

MIL-T-6284K  
26 March 1979

SUPERSEDING  
(See Section 6)

## MILITARY SPECIFICATION

### TROUSERS, EXTREME COLD WEATHER, TYPE F-1B

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

#### 1. SCOPE

- \* 1.1 Scope. This specification covers one type of flying trousers designated F-1B and furnished in the following sizes as specified (see 6.2):

24	28	32	36	40	44
26	30	34	38	42	46

#### 2. APPLICABLE DOCUMENTS

- \* 2.1 Issues of documents. The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

#### 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-295	Thread, Nylon
KK-L-2004	Leather, Cattle Hide, Deerskin and Horsehide, Chrome Tanned
CCC-C-426	Cloth, Cotton, Drill
CCC-C-440	Cloth, Cheesecloth, Cotton
DDD-L-20	Label, For Clothing, Equipage, And Tentage, (General Use)
PPP-B-636	Boxes, Shipping, Fiberboard
PPP-T-45	Tape; Gummed, Paper, Reinforced And Plain, For Sealing And Screening

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: HQ AFLC CASO/LODS, Federal Center, Battle Creek MI 49016 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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## Military

MIL-C-3735	Cuffs, Knit Wrist And Ankle And Cloth Knitted
MIL-C-3924	Cloth, Oxford, Cotton, Warp And Nylon Filling, Quarpel Treated
MIL-S-6790	Suspenders, Flying Suit
MIL-F-10884	Fasteners, Snap
MIL-C-18387	Cloth, Twill, Cotton, Fire Retarded Treated
MIL-F-21840	Fastener Tapes, Hook And Pile Synthetic
MIL-B-41826	Batting, Synthetic Fibers: Polyester, Quilted And Unquilted

## STANDARDS

## Federal

FED-STD-191	Textile Test Methods
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

## DRAWING

## Air Force

51B3557	Trousers - Air Crew, Heavy, Type F-1B
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(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

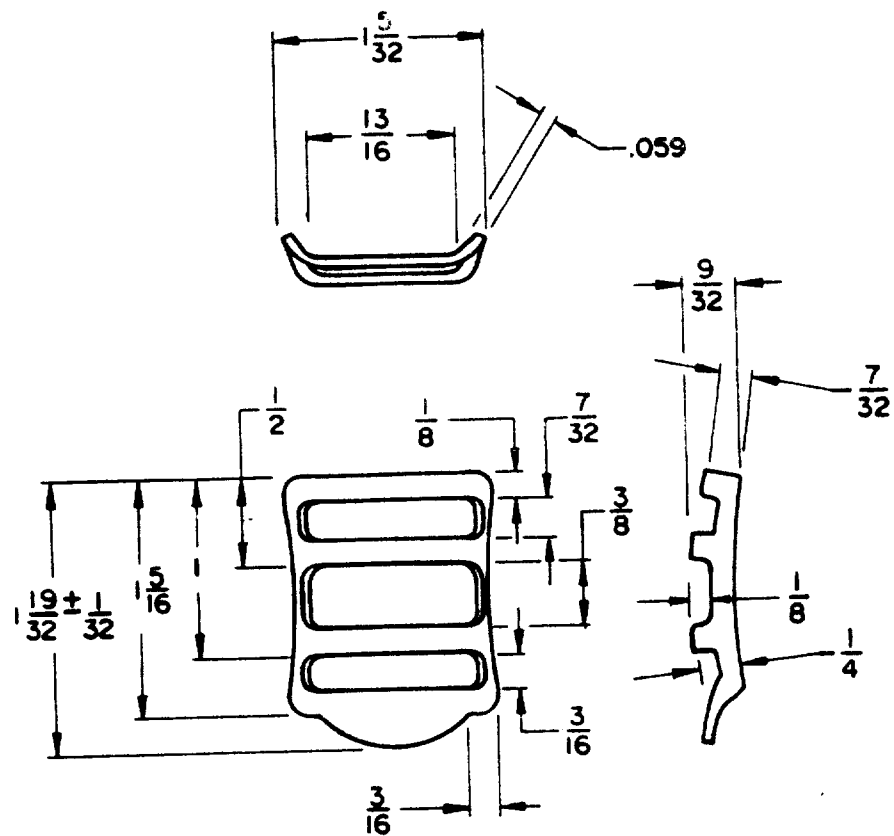
## 3. REQUIREMENTS

- \* 3.1 First article. When specified (see 6.5), the supplier shall furnish a sample for first article inspection and approval (see 4.2).
- \* 3.2 Materials.
  - \* 3.2.1 Basic material. The basic material for the trousers shall be as specified in 3.2.1.1 and 3.2.1.2.
    - \* 3.2.1.1 Outershell. The material for the outershell of the trousers shall be sage green USAF color shade No. 1509 and shall be Cloth, Oxford, Cotton Warp and Nylon Filling, Quarpel Treated, class 2, MIL-C-3924, except the air permeability maximum average shall be 5.0.

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- \* 3.2.1.2 Lining. The lining of the trousers shall be sage green USAF color shade No. 1509 and shall be Cloth, Twill, Cotton, Fire Retarded Treated, MIL-C-18387 except fire retardent air permeability, cu ft of air/minute/sq ft at 1/2 inch water pressure and stiffness requirements do not apply.
- 3.2.2 Interlining. The material for the interlining shall be Batting, Synthetic Fibers: Polyester, Quilted and Unquilted, type IV, style a, MIL-B-41826, except that the covering material shall conform to type I, class 2 of CCC-C-440, except that dimensional stability requirements do not apply.
- \* 3.2.3 Anklets. The anklets shall be knit wool cloth conforming to type I, class 3 of MIL-C-3735.
- \* 3.2.4 Pocketing. The pocketing shall conform to type I, class 2 of CCC-C-426 or shell material.
- 3.2.5 Thread.
  - 3.2.5.1 Nylon. The thread used for all sewing, except for the knitted fabric, shall conform to type I or II, class 1, size E or B of V-T-295. The thread shall show good colorfastness to wet-dry cleaning and to perspiration. The thread shall match the outer-shell material.
  - 3.2.5.2 Cotton. The thread for stitching the knitted fabric may be cotton thread conforming to type IA3, ticket No. 30, 3 ply of V-T-276.
  - 3.2.6 Buttons. The buttons shall conform to type II, class D melamine formaldehyde composition, style 4, size 27 line of V-B-871. The color of the buttons shall match the shade of the outer-shell material.
- \* 3.2.7 Leather. The leather used for the slide fastener pull tab shall be chrome-tanned horsehide leather conforming to type III, class 2, 1-1/2 to 3-1/4 ounces of KK-L-2004. The color of the leather tab shall be black.
- 3.2.8 Snap fasteners. The snap fasteners shall conform to style 2, finish 2 of MIL-F-10884, except that the accelerated-weather test for enamel coating is not required. The color of the visible surface of the cap portion of the snap fastener shall match the shade of the outer-shell material.
- 3.2.9 Slider. A 4-bar friction type of slider with lip, manufactured from brass or steel, with a dark oxidized finish and suitable for a 1-inch-wide strap shall be provided for adjusting the back waist. The slider shall conform to Figure 1.
- \* 3.2.10 Slide fasteners. The slide fasteners shall conform to Tables I and II herein and to V-F-106. The chain shall be brass, aluminum, or zinc alloy, with a short pull tab to accomodate a 3/8-inch-wide thong. The tape shall be cotton or cotton warp and nylon filling. The finish of the metal parts shall be natural chromate finish if zinc alloy, black chemical finish if brass, or colored anodized finish if aluminum. The length of the slide fastener shall conform to Table II.

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UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AND TOLERANCES ARE  $\pm 1/64$  FOR FRACTIONS AND  $\pm 0.005$  FOR DECIMALS.

FIGURE 1. 4-Bar slider

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TABLE I. Slide fasteners.

Location	Type	Style	Size	Length (Inches)
Pass-through opening	1	7	LMS <u>1/</u>	10-1/2
Fly opening	1	3	LMS <u>2/</u>	See Table II
Leg opening	1	3	MHS	14

1/ The tape shall be 3/4 inch (plus 1/16 inch or minus 1/32 inch) wide.  
2/ The tape shall be 9/16 inch (plus 1/16 inch or minus 1/32 inch wide).

TABLE II. Length of fly opening.

Size	Length (Inches) <u>1/</u>
24	8-1/4
26	8-1/2
28	8-3/4
30	9
32	9-1/4
34	9-1/2
36	9-3/4
38	10
40	10-1/4
42	10-1/2
44	10-3/4
46	11

1/ A tolerance of plus or minus 1/2 inch is permitted.

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- \* 3.2.10.1 Color of shade fastener tape. The tape shall be vat dyed to approximate the shade of the outershell material and shall have at least fair colorfastness to light and good colorfastness to weather only.
- \* 3.2.10.2 Hook and pile fastener tape. The fastener tape shall conform to type I, class I of MIL-F-21840. Color to approximate the shade of the outer shell.

3.3 Color. The USAF color shades (see 6.3) of the component materials for the outer shell and the wool anklets shall be as specified.

- \* 3.4 Design. The trousers shall consist of a outer shell interlined with a polyester cloth and lined with a twill cloth. Each pair of trousers shall have right and left hip pockets and right and left thigh pockets provided with flaps and hook and pile fasteners closures. The trousers shall have reinforcement patches, fabricated of outer-shell material, positioned at the seat and the knees. A 4-bar, friction-type slider buckle and take-up strap shall be positioned at the back waist for size adjustment. Each pair of trousers shall have side pass-through openings provided with protective flaps under the slide fasteners. The trousers fly opening shall have a slide-fastener closure with a protective flap under the slide fastener. The trousers shall terminate in knitted anklets and shall have a slide fastener positioned on the outer side of each leg, running a course from the trouser terminals to a point below the knee. The slide-fastener opening shall have a protective fly.

3.5 Construction. The trousers shall be constructed in accordance with Table III, but the manufacturer is not required to follow the exact sequence of operations as specified therein.

3.5.1 Stitches, seams, and stitchings. Stitches, Stitches, seams, and stitchings used in construction of the trousers shall conform to FED-STD-751. Whenever two or more methods, seams, or stitches are specified for the same operation, any one of them may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the garment.

3.5.1.1 Thread breaks and ends of seams. Ends of all seams and stitchings, when not caught in other seams or stitchings, shall be backstitched not less than 1/4 inch. 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 (stitch type 401) may be repaired using stitch type 301.

3.5.2 Stitches per inch. Unless otherwise specified, a tolerance of plus or minus one stitch per inch shall be permitted.

3.6 Patterns. The manufacturer's working patterns shall be identical in size and shape to the patterns referenced on 51B3557.

3.6.1 Pattern parts. The pattern parts and the number of parts cut shall be as specified in Table IV.

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TABLE III. Sewing operations.

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
1.	<p>CUTTING. The trousers shall be cut in accordance with the patterns that show size, shape, placement of pockets, and notches for proper assembling of all parts.</p> <p>a. OUTER SHELL. The oxford material shall be cut face down; that is, each ply of material shall be laid with the face of the cloth against the back of the next ply below, or as an alternate method, the cloth may be laid face to face. The finished trousers shall have the face side of the material on the outer side of the trousers. The face side of the material shall be the inside of the roll.</p> <p>b. Except for the leg protective fly, the side pass-through pocket protective fly pieces, the pocket facings, the facings for the leg and the side-pass-through openings, the fly linings, the flap linings, the strap linings, and the hangers, which may be cut from ends, all component parts of the outer shell shall be cut from one piece of material.</p> <p>c. INTERLINING. The batting material shall be cut in the direction of the warp, and the patterns may be tumbled.</p> <p>d. LINING. All component parts shall be cut from one piece of material. The material shall be cut face down (each ply of material shall be laid with the face of the cloth against the back of the next ply below), or as an alternate method, the cloth may be laid face to face.</p>			

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TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	<p>e. Patterns shall be laid in the warp direction in accordance with directional lines indicated on patterns for each component part of the trousers.</p> <p>f. Any part containing a hole shade bar, or weakening defects such as a smash, a multiple float, or a slub that is likely to develop into a hole shall be replaced at the time of cutting.</p> <p>g. Any part damaged during the manufacturing process by needle chews that may be expected to develop into a hole, scissor or knife cut, tear, hole, mend, burn, or exposed drill holes shall be replaced.</p>			
2.	<p>SHADE MARKING. Except for those parts cut from ends as indicated in No. 1., all component parts shall be marked or ticketed to insure a uniform shade and size throughout the trousers.</p>	301	SSE-3(a)	12
3.	<p>OUTER SHELL - BACK STRAPS. Sew the strans together with a single row of stitching 1/4 inch from the edge.</p>	301	SSE-3(b)	12
4.	<p>a. Turn and raise with a double row of stitching 1/4-inch gage 1/16 inch from the edge.</p> <p>BACK. Sew back darts with a 3/8-inch seam, catching the back strans at the notch and tapering to zero at the end. The 7-1/2-inch pointed strap shall be caught in the right back side of the trousers.</p> <p>a. Turn and raise seam on the darts, with the seam allowance toward the side seams on the inside, with a single row of stitching 1/16 inch from the edge.</p>	301	LSq-2(a)	12
		301	LSq-2(b)	12



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TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per. Inch
	<p>b. Bartack the top and the bottom edges of both back straps with a 1/2-inch bartack through the outer shell only. The bartack shall be vertical, and superimposed or adjacent to the dart raise stitching through all plies including seam allowance.</p>	bartack		28 per bartack
	<p>c. Attach the slider buckle to the left strap by threading the edge of the strap through the buckle 1 inch, and sew with a double row of stitching 1/4-inch gage 1/16 inch from the edge. The buckle side on back strap must be adjusted to accommodate 1/2 the width between the darts.</p>	301		12
	<p>d. SEAT PATCHES. Attach the seat patches, in accordance with the notches, with a 1/2-inch fold, and sew with a double row of stitching 1/4-inch gage 1/16 inch from the edge.</p>	301	Lsd-2	12
5.	<p>HIP AND THIGH POCKETS. Make two hip and two thigh welt and flap type of pockets. For sizes 32 to 46 inclusive (except as noted) the finished flap shall measure 7-3/4 inches (plus or minus 1/4 inch) long by 2-1/4 inches (plus or minus 1/4 inch) wide at the widest point. The welt shall measure approximately 7-3/4 inches (plus or minus 1/4 inch) long by 1/2 inch wide to correspond to the length of the flap. The depth of all pockets shall be 9-1/4 inches (plus or minus 1/4 inch) measured at the center.</p> <p>NOTE: The finished flap for sizes 24 to 30 shall measure 7 inches (plus or minus 1/4 inch) long by 2-1/4 inches wide at the widest point. The welt shall measure 7 inches long by 1/2 inch wide to correspond to the length of the flap; a 1/4-inch tolerance is allowed.</p> <p>a. The flap shall incorporate a sewn strip of fastener hook tape 3/4 inch wide and 3 inches long. Locate at drill marks and sew on four sides, with a single row of stitching, 1/16 inch from the edge.</p>	301	LSa-1	12

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TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	b. Sew strips of pile tape on pocket to correspond with hook tape on flap.	301	LSa-1	12
	c. Sew the flaps to the flap lining with a single row of stitching 1/4 inch from the edge, with square or slightly rounded corners.	301	SSE-3(a)	12
	d. Turn the flaps and raise with a double row of stitching, 1/4-inch gage 1/16 inch from the edge, catching the reinforcement piece in the second row of stitching. The drill reinforcing piece shall be centered between the inner and the outer plies.	301	SSE-3(b)	12
	e. Turn under 1/2 inch and sew the facings and the welt pieces to the ends of the pocketing with a single row of stitching 1/16 inch from the edge. When the facings and the welt pieces are cut with the selvedge, the selvedge edge need not be turned under.	301	LSd-1	12
	f. Sew the flaps, as indicated by the patterns, on the outer shell with a single row of stitching 1/4 inch from the edge.	301	SSa-1	12
	g. Sew the welt and the pocketing, with the raw edges of the pocketing and the flaps abutted with a single row of stitching 1/4 inch from the edge.	301		12
	h. Cut the pockets through with a diamond-shaped tongue at the corners.			
	i. Place the pocketing through the slits; double over at the edge for reinforcement to form a 1/2-inch welt.			
	j. Tongues at the corners shall be sewn to the welt on the inside with a single row of stitching.	301	SSa-1	12
	k. Sew around the sides and the bottom of the welts on the trousers with a single row of stitching 1/16 inch from the edge.	301	LSq-2(b)	12

TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	m. Fold the pocketing in place and sew through the flap and the seam allowance on the inside with a single row of stitching.	301	SSa-1	12
	n. Sew around the sides and the bottom of the pocketing with a row of stitching 1/2 inch from the side edges and 1/8 to 1/4 inch from the bottom folded edge.	301	SSa-1	12
	p. Sew across the top of the flaps on the trousers through the pocketing with a single row of stitching 1/16 inch from the edge.	301	LSq-2(b)	12
	q. Bartack each corner of the pocket opening with a 1/2-inch bartack through the outer shell only.	bartack		28 per bartack
6.	MAKE PASS-THROUGH. Join the facings to the fronts and the backs at the pass-through openings with a 3/8-inch seam	301	SSE-2(a)	12
	a. Turn and edge stitch with a single row of stitching 1/16 inch from the edge.	301	SSE-2(b)	12
7.	JOIN BACK SEAM OF INTERLINING. Join the seat seam with a 1/2-inch seam. In joining the seat seam, stretch shall be applied to the crotch to insure sufficient length of thread.	301	LSq-2(a)	12
	a. Turn and raise the seat seam, with a single row of stitching 1/4 inch from the edge with the left overlapping the right back.	301	LSq-2(b)	12
8.	KNEE PATCHES			
	a. Attach the knee patches, in accordance with the drill marks, matching the notches with a 1/2-inch fold, and sew with a double row of stitching 1/4-inch gage 1/16 inch from the edge.	301	LSq-2	12
	b. Join darts on the front leg with a single row of stitching 1/4-inch seam, tapering to zero.	301	LSq 2(a)	12

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TABLE III. Sewing Operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
9.	<p>c. Turn and raise, with a single row of stitching 1/16 inch from the edge, with the upper part overlapping the lower.</p> <p>PREPARE LININGS. Sew the battins interlining to the lining, face to face, for the side pass-through opening and the bottom leg opening 3/8 inch from the edge.</p> <p>a. Notch the openings at the corners, turn and edge stitch the openings 1/8 to 1/4 inch from the edge.</p> <p>b. Stitch the corresponding lining and interlining (fronts and backs) together along all raw edges, including the cutout darts 1/8 to 1/4 inch from the edge. In the finished trousers, the interlining shall be between the lining and the outer shell.</p>	301 301 or 401	LSq-2(b) SSE-2(a)	12 8-12
10.	<p>MAKE LEFT FLY. Position the left fly piece to the left front as indicated by the notch, and stitch 1/8 to 1/4 inch from the raw edge across the top and the front edge of the fly, through the lining and the interlining 1/16 to 1/8 inch from the edge</p> <p>a. Turn under the back edge of the fly, and stitch through the lining and the interlining 1/16 to 1/8 inch from the edge.</p> <p>NOTE: The back edge of the fly may be prehemmed prior to performing No. 10.a.</p> <p>b. Stitch the slide-fastener to the left fly through the lining and the interlining, with a double row of stitching 1/4 to 3/8 inch gauge. The bottom of the slide-fastener stop shall be positioned 1/2 inch above the fly notch, and the top end of the fastener tape shall be turned under and caught in the stitching to be away from the wearer. The scoops of the slide-fastener shall be positioned so that the right portion of the slide-fastener tape is not exposed when the slide-fastener of the fly is closed.</p>	301 301	SSa-1 SSa-1	12 12

TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
11.	<p>MAKE RIGHT FLY. Stitch the fly pieces together across the top and the front edge 1/4 to 3/8 inch from the edge.</p> <p>a. Turn the fly and edge stitch the seamed edge 1/16 to 1/8 inch from the edge.</p> <p>b. Quilt the fly with diagonal stitching with the points of the stitching approximately 3 inches apart. As an alternate method, omit operation 18a and close the open end 1/8 inch from the edge with 2 rows of stitching 3/4 inch gauge. Continue this stitching around all four sides.</p> <p>c. Stitch the assembled fly to the right front lining and interlining as indicated by the notch; continue the stitching to the bottom end of the assembled fly 3/8 inch from the raw edge.</p> <p>d. Raise stitch the seamed edge of the right fly, with the front lining over the fly, 1/8 to 3/16 inch from the edge. The raise stitching shall be from the top of the fly to approximately 1-1/2 inches above the bottom of the fly.</p>	301 301 301 301 301	SSE-2(a) SSE-2(b)  LSq-2(a) LSq-2(b)	12 12 12 12 12
12.	<p>ASSEMBLE FRONTS AND FLIES. Join the left front (outer shell) to the assembled lining and the interlining fronts from the fly notch to approximately 5 inches beyond the back edge of the left fly at the top of the trousers, 3/8-inch gage. Trim the top corner of the trousers: turn and edge stitch from the bottom notch to approximately 3 inches from beyond the back edge of the left fly at the top of the trousers, 1/4-inch gage.</p> <p>a. Stitch the back edge of the left fly, from the fly notch to the top of the trousers, through the inner and the outer shells 1-3/4 to 2 inches from the front edge. The line of stitching shall follow the contour at the bottom of the fly.</p>	301	SSE-2	12

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TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	<p>b. Stitch the right portion of the slide-fastener tape to the right front outer shell 3/8 inch from the edge. The bottom of the slide-fastener stop shall be positioned approximately 1/2 inch above the fly notch, and the top raw end of the tape shall be turned in at the top and caught in stitching 301.</p>	301	LSb-2	12
	<p>c. Join the crotch of the outer shell with a double row of stitching 1/4-inch to 5/6-inch gage 1/16 inch from the edge, with the left front over the right front.</p>	301	SSa-1	12
13.	<p>d. Join the inner shell at the crotch, as indicated by the pattern notch, with a single row of stitching 3/8-inch gage.</p>	301 or 401	LSc-2	12
	<p>JOIN OUTER SHELL. Join the backs (seam) with a 1/2-inch seam, and raise stitch seam 1/4 inch from the edge.</p>	301	LSq-2	12
	<p>a. The seat seat may be joined with a double lapped seam 1/4-inch to 5/16-inch gage 1/16 inch from the edge.</p>	301	LSa(a)	12
	<p>b. Join the side seam above and below the side pass-through opening and with the back over the front; raise stitch seam 1/4 inch from the edge.</p>	301	LSg-2(b)	12
	<p>c. Join inseam with a single row of stitching 1/2 inch seam</p>	301	LSc-2	12
	<p>d. Turn and raise inseam, with a single row of stitching 1/4 inch from the edge with the back overlapping the front</p>	301 or 401	LSa(a)	12
	<p>e. Join the outer shell inseams of trousers with the back overlapping the front, with a double-lapped seam, with a double row of stitching, with not less than 1/4 inch gage nor more than 5/16 inch gage.</p>	301 or 401	LSc-2	12

TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per inch
14.	<p>JOIN BACK OF INNER SHELL. Join the backs (seat seam) with a single row 3/8 inch from the edge: spread seam open and raise stitch 1/8 inch-gage each side of seam.</p> <p>a. Sew the label to the lining and the interlining, on all four sides 1/16 to 1/8 inch from the edge, centered on the seat seam 3 (plus or minus 1/2) inches below the top edges.</p> <p>b. Make a hanger of the outer-shell material. The finished hanger shall be 3/8 to 1/2 inch wide and approximately 5-1/2 inches long.</p> <p>c. Position the hanger directly above the label centered across the seat seam. Turn under and tack each end with a double row of back-stitching, or the ends may be bartacked with one bartack.</p>	301 of 401	SSz-3	12
15.	<p>JOIN INNER SHELLS, DARTS, SIDE SEAMS, AND INSEAMS. Join the knee and the back darts with a 3/8-inch seam tapering to zero at the end; spread the seams open and raise stitch 1/8-inch gage on each side of the seam.</p> <p>a. Join the side seams above and below the pass-through opening with a 3/8-inch seam: spread seam open and raise stitch 1/8-inch gage each side of the seam.</p>	301 bartack	Lsd-2	12 per bartack
16.	<p>KNITTED CUFFS. Sew the facings to each end of the knitted wool fabric with a single row of stitching 1/2-inch gage; raise stitch seam on the side of the basic material 1/4 inch from the edge.</p> <p>a. Sew both sides of the knitted cuff facings with each end turned back 1/2 inch and stitch to the bottom of the lining and the interlining assembly 1/2 inch gage.</p>	301 or 401	SSz-3	12
		301	LSq-2	12
		301	SSa-1	12

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TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
17.	<p>SLIDE FASTENERS AND THONGS. Sew the slide fasteners to the pass-through openings of the lining-interlining assembly with a single row of stitching 1/16 to 1/8 inch from the edge, exposing approximately 1/4 inch of the slide-fastener tape. The slider shall be at the bottom when the slide fastener is closed.</p> <p>a. Sew the slide fasteners to the lining-interlining assembly, at the bottom opening, including the turned under knitted cuff facings in accordance with the notches, with a single row of stitching 1/16 to 1/8 inch from the edge, exposing approximately 1/4-inch of the slide-fastener tape. When the slide fastener is closed, the slider shall be at the bottom.</p>	301		12
	<p>b. Position the leather thongs in the holes of the sliders, and sew all around the top, the sides, and the bottom with a single row of stitching 1/8 inch from the edge, or the leather thong may be securely stitched with a cross box stitch, circular stitch or a triangular stitching with an automatic machine.</p>	301 auto- matic	SSa-1	10 28 stitches minimum
	<p>c. Secure the top and bottom of the side pass-through and the top of the bottom openings with a horizontal bartack through both sides of the slide-fastener tape and the lining-interlining assembly.</p>	304		42
18.	<p>MAKE PROTECTIVE FLY FOR PASS-THROUGH AND BOTTOM OPENINGS OF TROUSERS. Double the outer-shell material lengthwise; add one ply of pile material; join together on the sides, with a single row of stitching 3/8-inch gage, leaving an opening for turning.</p>	301	SSF-2(a)	12
	<p>a. Turn and edge stitch the four sides of the protective flies 1/4 inch from the edge closing the openings in the stitching.</p>	301	SSE-2(b) SSC-1 OSf-1	12
	<p>b. Quilt the protective flies with rows of diagonal stitching, with the points of the stitching approximately 3 inches apart.</p>	301	SSV-	12



TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
	<p>c. Position the protective fly of the pass-through to the back part of the trousers, approximately 3/4 inch from the side edge of the opening, covering the entire length of the opening, and stitch to the inner shell 1/8 inch from the folded edge. The side of the protective fly facing the front shall be left free.</p>	301		12
	<p>d. Place the protective fly on the front of the trousers at the bottom of the trouser, approximately 3/4 inch from the side edge of the opening, and stitch to the inner shell 1/8 inch from the folded edge. The leg protective fly shall extend approximately 1/4 inch from the finished bottom edge of the trousers. The side of the protective fly facing the back shall be left free.</p>	301		12
19.	<p>SWITCH KNITTED CUFF ASSEMBLY TO BOTTOM OF TROUSERS. Turn back each end of the facing 1/2 inch and stitch the facings and one ply of the knitted cuff to the bottom of the outer shell of the trousers, with the edge of the fold even with the opening, with a 1/2-inch seam.</p>	301	SSa-1	12
	<p>a. Complete the stitching of the knitted cuff to the bottom of the lining-interlining assembly with a single row of stitching 1/2-inch gage.</p>	301	SSa-1	12
	<p>b. Join the seam allowance of the knitted cuff at the bottom with a row of stitching to within approximately 1 inch from the cuff facing seam on both sides.</p>	301	SSa-1	13
20.	<p>JOIN INSEAM OF INTER-SHELL. Join the inseam with a single row of stitching 3/8 inch from the edge, spread seam open and raise stitch 1/8 inch gage each side of seam.</p>	301 of 401	SSz-3	12

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TABLE III. Sewing Operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
21.	CLOSE THE OUTER SHELL TO ZIPPER AND LINING AT PASS THROUGH AND LEG OPENING. Stitch with two rows of stitching 1/4 inch gage, 1/16 inch from folded edge, down side, across the bottom, up the other side, across the top of opening through all plies. Close the bottom leg opening stitch with 1/4 inch gage, 1/16 inch from edge up one side of zipper across top and down the other side through all plies. Ends of stitches backstitched. In performing the pass through and leg opening closing, do not catch the protective fly in the stitching.	301	Sse-2(a)	12
22.	COMPLETE SEWING OF OUTER SHELL TO INNER SHELL. Stitch the inner shell to the outer shell at the top of the trousers, starting beyond the end of the stitching performed in operation No. 12 and finish at the back edge of the right fly.	301	Sse-2(b)	12
	a. Turn the trousers right side out through the opening in the right fly.			
	b. Edge stitch the top of the trousers, 1/4-inch gage, from the back edge of the right fly 1/2 to 1 inch beyond the edge stitching on the left front performed in operation No. 12.			
	c. Raise stitch 1/4-inch gage the bottom of the trousers through the knitted cuff seam allowance from one edge of the facing to the outer edge of the facing.			
	d. Turn under the right trouser, front over the right fly, joining seam with the slide-fastener tape between the front and the fly. Topstitch the right front edge, through all plies 1/16 to 1/8 inch from the seamed edge.			

TABLE III. Sewing Operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
23.	<p>BARTACKING. In addition to the bartacking operations specified in the preceding operations, the following locations shall be bartacked with a 1/2-inch bartack.</p> <p>a. Bartack the top and the bottom free ends of the protective fly of the side pass-through through the outer shell and the lining.</p> <p>b. Bartack the bottom of the fly opening through the linings and the outer shell, catching the right fly.</p> <p>c. Bartack the top of the free end of the protective fly at the bottom of the right and the left leg openings of the trousers, through the outer shell and the lining.</p> <p>d. Vertically bartack the bottom of both slide-fastener tapes at the right and the left leg terminals.</p>	304 bartack		42 per bartack
24.	<p>SNAP FASTENERS. Stamp on one snap fastener socket 1/2 inch from the left fly front edge and 3/4 inch from the top waist edge. The snap fastener shall be at the top edge of the fastener tape when finished.</p>			
25.	<p>a. Stamp the stud and the eyelet on the right front of the fly in a position that corresponds with the sockets of the snap fasteners on the left fly.</p> <p>SPACE AND SEW ON BUTTONS. The suspender buttons shall be placed as follows: front buttons 1/2 the distance between the side and the fly opening; one button 1/2 inch in front of each side seam; two back buttons 2 inches from the seat seam; and two buttons, to act as snares, placed 1 inch outward from each back button. All buttons shall be 1 inch from the waist edge.</p>	101 or 301		20 to 22 per buttons 16 to 18 per button

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TABLE III. Sewing operations. (Cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch
26.	<p>CLEANING</p> <p>a. All thread ends shall be trimmed, and loose ends shall be removed.</p> <p>b. Remove all spots, stains, and shade tickets.</p> <p>c. Shade tickets shall be removed without harming the fabric.</p>			
27.	<p>NOTES</p> <p>a. SEWING TOLERANCES. The tolerances of the operations specified herein shall be plus or minus 1/16 inch for raise seam 3/16-inch gage; plus 1/16, minus 0 for raise seams open 1/8 inch; plus 1/16 inch, minus 0 for 1/16 inch from the edge.</p> <p>b. The letters "l" and "o" are not used to designate the subparagraphs of this table because of their resemblance to the numerals "1" and "0."</p>			

TABLE IV. Pattern parts.

Material	Part	Quantity to be cut
Basic material (see 3.2.1.1 for class 1 and see 3.2.1.3 for class 2)	Fronts	2
	Backs	2
	Leg protective fly	2
	Side pass through protective fly	2
	Front pass through facing	2
	Back pass through facing	2
	Lower leg facing	4
	Back takeup straps	2
	Buckle straps	2
	Seat patches	2
	Left fly facing	1
	Right fly	2
	Hip and thigh pocket welts and facings	2
	Pocket flaps and lining	8
	Knit cuff facings	8
	Hanger loop	4
Knee patches	2	
Lining (see 3.2.1.2 for class 1 and see 3.2.1.4 for class 2)	Fronts	2
	Backs	2
Interlining (see 3.2.2)	Fronts	2
	Backs	2
	Side pass through protective fly	2
	Leg protective fly	2
Drill pocketing (see 3.2.4)	Hip and thigh pockets	4

- \* 3.7 Suspenders. Each pair of trousers shall be furnished with a pair of suspenders conforming to type I of MIL-S-6790, except that the color-fastness to wet crocking shall be fair for the leather compounds and the identification marking is not required. The suspenders shall be attached to the trousers. The color of the suspenders shall be sage green matching the shade of the outer-shell material.

3.8 Finished measurements. The finished measurements shall conform to Table V.

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TABLE V. Finished measurements in inches.

Size	Measurement <u>1/</u>	
	1/2 Waist <u>2/</u>	Inseam <u>3/</u>
24	14	27-1/4
26	15	27-1/2
28	16	28-3/4
30	17	28-1/4
32	18	28
34	19	29-1/4
36	20	29
38	21	30
40	22	29-3/4
42	22-3/4	29-1/2
44	23-3/4	31-3/4
46	24-3/4	31-1/2

- 1/ The tolerance shall be plus or minus 1/2 inch for the 1/2 waist and plus or minus 3/4 inch for the inseam.
- 2/ The measurement of the 1/2 waist shall be taken, with the slide fastener closed and with the trousers laid flat along the top of the fronts from side to side.
- 3/ The measurement of the inseam shall be taken, from the crotch to the top of the knit, on the inside of the leg.

### 3.9 Identification of product.

- \* 3.9.1 Identification label. A printed label conforming to type I, class 1 of DDD-L-20 shall be securely sewn to the lining of each pair of trousers. The label shall measure not less than 1-5/16 inches wide by 3 inches long. The trousers are intended to be dry cleaned.

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Trousers, Extreme Cold Weather, Type F-1B  
MIL-T-6284K  
Stock No. 1/  
Size 1/  
Manufacturer's Identification 1/  
Contract No. and Date 1/  
Dry Clean Only

1/ The manufacturer shall include the applicable information.

3.9.2 Workmanship. The trousers shall be constructed in a thoroughly workman-like manner. The finished trousers shall be clean and free from any defects that might affect appearance or functionability.

#### 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 the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

\* 4.2 First article inspection. When required (see 6.5), the preproduction sample submitted in accordance with 3.1 shall be inspected for all the provisions of this specification applicable to end product examination.

4.3 Inspection for acceptance. Unless otherwise specified hereinafter, inspection shall be in accordance with MIL-STD-105.

4.3.1 Testing of components. Except that this specification shall govern in the event of conflict, testing of components shall be in accordance with applicable subsidiary specifications and drawings referenced to the extent applicable. In addition to the testing provisions contained in subsidiary specifications and drawings, testing shall be performed on the component listed in Table VI for the characteristics noted.

4.3.1.1 Sampling for testing. Unless specifically requested by the Government, Government furnished materials shall not be sampled or tested. The acceptable quality level (AQL) for characteristic tested shall be 6.5 defects per 100 units (dhu). The sample unit for testing sliders shall be one slider, and the unit for expressing the lot size of the sliders shall be six sliders.

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TABLE VI. Testing of buckle (slider).

Characteristic	Requirement (See 3.1.9)	Test Method	Determinations Per Sample Unit
Material characteristic	Brass or steel <u>1/</u>	standard commercial	1
Style	4-bar, friction- type slider with lip <u>1/</u>	standard commercial	1
Dimensions	conform to figure 1	gage and rule	1 for each rule
Finish	dark oxidized <u>1/</u>	standard commercial	1

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

4.3.2 Examination of the end item. Trousers shall be examined for the defects listed in 4.3.2.1, 4.3.2.2 and 4.3.2.3. Except for the defects with an asterisk (\*) in the classification column, all defects found during examination shall be classified in accordance with 4.3.2.1, 4.3.2.2, and 4.3.2.3. A defect with an asterisk in the classification column shall be classified as a major defect when it affects appearance or serviceability seriously and as a minor A defect when it affects appearance or serviceability but not seriously. The inspection level for 4.3.2.1 and 4.3.2.2 (combined) shall be II of MIL-STD-105, and the inspection level for 4.3.2.3 shall be S-3 of the appendix of MIL-STD-105. The AQL for 4.3.2.1 and 4.3.2.2 shall be 2.5 dhu for major defects, 15.0 dhu for major and minor A (combined) defects, and 50.0 dhu for total major and minor A and B (combined) defects. The AQL for 4.3.2.3 shall be 4.0 dhu for defects (one class).

\* 4.3.2.1 General Defects. General defects shall be classified as follows:

1. BARTACKS (APPLYING TO ALL BARTACKS)
  - a. One or more missing or loose
  - b. Misplaced, not serving intended purpose
    - one bartack
    - two or more bartacks

	Classification	
	Major	Minor
		A
		X
	X	X



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		Classification	
		Major	Minor
		A	B
2.	BUCKLE		
	a. Not specified type, size, or finish		X
	b. Missing, bent, broken, or defective	X	
	c. Rough or sharp edges		
3.	BUTTONS (APPLYING TO ALL BUTTONS)		
	a. Missing, loose or broken		
	-one button		X
	-two or more buttons	X	
	b. Not specified type size, or color	X	
4.	CLEANNESS		
	a. Spot or stain of a permanent nature		
	b. Removable spot or stain, clearly noticeable		X
	c. Thread ends not trimmed or loose thread or one or more shade tickets not removed		X
	d. Any shade stamp marking exposed and visible on outside of trousers (to be scored only when clearly noticeable)		
5.	COMPONENTS AND ASSEMBLY		
	a. Any defective component		
	b. Any component part omitted		
	c. Any required operation omitted or improperly performed		
6.	CUTTING		
	a. Any component part not cut in accordance with directional lines indicated on patterns or specified requirements	X	
	b. Any component part of outer shell finished with twill lines not running from lower left-hand corner to upper right-hand corner	X	

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	Classification	
	Major	Minor
		A
<b>7. LABELS</b>		
<b>a. Identification</b>		
(1) Missing, incorrect, or illegible		X
(2) Not stitched on four sides		X
(3) Placed less than 2-1/2 inches or more than 3-1/2 inches below top edge of trousers		X
(4) Off-center with seat seam by more than 1/2 inch		X
(5) Size shown on label not in conformance with size shown on intermediate or outer container, as applicable		X
<b>b. Size ticket missing, incorrect, illegible, or not securely stitched to thigh pocket</b>		X
<b>8. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES</b> (Material defects and workmanship damages shall be classified as indicated when the defect definitely weakens fabric. If the defect does not definitely weaken the fabric but the defect is conspicuous when the item is worn, the defect shall be classified as indicated. Material defects or workmanship damages which are inconspicuous and do not definitely weaken the fabric shall not be classified as defects.)		
<b>a. Applicable to all materials except knitted fabric</b>		
(1) Any weakening defect, such as smash, multiple float, or loose slub that may develop into a hole		
(2) Shade bars, slubs, dye or finishing streaks		
(3) Hole, scissor or knife cut, tear, mend, or burn or a needle chew that may develop into a hole		
(4) Ruptured fibers in the line of sewing (usually caused by broken, blunt, or hooked needles) affecting appearance or serviceability		X
(5) One or more bare spots in pile fabric		

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	Classification	
	Major	Minor
		A
b. Applicable to knitted fabric		
(1) Hole, run, or dropped stitches	*	
(2) Elasticity lacking, i.e., tight		X
(3) Slubby yarn, affecting appearance		X
(4) Unsightly mend		X
9. SEAMS AND STITCHING. (Nylon fabrics have a tendency to pucker at joining seams and at stitching. Unless this puckering is excessive so that it seriously affects appearance, it shall not be classified as a defect.)		
a. Accuracy of seaming		
(1) Seam twisted, puckered, or pleated, affecting appearance (unless otherwise classified herein)		X
(2) Part of trousers caught in any unrelated operation of stitching	*	
(3) Thread(s) used on outside of same trousers not same shade or not satisfactorily matching shade of garment, affecting appearance		X
(4) Thread breaks or end(s) of stitching, when not caught in other seams or stitching, not backstitched		X
(5) Fastener tape not sewn properly		X
b. Gage of stitching (edge, raised or double stitching)		X
(1) Irregular, i.e., unevenly gaged or corresponding stitchings not uniformly gaged, affecting appearance		X
(2) Gage of stitching (width) exceeding tolerance specified in Table III		X
c. Open seams. (A break in a line of stitching or continuous skipped or run-off stitches (except on edge or raise stitching) shall constitute an open seam.)		

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	Classification		
	Major	Minor	
		A	B
(1) Any open seam on outside -more than 1/8 inch but not more than 1/4 inch -more than 1/4 inch but not more than 1 inch -more than 1 inch	X	X	X
(2) Any open seam on inside -1/4 inch or more but not more than 1/2 inch -more than 1/2 inch		X	X
d. Raw edges. (A raw edge shall be classified as such when it occurs along an edge required to be turned under, but the edge is securely caught in the stitching. If the edge is not securely caught in the stitching, it shall be scored as an open seam.)			
(1) Any raw edge on outside -less than 1/8 inch or more but less than 1/4 inch -1/4 inch or more but not more than 1 inch -more than 1 inch	X	X	X
(2) Any raw edge on inside -1/4 inch or more but not more than 1 inch -more than 1 inch		X	X
e. Run-offs			
(1) On joining seams, when resulting in an open seam, to be classified as open seam			
(2) On edge or raise stitching when not resulting in open seam -more than 1/4 inch but not more than 1/2 inch -more than 1/2 inch		X	X
f. Seams and stitching not specified seam or stitch type		X	
g. Stitch tension. (Puckering is evidence of tight tension. When puckering is evident, seam shall be tested by exerting normal pull in the lengthwise direction of seam or stitching.)			
(1) Loose tension, resulting in a loose seam	X		
(2) Loose tension on edge, top, or raise stitching, recognized by loosely exposed loops of top or lower thread		X	

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## Classification

	Major	Minor	
		A	B
(3) Tight tension (stitches break when normal strain is applied to seam or stitching) to be scored as an open seam			
h. Stitches per inch, plus or minus tolerance of 1 stitch (to be scored only when the condition exists on major portion of seam)			
(1) Exceeding the minimum tolerance specified (except on labels) -one or two stitches -three stitches -more than three stitches	X	X	X
(2) Exceeding the maximum specified (except on labels) -one or two stitches -three or more stitches		X	X
(3) Exceeding the minimum tolerance specified by one or more stitches on labels			X
i. Stitches skipped or broken			
(1) One edge or raised stitching when seam is seamed, turned, and stitched -1/4 inch or more but not more than 1/2 inch -more than 1/2 inch		X	X
(2) On quilting stitching more than 1 inch			X
10. SHADED PARTS			
a. Any outer-shell part shaded, except pocket facings, strap linings, and hanger			
b. Any lining part shaded, except leg protective fly and side pass-through pocket protective fly pieces			X
11. SNAP FASTENERS. (Studs and sockets shall be checked for proper functioning and secure clinching by opening and closing several times)			
a. Missing, loose, mismatched, or otherwise defective, affecting function -one snap fastener -two or more snap fasteners	X		X

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	Classification		
	Major	Minor	
		A	B
b. Not specified type, size, or finished		X	
c. Rough or sharp edges		X	
d. One or more clinched too tightly, cutting surrounding fabric	X		
12. SLIDE FASTENERS. (Slide fasteners shall be checked for proper functioning by opening and closing the slide fastener at least three times.)			
a. One or more omitted or defective, affecting function	X		
b. Not specified type, size, style, or class		X	
c. Tape set on too loosely or too tightly causing bulge, twist, or fullness on outside of trousers when fastener is closed, affecting appearance		X	
d. Stitched too close to metal chain, not permitting slider to pass	X		
e. Thong omitted or not specified type		X	
f. Thong stitching around top, bottom, or sides omitted or insecure			X
13. POLYETHYLENE BAG			
a. Any bag not completely sealed			X

- \* 4.3.2.2 Detailed defects applicable to specific parts. Detailed defects applicable to specific parts shall be classified as follows:

	Classification		
	Major	Minor	
		A	B
OUTSIDE OF TROUSERS			
1. TOP EDGE OF TROUSERS			
a. Excessive fullness, twist puckers, or gathers at joining to lining, affecting appearance		X	
b. Lining exposed above top of trousers, affecting appearance (to be scored only when condition exists along major portion of seam)		X	

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## Classification

	Major	Minor	
		A	B
2. SUSPENDERS AND BUTTONS			
a. Front buttons placed 1 inch or more from midway between fly opening and side seam		X	
b. Side seam button placed 1 inch or more from either side of side seam		X	
c. Back buttons placed less than 1-1/2 inches or more than 3 inches from seat seam		X	
d. Buttons placed less than 3/4 inch or more than 1-1/4 inches from top edge of trousers			X
e. Suspenders not attached to trousers		X	
f. Spare buttons placed less than 1/2 inch or more than 1-1/2 inches outward from each back button			X
3. PASS-THROUGH OPENINGS			
a. Openings on right and left side out of horizontal alignment by more than 3/4 inch		X	
b. Ends of opening puckered or twisted, affecting appearance		X	
c. Protective fly not completely covering top or lower ends of opening		X	
d. Diagonal rows of stitching on protective fly omitted		X	
e. Diagonal points of stitching more than 3-1/2 inches apart			X
f. Outer shell stitched to fastener openings with one row of stitching		X	
g. Opening less than 10 inches or more than 11 inches in length			X
h. Slide fastener reversed, i.e., closing upwards instead of downwards	X		

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	Classification		
	Major	Minor	
		A	B
4. FLY CONSTRUCTION AND CLOSURE			
a. Fly or fly base twisted, puckered, or bulging affecting appearance		X	
b. Fly opening uneven in length by -1/4 inch or more but not more than 3/8 inch -more than 3/8 inch	X	X	
c. Right fly stitching or fastener tape exposed beyond left front edge when fly is closed (to be scored when condition exists on major portion of seam)		X	
d. Diagonal rows of quilting stitching omitted on right fly		X	
e. Diagonal points of stitching on right fly more than 3-1/2 inches apart			X
f. Tape stitched to left fly with one row of stitching		X	
g. Ends of metal chain uneven at bottom of fly -1/4 inch or more but not more than 1/2 inch -more than 1/2 inch		X	X
h. Socket and stud not aligned, causing bulge or twist on fly when clinched, affecting appearance		X	
i. Waist socket placed less than 5/8 inch or more than 7/8 inch from top edge or less than 3/8 inch or more than 5/8 inch from left fly edge		X	
j. Edge of fly pleated in fly bartack		X	
k. Left fly exposed beyond front edge affecting appearance		X	
l. Slide fastener set too high above base of opening, leaving a gap between end of fastener chain and fly bartack by more than 1/2 inch			X
m. One or more ends of fastener tapes not turned under		X	
n. Length of fly opening exceeding measurement specified in Table II		X	



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	Classification		
	Major	Minor	
		A	B
5. POCKETS			
a. Applying to all pockets			
(1) Notch exposed at one or both ends of one or more openings			
(2) Facing short, i.e., ends of facing not caught in bartacks	X		
b. Hip and thigh pockets			
(1) Flap lining tight or short, causing flap to curl or fullness on outside, affecting appearance		X	
(2) Corners of opening pleated or puckered, affecting appearance		X	
(3) Flap poorly shaped, affecting appearance		X	
(4) Length of finished flap and opening -less than 6-3/4 inches or more than 7-1/4 inches for sizes 24 - 30 -less than 7-1/2 inches or more than 8 inches for sizes 32 - 46		X	
(5) Width of flap at widest point less than 2 inches or more than 2-1/2 inches			X
(6) Welt edge irregular or not uniform in width			X
(7) Ends of welt exposed more than 1/8 inch beyond side edges of flap		X	
(8) Facing not caught in raised stitching of flap	X		
(9) Width of welt less than 3/8 inch or more than 5/8 inch			X
(10) Edge of pocket opening stretched or gapped			X
(11) Depth of pocket at center -less than 8-7/8 inches but not less than 8-5/8 inches or more than 9-5/8 inches			X
(12) Pockets out of horizontal alignment by -more than 1/2 inch but not more than 3/4 inch -more than 3/4 inches	X	X	

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	Classification		
	Major	Minor	
		A	B
(13) Fastener tapes out of alignment causing a noticeable bulge or twist on flap or trousers affecting appearance		X	
(14) Corners of flaps caught in bartacks, restricting freedom of flap		X	
(15) Fastener tape off-center of flap by more than 1/4 inch		X	
(16) Fastener tape omitted		X	
6. CROTCH SEAM			
a. Raised stitching omitted		X	
b. Raised stitched with right fly overlapping left fly		X	
c. Stitched above fly bartack by -1/4 inch or more but not less than 3/8 inch -more than 3/8 inch		X	X
d. Improperly joined, i.e., causing exposure of right fly joining seam		X	
e. End of crotch seam not centered to end of seat seam by more than 3/8 inch		X	
7. SEAT SEAM			
a. Raised stitching omitted			
b. Raised stitched with right back overlapping left back			X
8. SEAT PATCHES			
a. Fullness, tightness, twisting, or pleats on patches or trousers in joining to seat, affecting appearance		X	
b. Top or lower edges of patch staggered at seat seam by 3/8 inch or more		X	
c. Poorly shaped, affecting appearance		X	
d. Joined with one row of stitching		X	

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		Classification	
		Minor	
Major		A	B
9.	BACK DARTS		
a.	Ends of darts not properly tapered, causing unsightly bulge or fullness		X
b.	Raise stitching omitted	X	
c.	Darts not in corresponding position by -more than 3/8 inch but not more than 5/8 inch -more than 5/8 inch	X	X
10.	BACK STRAPS		
a.	Ends of buckle or adjustment straps not caught in dart stitching or not securely bartacked at one or both ends		X
b.	Straps out of horizontal alignment by more than 1/2 inch	X	
c.	Free end of pointed strap placed on left back	X	
d.	Adjustment straps not of proper width, i.e., not allowing free movement through buckle	X	
e.	Buckle attached to strap with one row of stitching		X
11.	INSEAM AND SIDE SEAM		
a.	Raise stitching omitted on one or more seams	X	
b.	Raised stitched with fronts overlapping backs at side seam	X	
c.	Raised stitched with fronts overlapping backs at inseam	X	
12.	KNEE DARTS		
a.	Raise stitching omitted	X	
b.	Raise stitched with lower part overlapping on top of upper part		X
13.	KNEE PATCHES		
a.	Fullness, tightness, twisting, or pleats on patches or trousers in joining to front leg, affecting appearance	X	

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	Classification		
	Major	Minor	
		A	B
b. Poorly shaped, affecting appearance		X	
c. Joined with one row of stitching		X	
14. LEG OPENING			
a. Slider of fastener located at top of opening when fastener is closed		X	
b. Length of slide fastener less than 13-1/2 inches or more than 14-1/2 inches		X	
c. Protective fly extending less than 1/2 inch above top end of opening or extending beyond bottom end of opening or extending beyond bottom and of opening by more than 1/2 inch		X	
d. Row of quilting stitching omitted on protective fly		X	
e. Diagonal points of stitching more than 3-1/2 inches apart			X
f. Outer shell stitched to fastener opening with one row stitching		X	
g. Leg opening uneven in length at bottom when fastener is closed -more than 1/4 inch but not more than 3/8 inch -more than 3/8 inch		X	X
15. ANKLETS			
a. Badly twisted		X	
b. Uneven in width by more than 1/2 inch		X	
c. Raised stitching at bottom of trousers or on facing joining seam to knitted cuff omitted		X	
16. BATTEN INTERLINING			
a. Twisted, tight, or short, causing a noticeable bulge or twist on outside of trousers, affecting appearance		X	
b. Not stitched to the lining prior to joining outseams, inseams, crotch, and seat seams		X	

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## Classification

	Major	Minor	
		A	B
INSIDE OF TROUSERS			
17. HANGER			
a. Hanger less than 1/2 inch but not less than 3/8 inch wide			X
b. Hanger less than 3/8 inch wide		X	
c. Hanger placed less than 2 inches or more than 3 inches from top edge of trousers			X
d. Ends of hanger stitched with one row of stitching		X	
e. Hanger off-center with seat seam by more than 1/2 inch			X
f. Hanger less than 5 inches or more than 6 inches long			X
g. Hanger omitted or ends of hanger insecurely stitched		X	
18. LININGS			
a. Linings tight, short, or twisting causing fullness or twist, affecting appearance on outside of trousers		X	
b. Raised stitching omitted on one or both sides of back darts		X	
c. Raise stitching omitted on one or both sides of outseams or inseams		X	
d. Raised stitching omitted on one or both sides of seat or crotch seam		X	
e. Linings twisted, not affecting smoothness on outside of trousers			X

4.3.2.3 Finished measurement defects. Any finished measurement deviating from the finished measurements specified in Table V shall be classified as a finished measurement defect. Inseams uneven in length by 1/2 inch or more shall be classified as a finished measurement defect.

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4.3.2.4 Inspection levels and AQL. The inspection level for 4.3.2.1 and 4.3.2.2 (combined) shall be II of MIL-STD-105, and the inspection level for 4.3.2.3 shall be S-3 of the appendix of MIL-STD-105. The AQL for 4.3.2.1 and 4.3.2.2 shall be 2.5 dhu for major defects, 15.0 dhu for major and minor A (combined) defects, and 40.0 dhu for total major and minor A and B (combined) defects. The AQL for 4.3.2.3 shall be 4.0 dhu for defects (one class).

4.3.2.5 Examination of preparation for delivery requirements. An examination shall be made to determine if preservation and packaging, packing, and marking requirements of section 5 have been met. The sample unit shall be one shipping container that is fully prepared for delivery with the exception that it need not be sealed. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 of MIL-STD-105, and the AQL shall be 4.0 dhu. Shipping containers fully prepared for delivery shall be examined for defects of closure and shall be scored as follows:

EXAMINE	DEFECT
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.
Materials	Any component missing. Any component damaged, affecting serviceability.
Workmanship	Inadequate application of components, such as, incomplete closure of case liners, container flaps, loose strapping, and inadequate stapling. Bulging or distortion of containers.
Weight of content (exterior and interior)	Number of intermediate packages is more or less than required or gross or net weight exceeds requirement.

- \* 4.3.3 Tests. The method of testing shall be as specified in FED-STD-191, wherever applicable, and as listed in Table VI.

## 5. PACKAGING

5.1 Preservation and packaging

- \* 5.1.1 Level A. Each pair of trousers shall be folded to approximately 16 inches in width by 12 inches in length. Each pair of the folded trousers shall be placed in a box conforming to type CF, class - domestic, style RSC, grade 175 of PPP-B-636. The maximum outside dimensions of the box shall be 16 inches by 12 inches by 8 inches. The box shall be sealed with 2-inch-wide tape conforming to PPP-T-45.
- \* 5.1.1.1 Intermediate packaging. One pair of trousers packaged as specified in 5.1.1 shall be placed in a box conforming to type CF, class - domestic, style RSC, minimum bursting strength 175 pounds per square inch (psi) of PPP-B-636. The maximum outside dimensions of the box shall be 16 inches by 12 inches by 8 inches. The box shall be sealed with tape conforming to PPP-T-45.

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## 5.2 Packing.

5.2.1 Level A. Six pair of trousers of one size and type only, packaged as specified in 5.1, shall be packed in an exterior shipping container conforming to type CF or SF, class - weather-resistant, grade V3c or V3s, style RSC of PPP-B-636. Closure and strapping shall be in accordance with the appendix to the container specification. The inside dimensions of the container shall be 24 inches by 24 inches by 16 inches. Toward the end of the contract or when there are less than the quantity of the same size required per container, mixed sizes (see 5.3.1) may be packed within the same shipping container.

5.2.2 Level B. Six pair of trousers of one size and type only, packaged as specified in 5.1, shall be packed in an exterior container conforming to type CF or SF, class - domestic, style RSC, minimum bursting strength 275 psi of PPP-B-636. The inside dimensions of the container shall be 24 inches by 24 inches by 16 inches. Containers shall be sealed by applying a suitable adhesive (glue) throughout the entire area of contact between the flaps or by a combination of metal stitching the bottom flaps and sealing the top flaps with adhesive. Toward the end of the contract or when there are less than the quantity of the same size required per container, mixed sizes (see 5.3.1) may be packed within the same shipping container.

5.3 Marking. Intermediate and exterior shipping containers shall be marked in accordance with MIL-STD-129.

5.3.1 Mixed sizes. Each shipping container packed with mixed sizes (see 5.2.1 and 5.2.2) shall have white paper labels, 5 by 4 inches in size, securely attached to the end and side. The words "mixed sizes" shall be plainly printed on the labels. Under these words, the sizes and quantities of each size of trousers contained therein shall be legibly printed.

## 6. NOTES

6.1 Intended use. The trousers covered by this specification are intended for use in very cold temperature zones.

6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number, and date of this specification.
- b. When first article is required.
- c. Size required (see 1.1)
- d. Selection of applicable levels of preservation and packaging and packing.

6.3 USAF color shades. Samples of USAF color shades may be obtained from the procuring activity or as directed by the contracting officer.

6.4 Figures. Figures 2 and 3 indicate general appearance and are for information only.

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6.5 First article. When a first article sample is required, it shall be inspected and approved under the appropriate provisions of ASPR 7-104.55. The first article should be a preproduction sample and should consist of one pair of trousers. The contracting officer should include specific instructions in all procurement instruments, regarding arrangements for inspection and approval of the first article.

6.6 Reclaimed materials. The use of reclaimed materials shall be encouraged to the maximum extent possible.

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 MIL-T-83385 has been amended to remove the supersession of MIL-T-6284J(USAF). MIL-T-6284J(USAF), 17 December 1965, is reinstated and revised to MIL-J-6284K

Custodians:

Air Force - 99  
Army - GL

Preparing activity:

Air Force - 99

Review Activity:

Air Force - 45  
DLA - CT

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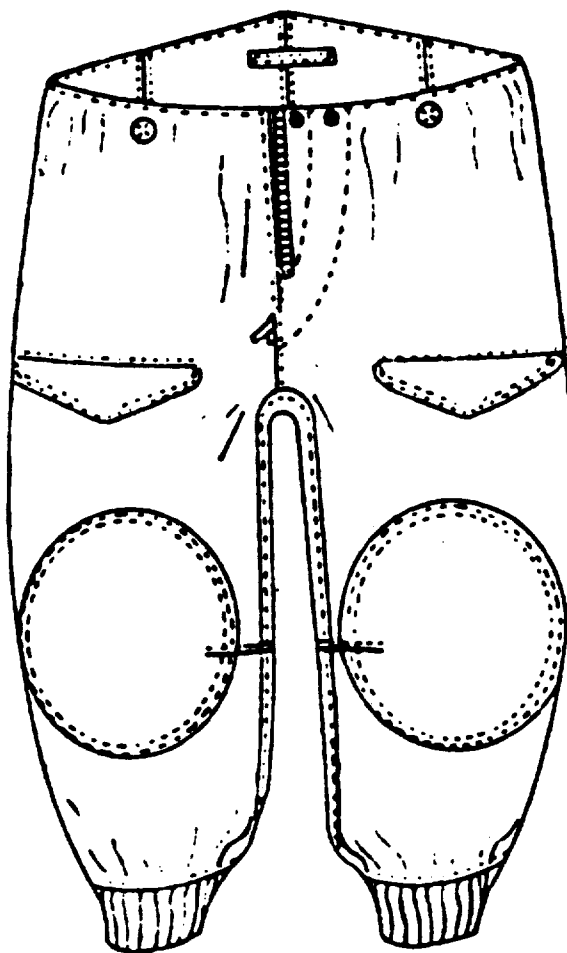


FIGURE 2. Trousers, Front View

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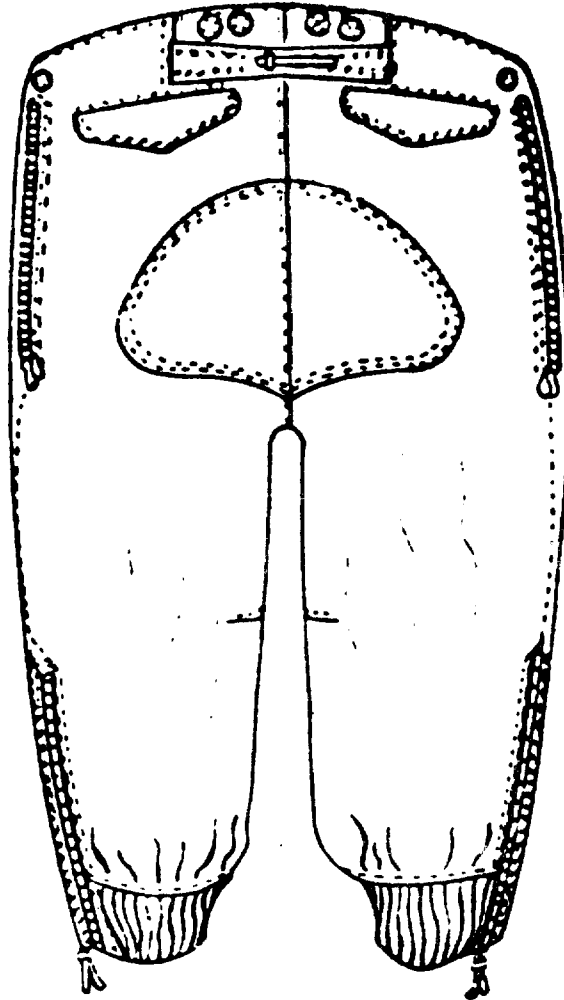


FIGURE 3. Trousers, Rear View

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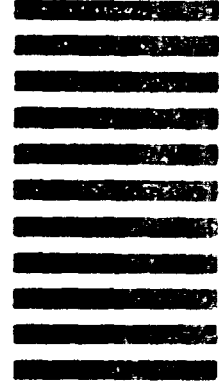
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