

MIL-T-87099
14 October 1987

MILITARY SPECIFICATION

TROUSERS, WET WEATHER

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 waterproof trousers, made of a double coated nylon twill cloth.

1.2 Classification. The trousers shall be of one type, and shall be procured in the following sizes as specified (see 6.2):

XX Small	- (20-22)
X Small	- (24-26)
Small	- (28-30)
Medium	- (32-34)
Large	- (36-38)
X-Large	- (40-42)

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.

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/NA

FSC 8405

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SPECIFICATIONS

FEDERAL

- V-T-295 - Thread, Nylon
- NN-P-71 - Pallet, Material Handling, Wood, Stringer Construction, 2 Way and 4 Way (Partial)
- JJ-W-155 - Webbing, Textile, (Cotton, Elastic)
- DDD-L-20 - Label; For Clothing, Equipage, and Tentage (General Use)

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- MIL-B-286 - Button, Tack; and Tack, Button
- MIL-F-495 - Finish, Chemical, Black (For Copper Alloys)
- MIL-W-5664 - Webbing, Textile, Elastic, Cotton
- MIL-P-15011 - Pallet, Material Handling, Wood, Post Construction, 4 Way Entry
- MIL-B-17757 - Boxes, Shipping, Fiberboard (Modular Sizes)
- MIL-C-19759 - Cloth, Coated, Twill, Nylon (Low Count)
- MIL-F-21840 - Fastener Tapes, Hook and Pile, Synthetic

STANDARDS

FEDERAL

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

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- 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

(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).

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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 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).

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).

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

3. REQUIREMENTS

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

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

3.3 Material.

3.3.1 Basic material. The basic material for the trousers shall be a chloroprene coated nylon twill conforming to Type II of MIL-C-19759, except that the coating shall be unvulcanized. The cloth shall be tested as specified in 4.4.1.

3.3.2 Buttons and tacks. The buttons and tacks for suspender attachment shall conform to the requirements specified in MIL-B-286. The buttons shall be of Type I, 27 line, and the tacks shall be of Type IX, 14 line by 0.406 inch prong length.

3.3.3 Cement, chloroprene. The cementing compound shall have a chloroprene base and the same curing characteristics as the coating compound specified in 3.3.1. The use of reclaimed rubber is prohibited (see 4.4.1). Cemented sample seams shall have a minimum adhesion of 5 pounds per inch width when tested as specified in 4.4.1. The color of the cement shall approximate the

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shade of the green coating compound specified in 3.3.1 or shall be unpigmented.

3.3.4 Thread, nylon. The nylon thread used for all seaming and stitching shall conform to Type III, Size B or E, of V-T-295, except that the colorfastness requirements shall not apply. The color shall approximate the green shade of the basic material.

3.3.5 Fastener tapes. The fastener tapes shall conform to Type II, Class 3 or 5, of MIL-F-21840. Unless otherwise specified, the tapes shall be 1 inch in width. The color shall be Green 3422.

3.3.6 Buckles, suspender. The buckles shall be made of brass and shall be chemically finished black conforming to the requirements of MIL-F-495. The shape and dimensions of the suspender buckles shall be as shown in Figure 2.

3.3.7 Suspender webbing. The webbing shall be 1 1/2 inch wide cotton elastic conforming to Class 2, of MIL-W-5664. The color shall be black, white or natural or shall approximate the green shade of the basic material.

3.3.8 Webbing, elastic. The elastic webbing for the trouser waist shall conform to Type I, Class 3 or 4, of JJ-W-155. Class 4 webbing shall be black. Class 3 webbing shall be unbleached, bleached, or dyed any shade.

3.3.9 Bias tape. The bias tape used as stay stripping or seam strapping shall be any suitable plain woven fabric, weighing not less than 2.5 oz. per square yard (see 4.4.1). The cloth shall be dyed to harmonize with the shade of the back side of the basic cloth and bias cut to the width required (see Table I). Any continuous length used for the construction of the trousers shall contain not more than two seams. As an alternate, the basic material specified in 3.3.1 may be used. When basic material is used, any continuous length shall not be spliced or seamed.

3.3.10 Combination label. A combination identification, size, and instruction label, conforming to Type IV, Classes 12 and 13, of DDD-L-20, shall be printed on a suitable sized piece of unvulcanized basic material or may be marked directly on the trousers. All markings shall be bright yellow in color. The inscription shall be as follows:

TROUSERS, WET WEATHER
 CONTRACT NO. DLA-100-00-0-0000 (EXAMPLE)
 STOCK NO. 8405-00-000-0000 (EXAMPLE)
 SIZE: MEDIUM (32-34) (EXAMPLE)
 NAME OF CONTRACTOR

INSTRUCTIONS

THESE WATERPROOF TROUSERS HAVE BEEN OVERSIZED
 TO FIT OVER HEAVY CLOTHING FOR USE UNDER COLD/
 WET WEATHER CONDITIONS. IF TOO LARGE WHEN WORN
 OVER LIGHT CLOTHING, USE A SMALLER SIZE.

RINSE GARMENT WITH A HOSE OR SPONGE USING FRESH WATER
 AFTER EVERY USE

DO NOT DRY CLEAN.

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3.3.11 Dusting medium. The dust used in fabricating both the basic material and trousers, shall be applied in the smallest quantity necessary to prevent blocking. The dust shall consist of a finely powdered mineral material such as talc, except that the addition of zinc stearate to the medium is permissible in an amount that will not support mildew growth on the finished vulcanized trousers (see 4.4.1).

3.4 Design. The trousers shall be of an elastized, high-waisted style, with cemented and vulcanized inseams and crotch seams, patch pockets and hemmed leg bottoms. The ends of the adjustable elastic suspenders shall be stitched to the back of the trousers. The slide loop buckles shall fasten to the buttons positioned on each side of the trouser front. The two back patch pockets with flaps shall fasten with hook and pile tape closures. Hook and pile fastener tape tabs shall be provided at leg bottoms for take-up.

3.4.1 Figures. Figures 1 through 5 are furnished for information purposes only. When inconsistencies exist between the written specification and the figures, the written specification shall govern.

3.5 Patterns. Standard patterns will be furnished by the Government. The standard patterns shall not be altered in any way and are to be used for cutting the contractor's working patterns. The working patterns shall be identical to the standard patterns.

3.5.1 Pattern parts. The component parts shall be cut from the material specified, and in accordance with the following pattern parts:

Material	Pattern Parts	Cut parts
Cloth coated, nylon twill	Front and Back	2
	Pocket	2
	Ankle Tab	2
Templates	Pocket cement marker	-

3.6 Construction.

3.6.1 Sewn seams. Stitch and seam types specified in Table I shall conform to FED-STD-751. Seam allowances shall be maintained with seams properly sewn so that no raw edges, runoffs, twists, pleats, or open seams will result. Thread breaks shall be secured by starting the repair stitch not less than 1/2 inch in back of the break. Skipped stitches shall be repaired using 301 stitch type. The minimum and maximum number of stitches per inch shall be as specified in Table I.

3.6.2 Cemented seams and parts. Prior to joining of precemented and dusted parts, the surfaces to be joined shall be washed and reactivated with a suitable solvent. Care shall be exercised in performing this operation to avoid solvent staining of adjacent surfaces. Unless otherwise specified in Table I, all LSa type cemented seams shall overlap 1/2 to 3/4 inch. The width of the cemented area (cement margin) for seams before joining shall be a maximum of 7/8 inch per single ply of material. The cement line after seams are joined shall be visible but no wider than 3/8 inch on the outside and 3/8 inch on the underside. Whenever possible, cementing shall be performed by

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shingling or with the aid of templates to insure that the cement lines are even, uniform, and within specified tolerances. Cemented parts such as the pocket and reinforcement patches shall show a cement line no wider than 3/8 inch around all outer edges. All cemented seams and parts shall be rolled to remove any puckers, tunnels, or wrinkles and shall be dusted in accordance with 3.3.11. Cemented seam types specified in Table I, are similar to the seam types specified in FED-STD-751 minus the stitchline.

3.6.3 Dusting visible cement lines. Before vulcanization, visible cement lines along edges of seams and parts shall be dusted with the minimum amount of dusting medium necessary to prevent adhesion of uncured coated fabric and cemented surfaces. Care shall be taken to insure only the cemented areas are dusted (see 3.3.11).

3.6.4 Vulcanization. The trousers shall be vulcanized in accordance with the time and temperature requirements supplied by the coated fabric manufacturer which shall result in seams meeting the requirements of 3.9 when tested as specified in 4.5.

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

3.7.1 Shade and size marking. The component parts shall be marked, ticketed, or banded to insure a uniform shade and size throughout the trousers, except parts which may be cut from ends. Any method may be used except:

1. Metal fastening devices
2. Sew-on tickets
3. Adhesive type tickets whose adhesive causes discoloration or whose adhesive mass adheres to the material upon removal of the tickets.

The use of a rubber stamp, ink pad numbering machine, or pencil is acceptable provided the numbers are legible and are not visible on the outside of the trousers.

3.7.2 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
Comrc1	-	Commercial
smlr	-	similar
Btnh1	-	Buttonhole
incl	-	including
dbl	-	double
bx stch	-	box stitch

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
1.	<u>Cutting</u>				
	<p>a. The trousers shall be cut in strict accordance with patterns furnished, which show size, shape, directional lines for cutting, and notches for proper assembly of all parts. The use of devices such as staples, pins, etc., to hold the working patterns on the basic material during cutting is not permitted.</p>				
	<p>b. All basic fabric component parts shall be cut from one piece of material except the labels, reinforcement patches (strapping) and stay stripping which may be cut from ends. Stay stripping, when cut from basic cloth shall not be spliced or seamed.</p>				
	<p>c. The use of a drill hole is permitted only when the hole is located in an area where it will be covered in a later operation by the cement portion of a cemented component part.</p>				
	<p>d. All other trimmings shall be cut in accordance with the pattern or in accordance with the description of operation when no pattern is furnished.</p>				
	<p>e. The lightly coated (green) side of the basic material shall finish on the outside of the trousers.</p>				
	<p>f. Patches of basic material or bias tape (see 3.3.9) of sufficient size shall be cemented to the underside of the trousers to reinforce and seal each area of stitching as indicated herein. Cement (see 3.3.3) shall be applied to the stitched area and to the reinforcement material. When basic material is used for reinforcement, the green side of the material shall be affixed to the trousers. When bias tape is used, either side may be affixed to the trousers.</p>				
	<p>g. Splicing of hook and pile tape is not permitted.</p>				

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL BOB/ LPR	
2.	<u>Replacement of defective components.</u> During the spreading, cutting, and manufacturing process, components having material defects or damages that are classified as defects in Section 4, shall be removed from production and replaced with non-defective and properly matched components.					
3.	<u>Shade and size marking</u> All parts shall be marked, ticketed, or bundled in accordance with 3.7.1. When parts are cut from ends, the parts shall closely match the major component parts of the trousers.					
4.	<u>Assemble and attach ankle tabs and take-up tape (see Figure 4).</u>					
	a. Cement entire back of each tab. Fold edges in half in accordance with pattern marks and roll flat. The finished dimensions of the tabs shall be 3 1/8 to 3 1/4 inches X 7/8 to 1 inch.		OSf			
	b. Stitch a 1 1/4 to 1 3/8 inch length of 1 inch hook fastener tape to one end of the tab around all sides, 1/16 to 1/8 inch from edges.	301	LSbj-1	8-10	B or E	B or E
	or					
	c. As an alternate, the hook tape may be stitched to the tab prior to cementing and folding.	301	LSbj-1	8-10	B or E	B or E
	d. Apply a 1 1/4 to 1 3/8 inch length of 1 inch pile fastener tape to the front of each trouser leg, as indicated by marks on pattern for tab placement and stitch around all sides, 1/16 to 1/8 inch from edges.	301	LSbj-1	8-10	B or E	B or E
	e. Align hook portion of tab onto pile portion so that the tab is parallel to the trouser bottom and the free end faces toward the inseam. Boxstitch free end of tab to trouser leg, 1/16 to 1/8 inch from the three free edges and the inner hook tape stitch line.	301	bx stch	8-10	B or E	B or E

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	f. Position a 6 1/4 to 6 3/8 inch length of 1 inch pile fastener tape on to each leg in accordance with pattern marks. Stitch around all sides, 1/16 to 1/8 inch from edges.	301	LSbj-1	8-10	B or E	B or E
	g. Cut pieces of basic material or bias tape (see 3.3.9) and cement solid to the inside of the trousers to reinforce and seal each area of stitching produced by operations 4d. through 4f.					
5.	<u>Assemble pockets (see Figure 5).</u>					
	a. Attach two 1 1/4 to 1 3/8 inch lengths of 1 inch pile fastener tape to top portion of pockets, each positioned 1/2 (+ 1/16) inch below the top set of pattern marks and 3/4 (+ 1/16) inch from edges by box stitching around all sides, 1/16 to 1/8 inch from each edge.	301	bx stch	8-10	B or E	B or E
	b. Stitch two 1 1/4 to 1 3/8 inch lengths of hook fastener tape in the same manner as described in 5a., to the mid portion of pockets, each positioned 1 1/2 (+ 1/16) inches below lower set of pattern marks and 3/4 (+ 1/16) inch from each edge.	301	bx stch	8-10	B or E	B or E
	c. Cement all around the back of the pocket from the outside edge to 1/2 to 5/8 inch from edge. Cement an area 1 1/2 to 1 5/8 inches wide between the top set of pattern marks 3/4 (+ 1/16) inch above marks and 3/4 (+ 1/16) inch below).					
	d. Cement and affix a 7/8 to 1 inch by 8 1/2 to 8 5/8 inch strip of reinforcing material (cut from basic material or bias tape) over area marked for pocket opening. Puncture at ends of pocket opening, as indicated by marks on pattern, with 1/8 inch diameter holes. Slash between dots through both plies.					

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	e. Fold cemented area of pocket together along top set of pattern marks to form flap. Fold the bottom portion of pocket in the opposite direction along the lower marks. The hook and pile tapes shall line up in the finished pocket assembly. The edges and folded area forming the flap shall be securely cemented together, with the back of the topmost portion of the flap free to be attached to the trousers.		OSf		
6.	<p data-bbox="106 721 584 749"><u>Attach pockets (see Figure 5).</u></p> <p data-bbox="106 753 839 939">a. Make a reusable rigid template for each pocket, of the same configuration as the pocket piece with $3/8$ ($+ 1/16$) inch removed from around the side and bottom edges. The top of the template shall finish at the lower set of pocket pattern marks.</p> <p data-bbox="106 975 839 1161">b. Apply cement to both outside surfaces of a length of V-stay strip (1 strip per pocket template; see 3.3.9). The V-stay strips shall consist of a $7/8$ to 1 inch width of bias tape or basic material folded in half lengthwise and permanently creased.</p> <p data-bbox="106 1197 839 1342">c. Encase the side and bottom of the templates described in 6a. with the inside surfaces of the V-stay strips. Ends of the V-stay strips shall extend $1/4$ to $3/8$ inch beyond the top of the templates.</p> <p data-bbox="106 1378 839 1471">d. Apply cement to the trouser fronts by means of the cement marker template in the areas where pockets are to be affixed.</p> <p data-bbox="106 1507 839 1719">e. Position the templates prepared as specified in 6c. onto the trousers so that the top of the templates are even with the pocket placement marks on the trousers. The templates shall be cemented so that the cemented areas on the trousers are of even width around the outside of the templates.</p>		OSf		

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	f. Activate the cement applied in operation 5c. around the back of the pocket assemblies with an appropriate solvent. Place each pocket assembly over the respective template and secure pocket sides and bottoms to the trousers and V-stay strips in accordance with pattern marks. The tops of the pocket assemblies shall be left free.				
	g. Remove templates, leaving the V-stay strips in place and affix the tops of the pocket assemblies to the trousers.				LSbj
7. <u>Join inseams and crotch seams.</u>	a. Seams shall be cemented in the following manner (see Figure 4 and 3.6.3).				
	1. Apply cement over a 3/4 to 7/8 inch width along each surface to be joined. Cement may be allowed to dry and be dusted and reactivated with an appropriate solvent before the seam is joined.				
	2. Cemented face and back surfaces shall be joined by overlapping in the specified direction 1/2 to 3/4 inch. The cemented areas shall extend 1/4 to 3/8 inch beyond the lapped edge of the seam on both the front and back of the garment.				
	3. Roll seam flat. There shall be no puckers, pleats or areas of poor adhesion.				
	b. Join crotch seams from top of waist to crotch, lapping left over right for both front and back.				LSa
	c. Join inseams, lapping front over back, matching crotch seams and leg bottoms.				LSa
8. <u>Hem trousers.</u>	a. Apply cement from edge of each leg bottom to 1 1/4 to 1 1/2 inches in from edge on the inside of trousers.				
	b. Fold under leg bottom 1/2 to 3/4 inch to form a hem. Roll flat to ensure adhesion.				EFa

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	c. As an alternate, trouser hems may be folded under 1/2 to 3/4 inch and stitched close to the raw edge.	301	EFa-1	8-10	B or E	B or E
9.	<u>Label (see 3.3.10).</u> Cement the combination identification - size - instruction label or print label inscription directly on inside of trousers, 4 to 4 1/8 inches below the top edge and 1 to 1 1/8 inches from the center back seam on the right side of the trousers.		LSbj			
10.	<u>Finish top of trousers.</u>					
	a. The webbing for the suspender straps (see 3.3.7) shall be 41 1/2 (+ 1/4) inches long for sizes XXS and XS and 43 1/2 (+ 1/4) inches long for sizes S through XL. Bias cut one end of the strap (approximately 45° angle) and gum the ends with cement (see 3.3.3) to prevent raveling.					
	b. Cross the suspender straps (left over right) at a distance of 7 1/2 (+ 1/2, - 0) inches from the uncut ends of the straps. Stitch together with a diamond stitch (see Figure 3). The outer row of stitching shall be 1/8 (+ 1/32) inch from the edges of webbing.	301	SSa-1	6-8	B or E	B or E
	c. Reinforce the top and bottom ends of the diamond stitch with horizontal bartacks (see Figure 3).	301	Brtck	21-28 stchs/ Brtck	B or E	B or E
	d. Fold top of trousers to inside, 1 to 1 1/4 inches from the edge, placing the uncut ends of the suspender straps within the fold where indicated by pattern marks on each side of center back. Stitch around top of trousers within 1/4 inch of raw edge, catching the suspender straps securely in the stitching.	301	SSbc-1	8-10	B or E	B or E

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD	
					NDL	BOB/ LPR
	e. Turn straps up to their finished positions against the folded portion of trouser top. Secure suspenders to back of trousers with a 1 1/4 inch wide by 3/4 inch high boxstitch. The top row of box-stitching shall finish 1/8 to 3/16 inch from the top folded edge of trousers.	301	bx stch	8-10	B or E	B or E
	f. Elastic for the waist (see 3.3.8) shall be cut in the following relaxed lengths: (+ 1 inch tolerance). XXS - 17 inches M - 25 inches XS - 19 inches L - 29 inches S - 21 inches XL- 33 inches					
	g. Stitch the appropriate length of 3/4 inch wide elastic webbing around the waist with two rows of stitching, starting and ending at the center back seam, positioning the lower edge of the webbing at the waistline as indicated by pattern marks. The top edge of the webbing shall finish 1/4 to 3/8 inch below the raw edge of the turned trouser top. The two rows of stitching shall finish 1/16 to 1/8 inch from each edge of the elastic braid. The braid shall be stretched during stitching to distribute the trouser fullness evenly when the elastic is allowed to relax. The ends of the elastic braid shall overlap 3/8 to 5/8 inch at center back and the stitching shall extend a minimum of 1/2 inch beyond the overlapping braid.	301	LSbj-2	8-10	B or E	B or E
	h. Secure the suspender buttons (see 3.3.2) to the left and right trouser fronts as indicated by pattern marks.					
11.	<u>Vulcanization.</u> a. The assembled trousers shall be fully heat cured or pressure vulcanized for the appropriate length of time at the recommended temperature to produce a properly vulcanized garment.					

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TABLE I - CONSTRUCTION OF TROUSERS

NO.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH IN	THREAD NDL BOB/ LPR
	b. Thread bias cut ends of suspender straps through buckles (see 3.3.6) and fasten buckles to buttons.				
	CAUTION: This operation shall not be performed prior to vulcanization.				
12.	<u>Cleaning.</u>				
	a. Trim all thread ends to less than 1/2 inch.				
	b. Clean all removable spots, stains, dusting medium, and shade and size markings on outside of trousers, taking care not to damage coating in the process.				

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3.8 Measurements. The finished trousers shall conform to the dimensions as specified in Table II. All measurements and tolerances are expressed in inches and shall be taken with the trousers laid smooth and flat.

Table II - Finished measurements

Measurement	Size						Tolerance
	XX Small (20-22)	X Small (24-26)	Small (28-30)	Medium (32-34)	Large (36-38)	X Large (40-42)	
Waist (A)	30	34	38	42	46	50	+ 1 1/2
Length (B)	42 3/4	44	45 1/4	46 1/2	47 3/4	49	+ 1
Inseam (C)	27 1/4	27 7/8	28 1/2	29 1/8	29 3/4	30 3/8	+ 1/2

NOTE: A, B, and C refer to Figure 1.

A. Twice the measurement taken across the waist, folded edge to folded edge, with the elastic fully extended.

B. Measurement shall be taken from top of the finished trouser along the outside to the bottom of the hemmed leg.

C. Measurement shall be taken from crotch seam, to bottom of hemmed right leg.

3.9 End item performance testing. The vulcanized cemented seams shall conform to the requirements specified in Table III when tested as specified in 4.5. The requirements specified do not refer to stitched or strapped seams.

Table III - Requirements for cemented seams in end item

Characteristic	Requirement	
	Average (min.)	Individual (min.)
Seam strength, lbs	150	100
Seam adhesion, lbs/1 inch width	5.0	4.0
Hydrostatic resistance, lbs/sq inch		
Initial	100	50
After 1 dry cleaning	80	50
After 3 launderings	80	50

3.10 Coating repairs on trousers.

3.10.1 Black coated side (inside). Pinholes and uncoated areas of any type shall be repaired either before or after curing the assembled trousers with the black coating compound specified in 3.3.1. When trousers are repaired after curing, the repair compound shall be formulated to cure at room temperature. The size of the inside repair shall not exceed 3/4 inch in length or width. The number of repairs allowed per pair of trousers on the black coated side shall not exceed four. The repairable area shall be coated with a minimum of two coats of the repair compound. The first coat shall completely wet out the defective area and shall be thoroughly worked into the surface. The second coat shall be spread on smoothly and evenly over the

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first coating. After the compound is dry, the repaired area shall be lightly dusted with the dusting powder specified in 3.3.11. When fully cured, there shall be no lifting of the edges; cracking, flaking, or removal of the repair compound from the inside repaired area when subjected to a flexing action between the hands.

3.10.2 Green coated side (outside). Any area where the nylon base fabric is exposed, shall be touched up (hidden) before or after curing with a suitably thinned solution of the green coating compound specified in 3.3.1. When trousers are repaired after vulcanization, the touch-up solution shall be formulated to cure at room temperature. The size of the repair shall not exceed 3/4 inch in length or width. Only the minimum amount of solution necessary to hide the uncoated area shall be applied. The number of repairs allowed per pair of trousers on the green coated side, shall not exceed two. The color of the repaired areas shall be a good match to the surrounding coating.

3.11 Workmanship. The finished trousers shall conform to the quality established by this specification. The occurrence of defects shall not exceed the applicable acceptable quality levels.

4. QUALITY ASSURANCE PROVISIONS

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

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

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

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

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

4.3 First article inspection. When required, the first article submitted

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in accordance with 3.2 and 4.3 shall be inspected as specified for compliance with design, construction, workmanship, and dimensional requirements.

4.4 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated.

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. A certificate of compliance shall be furnished for the chloroprene cement coating requirements of 3.3.1, the material identification of the chloroprene cement (see 3.3.3), the reclaimed rubber requirements of 3.3.3, the bias tape weight requirements of 3.3.9 and for the dusting medium characteristics specified in 3.3.11. In addition, components and materials listed in Table IV shall be tested for the characteristics specified and in accordance with FED-STD-191 whenever applicable. All test reports shall contain the individual values utilized in expressing the final result. For the cloth, coated, nylon twill (vulcanized), the lot size shall be expressed in yards and the sample size shall be 3 continuous yards full width. The sample size shall be as follows:

<u>Lot size (yards)</u>	<u>Sample size</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

The lot shall be unacceptable if one or more units fail to meet any requirement specified.

Table IV - Instructions for component testing

<u>Component</u>	<u>Characteristics</u>	<u>Requirement paragraph</u>	<u>Test Method</u>
Cloth, coated, nylon twill (vulcanized)	Blocking	3.3.1	<u>1/</u>
	Breaking strength	3.3.1	<u>1/</u>
	Weight	3.3.1	<u>1/</u>
	Tear strength	3.3.1	<u>1/</u>
	Hydrostatic resistance	3.3.1	<u>1/</u>
	Flex stiffness	3.3.1	<u>1/</u>
	Adhesion of coating	3.3.1	<u>1/</u>
	Resistance to heat	3.3.1	<u>1/</u>
	Cement, chloroprene	Seam adhesion	3.3.3

1/ Three yards of unvulcanized cloth shall be cured under conditions used on the end item and shall be tested to meet the requirements specified in paragraph 3.3.3.4 of MIL-C-19759 for Type II vulcanized cloth.

2/ Cemented seam specimens shall be prepared in accordance with 3.6.2 and Table I, operation 7a., except that the seam shall overlap 1-1/4 inches.

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After vulcanization, a 1 inch wide by 6 inch long strip shall be marked and cut from the overlapped seam in the length direction.

4.4.2 Examination of the end item. Examination of the end item shall be in accordance with 4.4.2.1 and 4.4.2.2. The applicable inspection levels and acceptable quality levels (AQL's) shall be as indicated in 4.4.2.3. The sample unit shall be one finished pair of trousers. The lot size shall be expressed in units of trousers.

4.4.2.1 Visual examination. The trousers shall be examined for defects classified in accordance with the list below.

Defect	Classification	
	Major	Minor
I <u>Material Defect(s) or Damage(s)</u>		
A. <u>Cloth, coated, nylon</u>		
1. Any hole, cut, tear, pinhole, uncovered drill hole, blister or burn	X	
2. Any lump or imbedded foreign matter	X	
3. Any weak or thin area	X	
4. Permanent crease or wrinkle	X	
5. Any pickoff or uncoated area	X	
6. Any tackiness	X	
7. Coating soft, i.e., not fully cured	X	
8. Any brittle area, i.e., coating cracks when bent	X	
9. Abraded or scuffed, resulting in a weak place or coating removal	X	
10. Any patched or stitched mend	X	
11. Any objectionable odor other than that which is characteristic of the coating compound		X
II <u>Cleanness</u>		
1. Any permanent spot, stain (except solvent), streak, or assembly marking on any outside portion of the trousers which would be visible when worn		
- Up to 1/2 inch inclusive in diameter or length		X
- More than 1/2 inch in diameter or length	X	
2. Any size, permanent spot, stain (except solvent), streak, or assembly marking not visible on outside when trousers are worn		X
3. Two or more removable spots, stains, streaks, or assembly markings on outside of trousers		X
4. Six or more thread ends not trimmed to less than 1/2 inch		X
5. Cement on any area other than where specified		X
6. Excessive dusting powder distributed over outside		X

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Defect	Classification	
	Major	Minor
7. Excessive solvent staining on outside		X
<u>III Components and Assembly (unless otherwise classified)</u>		
1. Any component part omitted, misplaced, damaged, or otherwise defective	X	
2. Any required operation omitted	X	
3. Any required operation not as specified		X
4. Any component part not as specified, (type, size, color, etc)	X	
<u>IV Cutting</u>		
- Any part not cut in accordance with directional lines indicated on patterns or not in accordance with specification requirements	X	
<u>V Shaded part(s)</u>		
- Variation in shade within or between outside parts (except those parts which may be cut from ends)		X
<u>VI Repaired area(s)</u>		
1. Repair compound on coated fabric cracks, i.e., lifts off or flakes when coated fabric is flexed between the hands	X	
2. Repair compound not smoothly or evenly applied		X
3. Repair compound does not cover defective area		X
4. Repaired area not dusted		X
5. Size of repair more than 3/4 inch in length or width		X
6. Repaired areas number more than four (4) on black side or more than two (2) on green side		X
7. Color of repaired area on green side not good color match		X
<u>VII Seams and Stitchings</u>		
<u>A. General</u>		
1. Any seam twisted, puckered, or pleated	X	
2. Any part of garment caught in an unrelated cementing or stitching operation	X	
<u>B. Cemented seams, patches, and strapping</u>		
1. Poorly rolled forming:		
a. An open tunnel		

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Defect	Classification	
	Major	Minor
(1) Extending up to 1/2 the width of the seam, patch, or strapping		X
(2) Extending for more than 1/2 the width of seam, patch, or strapping	X	
b. A permanent pucker, wrinkle, fold, or closed tunnel		X
2. Seam overlapped less than 1/2 inch or more than 3/4 inch		X
3. Direction of seam lap other than specified		X
4. Any loose or unaffixed edge (except reinforcement patches) with a:		
a. Length:		
(1) Up to 1/4 inch inclusive		X
(2) More than 1/4 inch	X	
b. Depth:		
(1) Up to 1/8 inch inclusive		X
(2) More than 1/8 inch	X	
5. Dusting powder omitted or improperly applied causing adhesion between two surfaces	X	
6. Visible cement line more than 3/8 inch in width for more than 1/2 the length of seam		X
7. Excessive cement resulting in adhesion of surfaces that were not required to be cemented	X	
8. Reinforcement patch edge loose or unaffixed by more than 1/4 inch		X
9. No visible cement line along more than 1/2 the length of the seam or patch		X
10. Seam not strapped as specified	X	
C. <u>Stitched seams</u>		
1. Stitching margin not as specified		X
2. Ends not securely tacked		X
3. Any open seam (see note)		
a. -1/4 to 1/2 inch inclusive		X

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Defect	Classification	
	Major	Minor
b. -more than 1/2 inch	X	
NOTE: One or more broken stitches or two or more continuous skipped or runoff stitches constitute an open seam.		
4. Loose tension resulting in a loosely secured seam		X
5. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching.)	X	
D. <u>Stitches per inch</u> (score only when condition exists on more than 1/2 the length of seam)		
1. One stitch less than the minimum or any number in excess of the maximum specified		X
2. Two or more stitches less than the minimum specified	X	
E. <u>Seam and stitch types</u>		
1. Not as specified	X	
2. Any line of stitching not beginning or not ending where specified		X
3. Any required line of stitching omitted	X	
VIII <u>Hems</u>		
1. Puckered, twisted, or pleated		X
2. Irregular in width by 1/4 inch or more		X
3. Width of hem on leg bottom less than 1/2 inch	X	
4. Width of hem on leg bottom more than 3/4 inch		X
IX <u>Buttons</u>		
1. One or both omitted, broken, or otherwise defective	X	
2. One or both misplaced, loose, not positioned or attached as specified		X
X <u>Ankle tab(s) and take-up tape assemblies</u>		
1. Any part omitted or insecurely attached	X	
2. Any part misplaced or distorted:		
a. Not serving intended purpose	X	

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Defect	Classification	
	Major	Minor
b. Serving intended purpose		X
3. Ankle tab or take-up tape assembly with a loose or unaffixed edge:		
a. Up to 1/4 inch inclusive in length or depth		X
b. More than 1/4 inch in length or depth	X	
XI <u>Suspender straps</u>		
1. Omitted or misplaced	X	
2. Not attached as specified	X	
3. Straight end of one or both straps insecurely attached to back of trousers	X	
4. Free end of one or both straps not cut on a bias		X
5. Free end of one or both straps not cement dipped, as evidenced by raveling		X
6. Finished length of one or both straps less than 41 1/4 inches or more than 41 3/4 inches for sizes XXS and XS and less than 43 1/4 inches or more than 43 3/4 inches for sizes S through XL, when measured from the top edge of trouser hem to top edge of free end (measurement to be taken prior to threading of free end through buckle)		X
XII <u>Pockets</u>		
1. Set on crookedly or poorly shaped	X	
2. V-stay strip omitted or misplaced	X	
3. Bias tape V-stay strip (when applicable) contains more than 2 seams		X ₁
4. Basic cloth V-stay strip (when applicable) spliced or seamed		X
5. Incorrect size, design or configuration		X
6. Irregular in width by 1/4 inch or more		X
XIII <u>Top of Trousers</u>		
1. Elastic positioned improperly		X

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Defect	Classification	
	Major	Minor
2. Trouser fullness distributed unevenly under elastic		X
3. Elastic more than 1 inch longer than required		X
4. Elastic more than 1 inch shorter than required	X	
5. Trouser top turned under less than 1 inch	X	
6. Trouser top turned under more than 1 1/4 inch		X
XIV <u>Eyelets, Grommets and Hooks.</u>		
1. Any omitted	X	
2. Any misplaced, not positioned or attached as specified		X
3. Finish omitted or not type specified		X
4. Any broken or malformed	X	
5. Any having a sharp or rough edge		X
6. Clinched		
a. Tightly, damaging or cutting adjacent material	X	
b. Loosely, permitting any component to rotate freely, but not to the degree that any component can be expected to become detached during use		X
c. Loosely, to the degree that any component can be expected to become detached during use	X	
XV <u>Label</u>		
1. Missing, incorrect, or illegible	X	
2. Misplaced		X
3. Not cemented (when applicable)		X
XVI <u>Fastener Tape(s) (hook and pile)</u>		
1. Omitted		X
2. Misplaced or not positioned as specified, i.e., not serving intended purpose	X	
3. Type, color or width not as specified		X
4. Stitched too close or too tight causing noticeable puckering or twist on outside	X	

4.4.2.2 Dimensional examination. The trousers shall be examined for defects in dimensions in accordance with the following:

a. Any measurement deviating from nominal dimensions and tolerances as specified in Table II, shall be scored as a size measurement defect.

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b. Leg inseam lengths unequal in length by 1/2 inch or more, shall be scored as a size measurement defect.

4.4.2.3 Inspection levels and acceptable quality levels (AQL's). The inspection levels and the acceptable quality levels, expressed in defects per 100 units for visual and dimensional examination, shall be as follows:

	Inspection level	AQL's	
		Major	Total
For defects applicable to 4.4.2.1	II	2.5	15.0
For defects applicable to 4.4.2.2	S-3	-	4.0

4.4.3 Examination of packaging requirements. An examination shall be made to determine that packaging, packing, and marking complies with the 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 except 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 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 100 units.

<u>Examine</u>	<u>Defects</u>
Marking (exterior and interior)	Omitted, incorrect, illegible, of improper size location, sequence or method of application
Materials	Any component missing, damaged, or not as specified
Workmanship	Inadequate application of components, such as incomplete closure of container flaps, improper taping, loose strapping, inadequate stapling, bulging or distortion of container, open and noncontinuous heat sealed seams of polyethylene bag, or incorrectly fabricated bag.
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. <u>1/</u>

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

4.5 Testing of the end item. The methods of testing specified in FED-STD-191 whenever applicable and as listed in Table V, shall be followed. Tests shall be conducted on cemented seams cut from three finished pairs of trousers randomly selected for each assembled shipping lot. Failure of any of the specimens tested to meet either the individual or average test requirements shall be cause for rejection of the lot. Test reports shall contain the individual test values.

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Table V - End item testing of cemented seams

Characteristic	Requirement paragraph	Test method	Number of tests per garment
Seam strength, initial	3.9	5100 <u>1/</u>	4
Seam adhesion, initial	3.9	5960 <u>2/</u>	3
Hydrostatic			
Initial	3.9	5512 <u>3/</u>	2
After 1 dry cleaning	3.9	5508 & 5512 <u>3/</u>	2
After 3 launderings (cotton)	3.9	5556 & 5512 <u>3/</u>	2

- 1/ A 4X6 inch test specimen shall be cut from each inseam, the center back seam and the center front seam. The seam shall be centered equidistant from the clamps at right angles to the direction of the load application.
- 2/ The result shall be calculated to the nearest 0.1 pound per inch by dividing the actual width of the seam tested into the actual test result recorded in pounds.
- 3/ Water pressure shall be applied to the lightly (green) coated side, with the seam centered directly over the opening of clamp.

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

5. PACKAGING

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

5.1.1 Level A. Each pair of trousers, folded as specified below, shall be inserted into a clear polyethylene film bag of 0.0015 inch thickness (+ 25 percent tolerance). The bag shall be formed with heat sealed seams that are straight, continuous and parallel to each other and the formed edges of the bag. The bag may be fabricated from polyethylene film tubing or sheeting. The final closure of the bag shall be heat sealed, with the heat seal made as close as possible to the open end. A 1/4 inch diameter hole shall be made at

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one corner of the bag to allow excess air to escape. Alternatively, the final closure of the polyethylene bag may be accomplished by means of a tuck or reverse flap.

Method of folding:

- (1) Lay trousers flat, face-side up, placing suspender straps inside the trousers.
- (2) Fold the trousers in half lengthwise, with the outer edges and inseams aligned.
- (3) Fold seat portion of trousers in, so that the width of the trousers is approximately 11 inches.
- (4) Fold the top third of the trousers down and the bottom third up. The folded trousers shall measure approximately 11 by 15 inches.

5.1.2 Level C. Trousers shall be preserved packaged to afford adequate protection against physical damage during shipment from the supply source to the first receiving activity. The contractor may use his standard practice when it meets this requirement.

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

5.2.1 Level A. Thirty (30) pairs of trousers, of one size only and packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to Type CF, Class Weather-Resistant, Variety DW, Grade V15c, Size 3A, of MIL-B-17757. The fiberboard for the box liner shall conform to Type CF, Class Domestic of MIL-B-17757. Level A packages shall be packed flat in two (2) tiers of fifteen (15) each, with each package reversed end to end and the length of the package parallel to the end panels of the container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Toward the end of the contract, or when there are less than the required amount per container of the same size, mixed sizes may be packed within the same shipping container.

5.2.2 Level B. Thirty (30) pairs of trousers, of one size only and packaged as specified in 5.1, shall be packed in a fiberboard shipping container conforming to Type CF, Class Domestic, Variety DW, Grade 275, Size 3A, of MIL-B-17757. The fiberboard for the box liner shall conform to Type CF, Class Domestic, of MIL-B-17757. Level A packages shall be packed flat in two (2) tiers of fifteen (15) each, with each package reversed end to end and the length of the package parallel to the end panels of the container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Toward the end of the contract, or when there are 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. Containers shall be in accordance with the U.S. Postal Service Manual, Uniform Freight Classification Rules, or National Motor Freight Classification Rules, as applicable.

5.2.4 Palletization. When specified (see 6.2) item, packed as specified

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shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with the bonding means C, K, and L or O or P. Pallet patterns shall be in accordance with the appendix of MIL-STD-147.

The pallet shall be 4-way, Type IV; Type V, Class 1, Size 2; or Type VIII, fabricated from wood groups I, II, III, or IV, Grade A of NN-P-71, or 4-way, Style 1, Size A, Type I, Class 1 fabricated from 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 first be approved by the contracting officer.

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

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

TROUSERS, WET WEATHER:
STOCK NO:
SIZE:
QUANTITY:

5.3.2 Labels, mixed sizes. Each shipping container, packed with mixed sizes, 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 printed or stamped thereon and under these words shall be legibly printed or stamped the correct quantity and National Stock Numbers contained therein.

6. NOTES

6.1 Intended use. The waterproof trousers are intended for use in conjunction with the wet weather parka, for protection of military personnel working in wet or wet/cold conditions.

6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number, and date of this specification.
- b. Sizes required (see 1.2).
- c. When 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 in acquisition documents regarding arrangement for examinations, quantity, and testing and approval.
- d. Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- e. When palletization is required (see 5.2.4).

6.3 Samples. For access to samples, address the procuring office issuing the invitation for bids.

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6.4 Subject term (key word) listing.

Clothing, wet/cold weather
Raingear
Seams, cemented and vulcanized
Style, high waisted
Suspenders
Waterproof

Custodian:
Navy - NU

Preparing Activity:
Navy - NU

User activities:
Navy - YD, CG

Review Activity:
DLA - CT

Project No. 8405-0026

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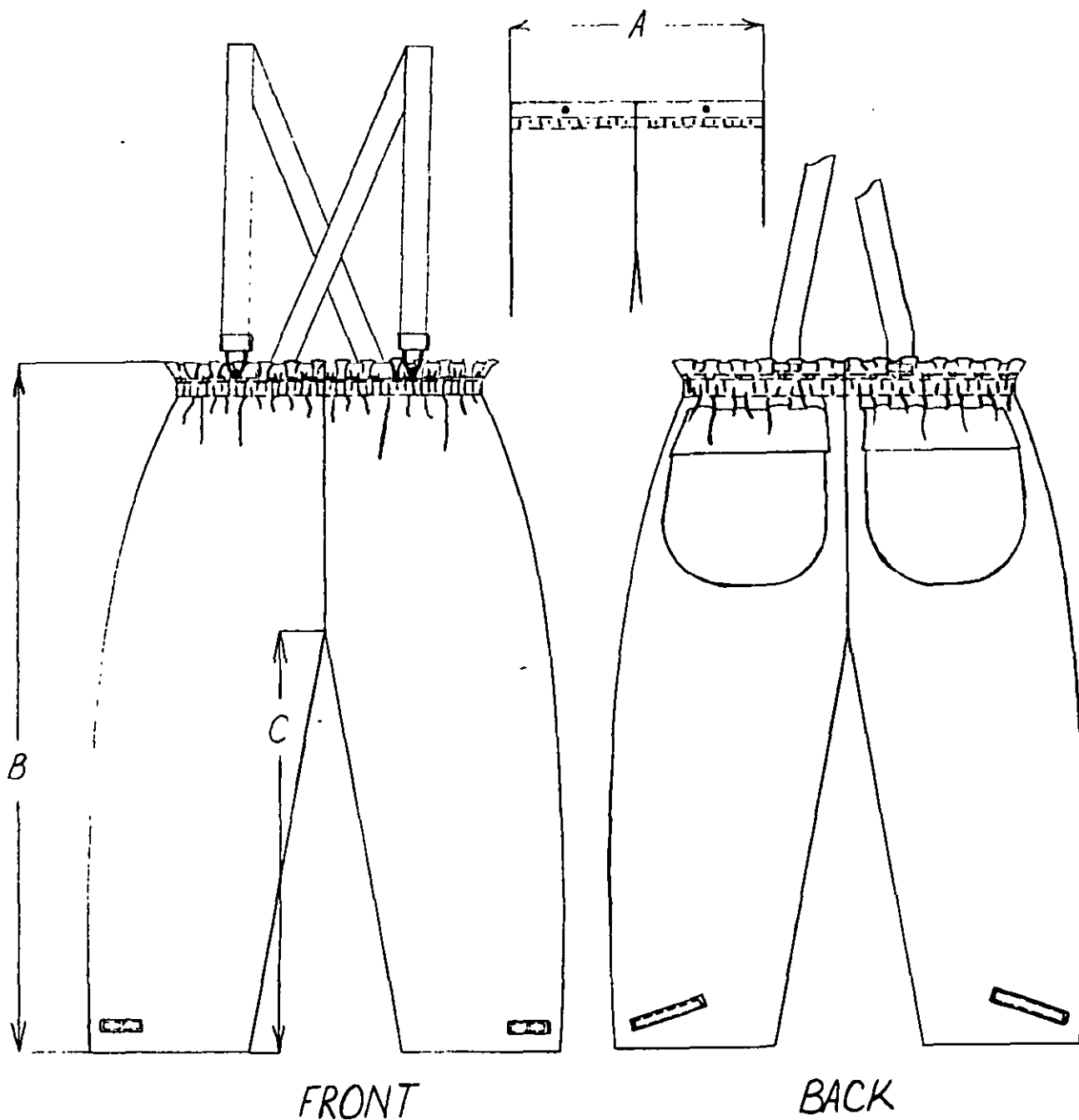


Figure 1 - Trousers, Wet Weather

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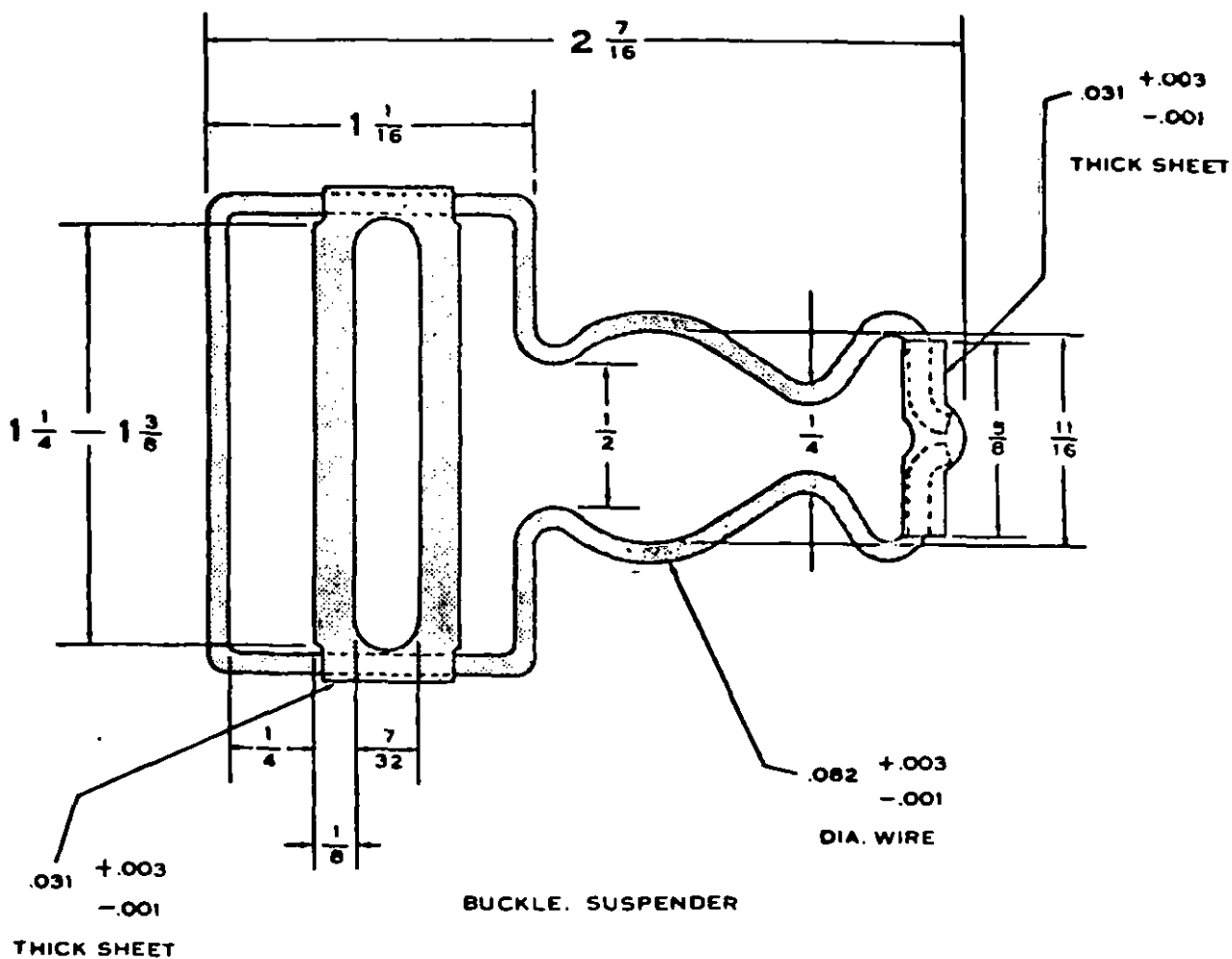
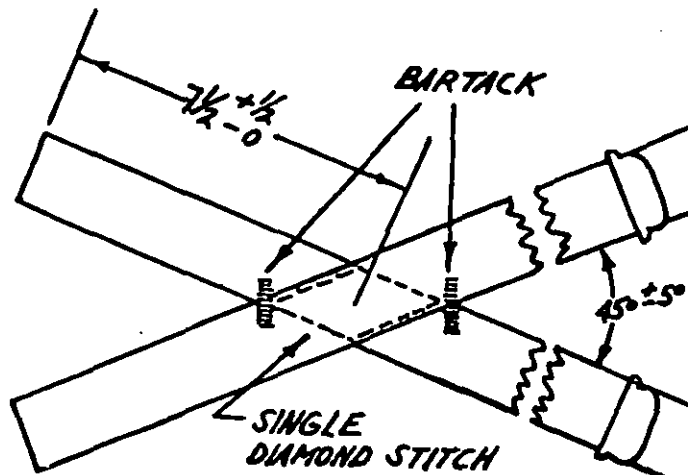
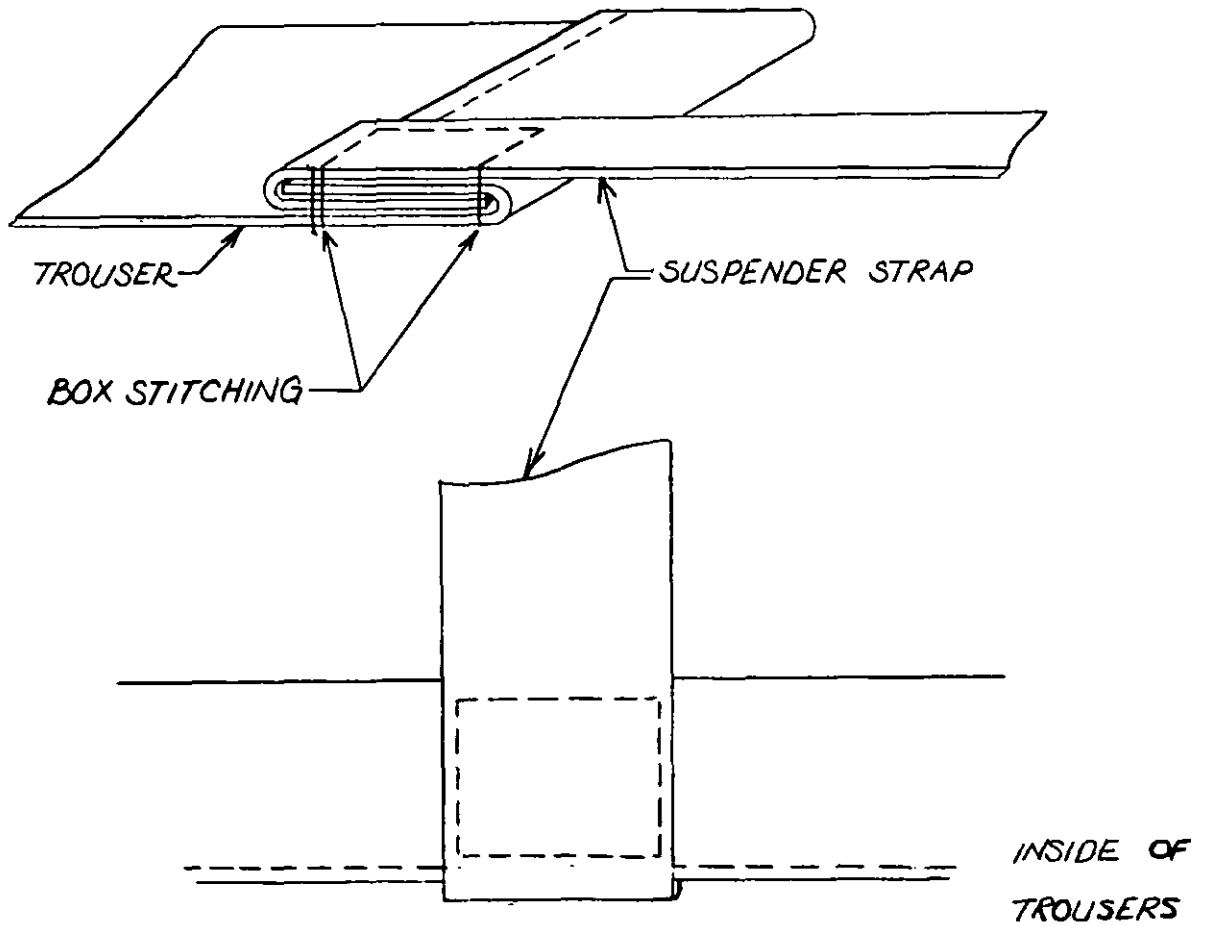


Figure 2 - Trousers, Wet Weather

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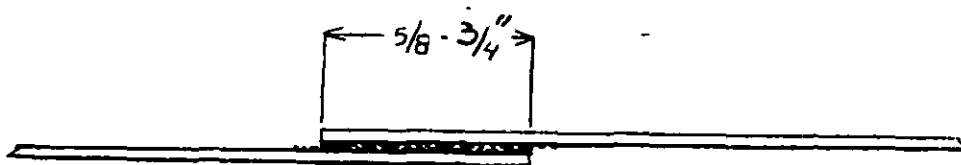
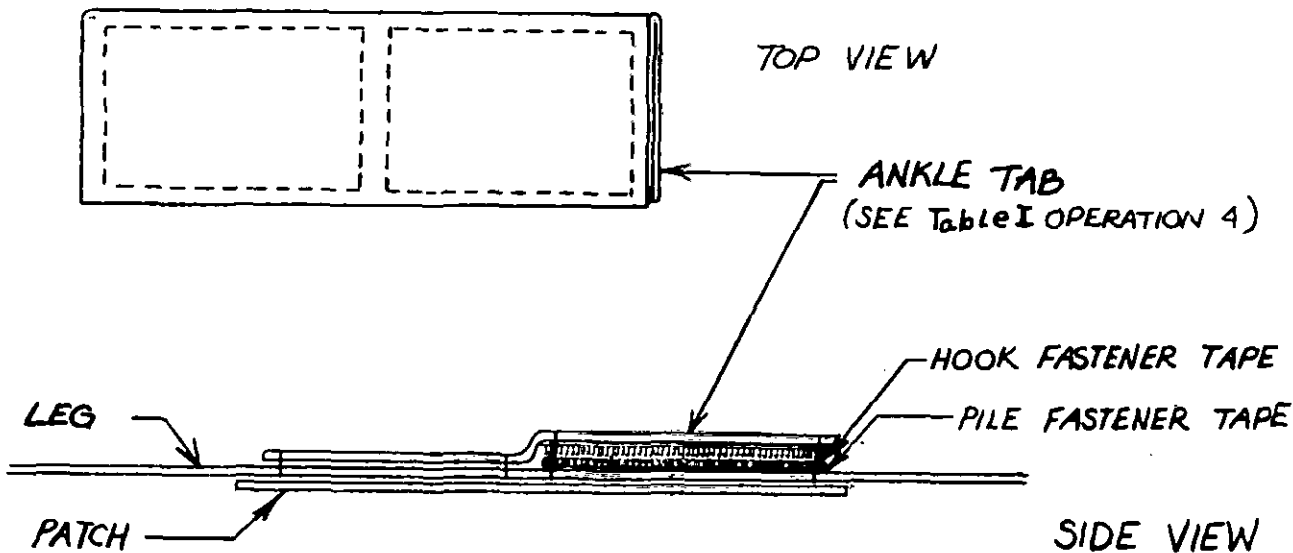


(See Table I, operation 10a, b)

SUSPENDER ATTACHMENT

Figure 3 - Trousers, Wet Weather

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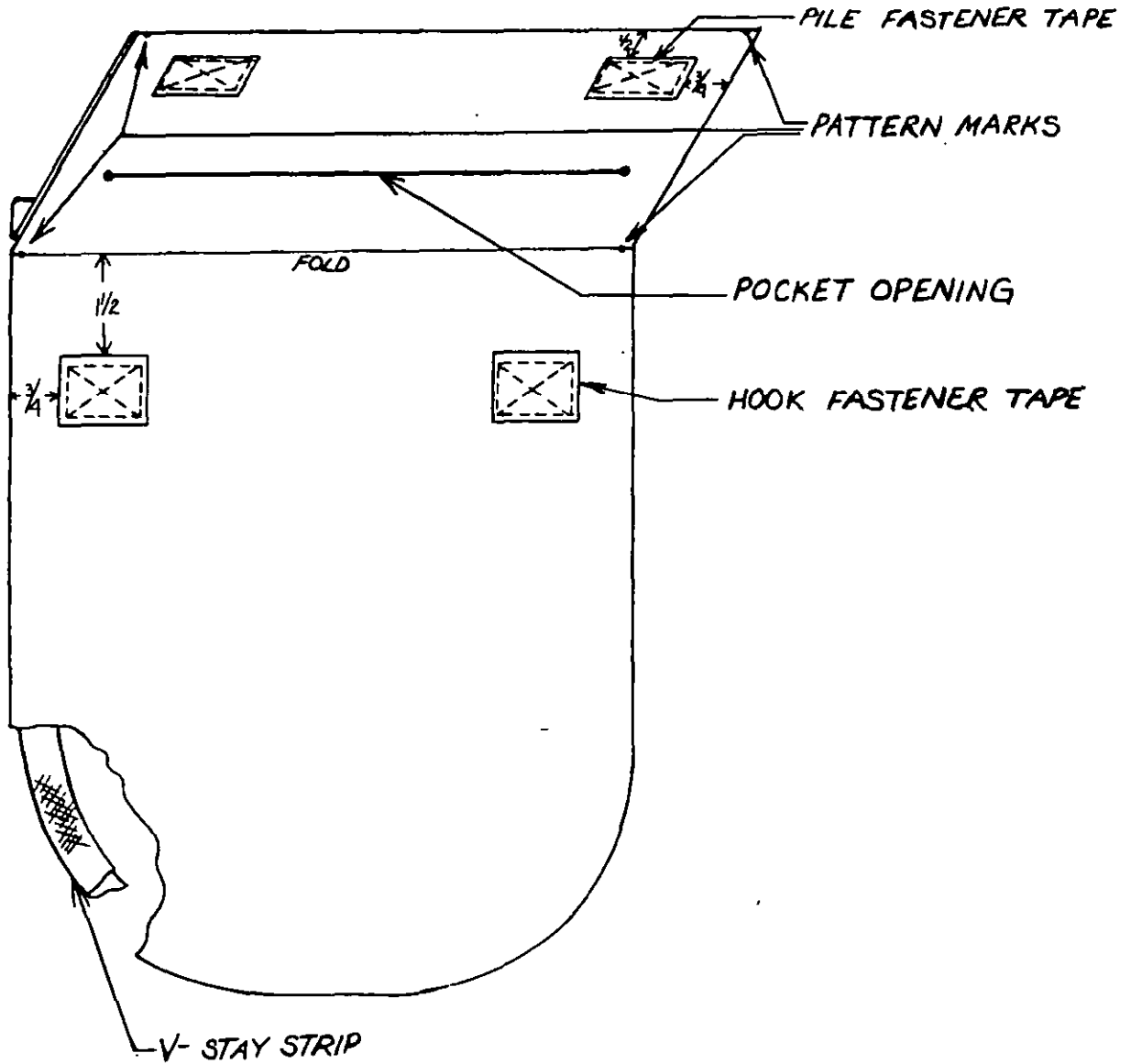


.... CEMENTED AREAS

LAPPED SEAM
(SEE Table I OPERATION 7.a)

Figure 4 - Trousers, Wet Weather

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POCKET ASSEMBLY
(SEE Table I, OPERATIONS 5 & 6)

Figure 5 - Trousers, Wet Weather

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

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

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL*(See Instructions - Reverse Side)*

1. DOCUMENT NUMBER MIL-T-87099		2. DOCUMENT TITLE TROUSERS, WET WEATHER	
3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
b. ADDRESS (Street, City, State, ZIP Code)		<input type="checkbox"/> VENDOR	
		<input type="checkbox"/> USER	
		<input type="checkbox"/> MANUFACTURER	
		<input type="checkbox"/> OTHER (Specify): _____	
5. PROBLEM AREAS			
a. Paragraph Number and Wording:			
b. Recommended Wording:			
c. Reason/Rationale for Recommendation:			
6. REMARKS			
7a. NAME OF SUBMITTER (Last, First, MI) - Optional		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8. DATE OF SUBMISSION (YYMMDD)	