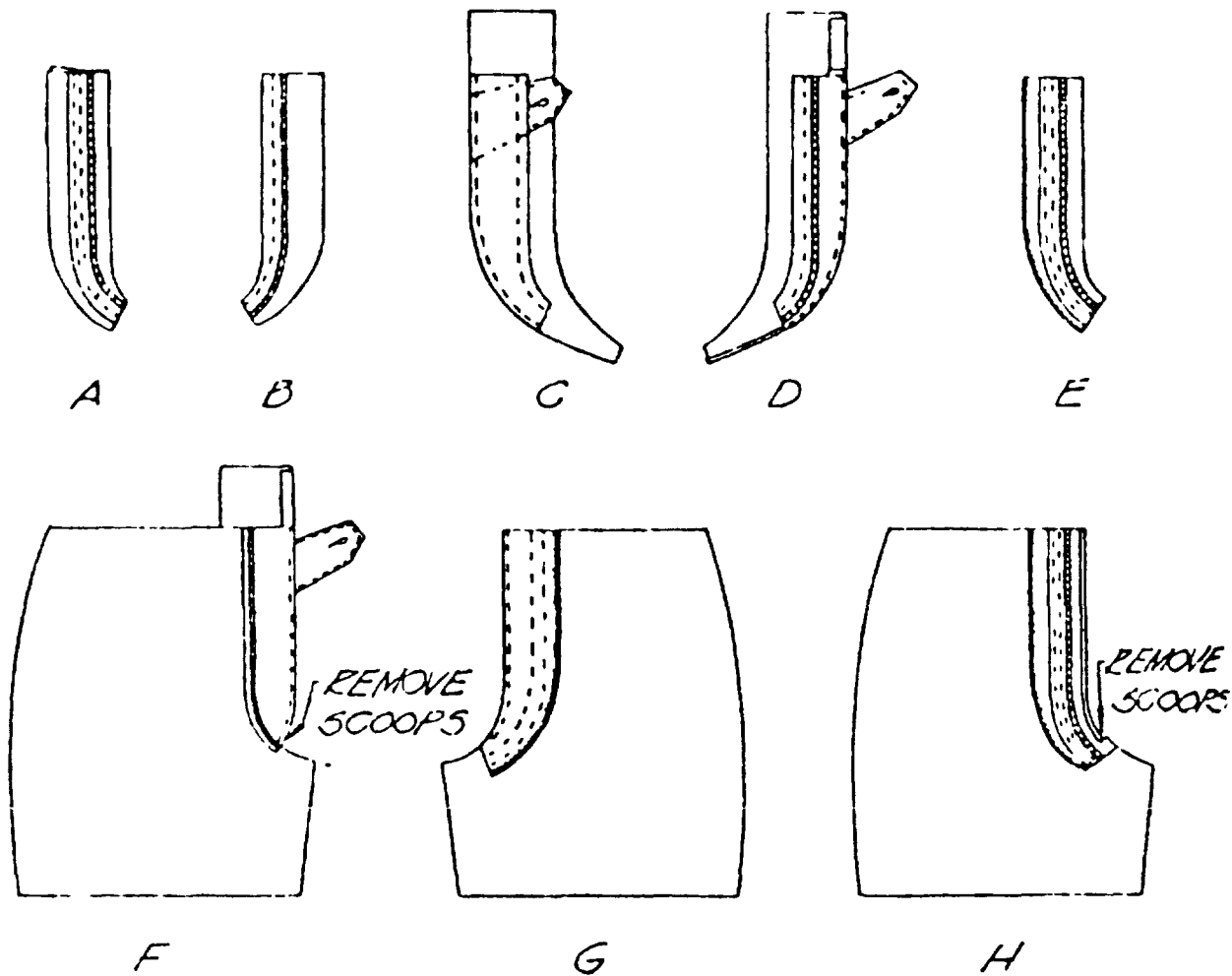
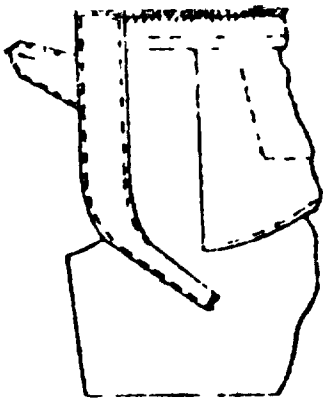


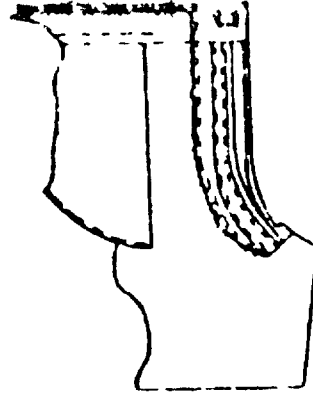
FIG-2. FLY (RIGHT WITH SEPARATE TAB, AND LEFT)

- 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 RAISE STITCH
- E - OVEREDGE LEFT FLY
- F - JOIN RIGHT FLY TO TROUSERS
- G & H - JOIN LEFT FLY TO TROUSERS AND PRESS.

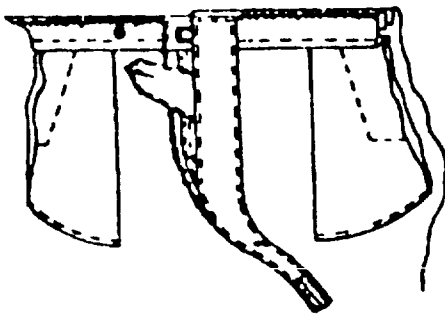
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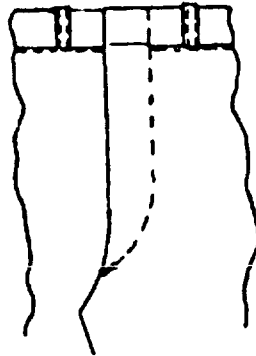
J



K



L



M

FIGURE-2-FLY (RIGHT WITH SEPARATE TAB, AND LEFT)-Continued

- J - RAISE STITCH RIGHT FLY CATCHING LINING
- K - RAISE STITCH BACK EDGE OF LEFT FLY THROUGH TROUSER
- L - FINISH END OF RIGHT FLY LINING
- M - BARTACK BASE OF FINISHED FLY

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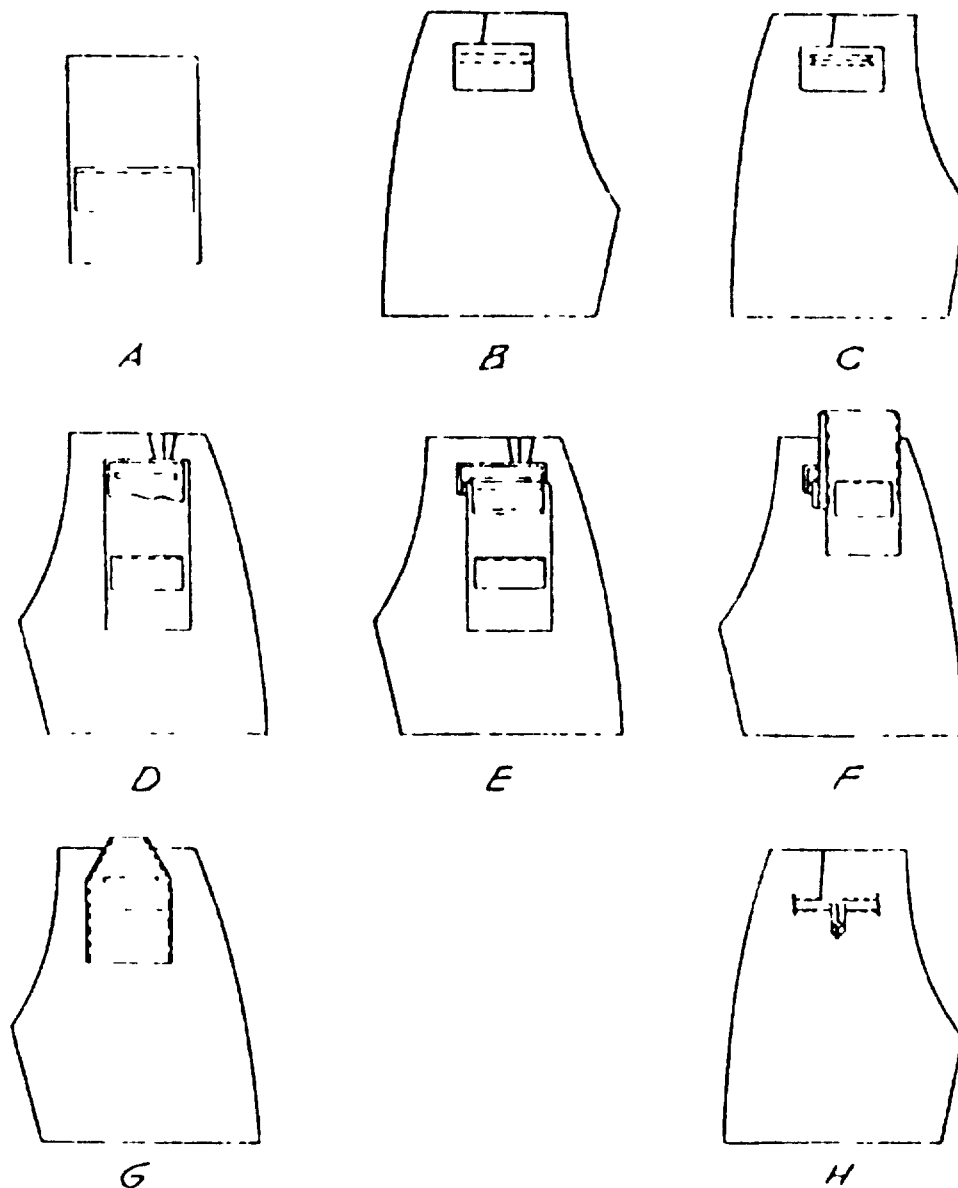


FIG.-3 - HIP POCKET

A-BEARER ON POCKET

B-CORD FACING PIECE ON OUTSIDE OF TROUSERS

C-CUT THROUGH CORD PIECE AND NOTCH

D-CORD PIECE TURNED INSIDE

E-MAKE CORD

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 WITH BUTTONHOLE TAB INSERTED.

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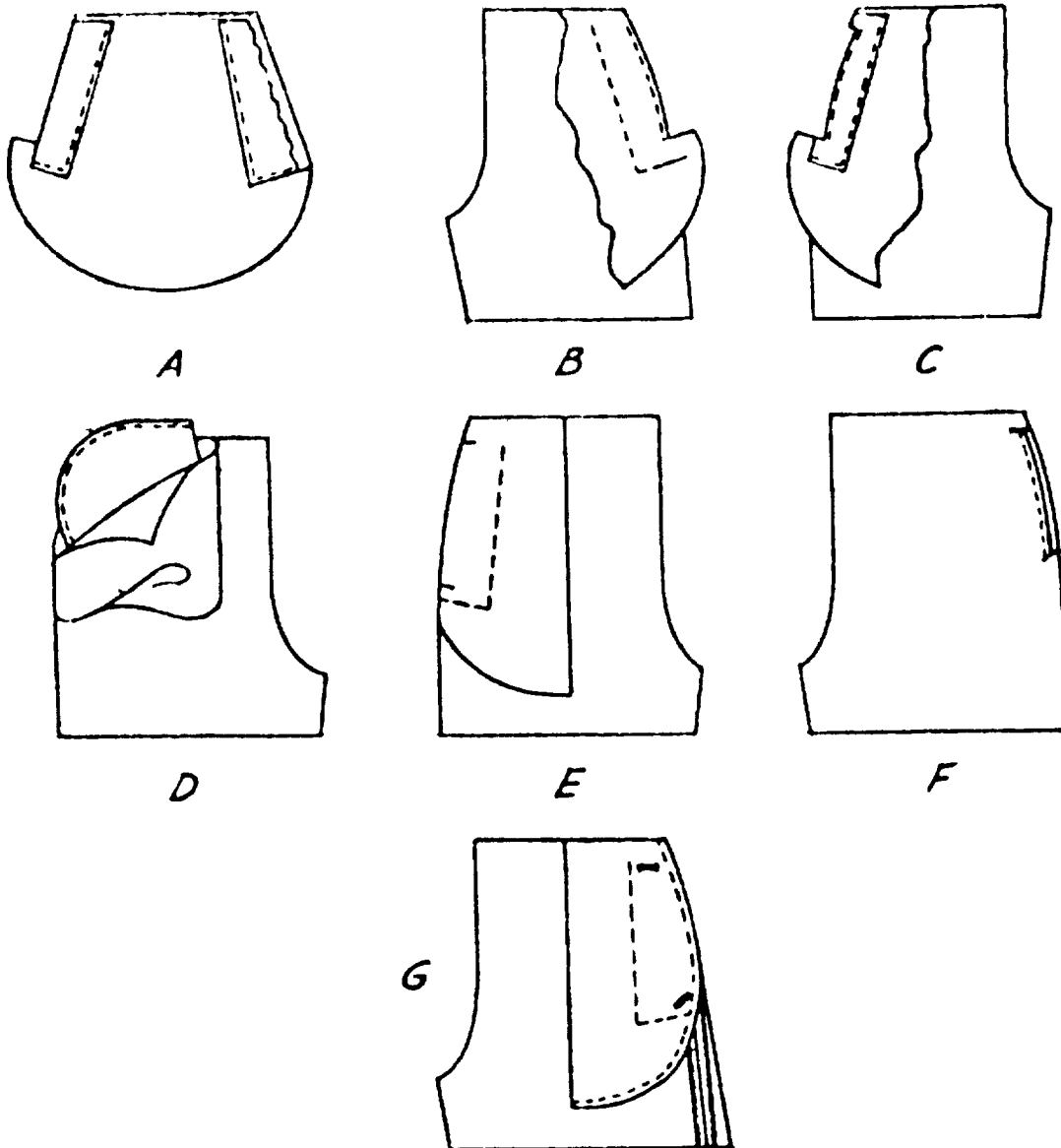


FIG. 4 SIDE POCKET

- 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**

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