

MIL-U-2416H(SA)
 7 May 1971
 SUPERSEDING
 MIL-U-2416G(SA)
 23 January 1967

MILITARY SPECIFICATION

UNIFORM, MAN'S (SERVICE, BLUE)

1. SCOPE

1.1 Scope.- This specification covers the requirements for a double breasted service blue uniform consisting of a coat and trousers.

1.2 Classification.- The uniform shall be of the following types, sizes, and lengths, as specified (see 6.2):

1.2.1 Types.-

Type I - Standard waist

Type II - Small waist

1.2.2 Sizes.-

1.2.2.1 Coats.- 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, and 48.

1.2.2.2 Trousers.- 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, and 42.

1.2.3 Lengths.- Short, regular, long, and extra long.

2. APPLICABLE DOCUMENTS

2.1 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:

SPECIFICATION

FEDERAL

V-B-871	- Button, Sewing Hole, and Button, Staple (Plastic)
V-F-106	- Fasteners, Slide, Interlocking
V-T-276	- Thread, Cotton
V-T-280	- Thread, Cotton Gimp, Buttonhole
V-T-285	- Thread, Polyester
V-T-295	- Thread, Nylon
V-T-301	- Thread, Silk
UU-P-553	- Paper, Wrapping, Tissue

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- CCC-C-438 - Cloth, Buckram, Cotton
- DDD-L-20 - Label; For Clothing, Equipage, and Tentage (General Use)
- DDD-T-86 - Tape, Textile, Cotton, General Purpose (Unbleached, Bleached, or Dyed)
- PPP-B-636 - Box, Fiberboard
- PPP-F-320 - Fiberboard; Corrugated and Solid, Sheet Stock (Container Grade); and Cut Shapes
- PPP-T-45 - Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing

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- MIL-C-326 - Cloth, Cotton, Silesia
- MIL-C-368 - Cloth, Satin, Rayon and Cloth, Twill, Rayon
- MIL-B-371 - Braid, Textile (Cotton, Tubular)
- MIL-C-823 - Cloth, Serge, Wool; Wool and Nylon
- MIL-B-3461 - Buttons, Insignia, Metal, Uniform and Cap
- MIL-C-15062 - Cloth, Flannel, Wool, Undercollar Cloth
- MIL-P-15064 - Pad, Shoulder and Sleeve-Head
- MIL-C-15065 - Coat Fronts
- MIL-C-16375 - Cloth, Wigan, Cotton
- MIL-B-17757 - Boxes, Fiberboard, Corrugated (Modular Sizes)
- MIL-C-43718 - Cloth, Twill, Polyester and Cotton

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

(Copies of specifications, drawings, standards, 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.)

2.2 Other publications.- The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issues in effect on date of invitation for bids or request for proposal shall apply:

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NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC.
National Motor Freight Classification

(Application for copies should be addressed to American Trucking Associations, Attn: Tariff Order Section, 1616 P Street, N.W., Washington, D. C. 20036.)

UNIFORM CLASSIFICATION COMMITTEE
Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 202 Union Station, 516 W. Jackson Blvd., Chicago, Illinois 60606.)

3. REQUIREMENTS

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

3.2 First article approval.- The requirement for first article will be as specified by the procuring activity (see 6.2).

3.3 Materials

3.3.1 Basic material.- The basic material for the coat and trousers shall be wool, serge, 15 ounce, Blue 3346, conforming to type I, class 5 of MIL-C-823.

3.3.2 Lining.- The material for lining the coat body, sleeves, left front fly, sword vent flap, and for the right inside breast pocket welt and facing shall be rayon, 3.7 ounce, conforming to class 1 of MIL-C-368. The material shall match shade Black 3202.

3.3.3 Rayon binding.- The binding for the underarm shields shall be the same material as specified in 3.3.2. The rayon shall be cut on a 45 (+ 5) degree angle in strips 3/4 to 7/8 inch wide. The ends of the strips shall be joined together by stitch type 301 and seam type SSa-1 with 10 to 12 stitches per inch. The seams shall be 1/8 inch wide and shall be pressed open and flat. The edges of the binding shall be treated with a synthetic resin to prevent raveling when tested as specified in 4.3.1.

3.3.4 Collar interlining.- The material for the collar interlining shall be cotton, buckram, natural or white conforming to type I, class 2 of CCC-C-438, except that the test for shrinkage shall be in accordance with test method 5580 of FED-STD-191.

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3.3.5 Undercollar cloth.-- The material shall be wool, flannel, shade Black 3204, conforming to MIL-C-15062.

3.3.6 Wigan.-- The material for interlining bottom of sleeves shall be cotton, wigan, 2.5 ounce, natural color, conforming to type I of MIL-C-16375.

3.3.7 Silesia or twill, polyester and cotton.--

3.3.7.1 Silesia lining, interlining, and stay for pockets.-- The material for lining the patch pockets, the right inside breast pocket, waistband lining, right fly lining, crotch pieces, left fly interlining, and stay for coat pockets and trouser side pockets shall be cotton, silesia, conforming to type I of MIL-C-326. The color shall be black. The crotch pieces, left fly interlining, and stay for pockets may be bleached. The stay for trouser side pockets may be cut from type III silesia pocket material (see 3.3.7.2).

3.3.7.2 Silesia pocketing.-- The material for the trouser pockets shall be black, cotton, silesia, conforming to type III of MIL-C-326.

3.3.7.3 Twill, polyester and cotton.-- As an alternate for the silesia specified in 3.3.7.1 and 3.3.7.2, a twill, polyester and cotton material, conforming to type I or type II of MIL-C-43718, may be used except the color shall be black and shall show fastness to wet-dry cleaning, perspiration and crocking, when tested as specified in MIL-C-326. Type I material shall be used for the waistband lining only.

3.3.8 Buckram.-- The material for interlining the trouser waistband shall be unbleached, cotton, buckram, conforming to type II, class 1 of CCC-C-438, except that the test for shrinkage shall be in accordance with test method 5580 of FED-STD-191.

3.3.9 Hanger loop.-- The hanger loop for the coat shall be of the material specified in 3.3.2 or shall be braid, cotton, tubular, conforming to type III, class 1 of MIL-B-371. The braid shall be black and shall show good fastness to crocking and wet-dry cleaning when tested as specified in 4.3.1.

3.3.10 Coat front.-- The coat fronts shall conform to type VI and the construction thereto of MIL-C-15065.

3.3.11 Shoulder and sleeve pads.-- The shoulder and sleeve pads shall conform to type I, class 1 and type IV and the construction thereto of MIL-P-15064. The type I shall be used for the shoulders and the type IV shall be used for the sleeve heads.

3.3.12 Tapes.--

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3.3.12.1 Woven tape.-- The tape for staying the coat shall be cotton, pre-shrunk, conforming to class 1 or class 2 and shall be of the following types and widths of DDD-T-86:

- Type I - 5/8 inch wide stay for bridle at breakline of lapel
- Type II - 3/16 inch wide stay for welt of pockets, front neck gorge, back armhole and lower part of front armhole
- Type III - 3/8 inch wide stay for lapel, front and bottom edges

3.3.12.2 Silesia cross tape.-- The tape for staying the front shoulder, back neck, and upper part of the front armhole shall be cotton, silesia, undyed or dyed a neutral shade conforming to type I or II of MIL-C-326. The tape shall be cut across the width of the cloth in strips 1/2 (+ 1/16) inch wide. The ends of the strips shall be abutted or overlapped a maximum of 3/32 inch and stitched with stitch type 304, having a minimum of 8 diagonal stitches per inch with a bight (throw) of 1/8 to 3/16 inch. The type I silesia specified in 3.3.7.1 may be used as cross tape. The edges of the tape shall be treated with a synthetic resin to prevent raveling when tested as specified in 4.3.1.

3.3.13 Thread.--

3.3.13.1 Cotton thread.-- The cotton thread for seaming and stitching the coat and trousers shall conform to type I of V-T-276 and shall be vat dyed black AA, cable No. 66043, except where otherwise specified, as follows:

COAT

Use	Type	Ticket No.	Ply
Seaming and stitching	IC2	0	3
Tacking armholes and attaching sleeve head pads	IA1 or IA2	30	3
Button sewing:			
Hand	IB3	12 or 16	4
Machine	IA3	20	4

TROUSERS

Use	Type	Ticket No.	Ply
Seaming and stitching	IC2 or IA3	A, 0, 70	3, 2
Inside stitching (white or unbleached)	IA1 or IA2	50, 70	3, 2
Buttonholes and bartacks	IC2	A or B	3
Button sewing:			
Hand	IB3	12 or 16	4
Machine	IA3	20	4

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3.3.13.1.1 The thread for basting and tacking shall be a good commercial grade cotton, bleached or unbleached. A monofilament synthetic thread may be used for only those basting operations where the thread is required to be removed provided the garment is subsequently given a treatment by a cleaning agent in which the synthetic thread is soluble. When this thread is used, any residue remaining on the garment after the dry cleaning process shall be brushed off or removed.

3.3.13.2 Silk thread.-- The silk thread for hand and machine sewing in the coat shall be dyed black AA, cable No. 66043, conforming to V-T-301 as follows:

Use	Type	Class	Ticket No.	Ply
Machine stitching and felling	I		O	3
Buttonholes and bartacks	I		B, C	3
Hand felling	III	3	A, C	2

3.3.13.2.1 The following threads may be utilized as alternates to the silk threads specified above for the operations indicated:

- a. For machine felling and blind felling - polyester thread conforming to type I, size A/3 or AA/2 of V-T-285 or a monofilament nylon thread of comparable type and size.
- b. For hand felling - nylon thread conforming to type IV, size A/2 or C/2 of V-T-295.

3.3.13.3 Colorfastness of threads.-- The dyed threads shall show colorfastness to wet-dry cleaning and light equal to or better than the standard sample when tested as specified in V-T-276, V-T-285, V-T-295, and V-T-301. When no standard sample is available, the dyed threads shall show good colorfastness to wet-dry cleaning and light when tested as specified in V-T-276, V-T-285, V-T-295, and V-T-301.

3.3.14 Gimp.-- The gimp for reinforcing the buttonholes shall be thread, cotton gimp, buttonhole conforming to type I or II, size No. 8 of V-T-280. The gimp shall be vat dyed black.

3.3.14.1 Colorfastness.-- The dyed gimp shall show fastness to wet-dry cleaning equal to or better than the standard sample when tested as specified in V-T-280. When no standard sample is available, the dyed gimp shall show good fastness to wet-dry cleaning when tested as specified in V-T-280.

3.3.15 Labels.--

3.3.15.1 Identification label.-- Each coat and trousers shall have an identification label conforming to type I, class 1 of DDD-L-20. The printing on the label shall show fastness to dry cleaning and shall bear the following inscription:

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UNIFORM, MAN'S (SERVICE, BLUE) (100% Wool)
 NAME OF SUPPLIER:
 CONTRACT NO.: DSA-000-000-000 (Example)
 STOCK NO.: 8405-000-0000 (Example)
 SIZE: 38R (Standard Waist or Small Waist) (Example for coat)
 SIZE: 38R Waist 32 (Standard Waist or Small Waist) (Example for trousers)

3.3.15.2 Size label.-- The size label for the trousers shall conform to type I, class 2 of DDD-L-20. The inscription shall read as follows:

Size 32R (Standard Waist or Small Waist) (Example)
 Stock No. 8405-000-0000 (Example)

3.3.15.3 Size ticket (uniform).-- Each coat and trouser shall have a size ticket which shall be made of suitable commercial cardboard, legibly printed and measure not less than 2-1/8 by 1-1/4 inches. The corners may be double perforated for ease in tacking.

For example:

UNIFORM, MAN'S (SERVICE, BLUE)
 Coat - 38R (Standard Waist or Small Waist)
 Trousers - 32R (Standard Waist or Small Waist)
 Shade (Matching No.)

3.3.15.3.1 Printing.-- The nomenclature, the item (trousers and coat), and model (short, regular, long, or extra long) shall be in letters and numerals not less than 1/8 inch in height. The model may be designated S, R, L, or XL. The size shall be in numerals not less than 3/16 inch in height. The matching shade number shall be in letters and numerals not less than 1/16 inch in height.

3.3.15.3.2 Position.-- The trouser size ticket shall be tacked to outside of waistband above right back pocket between the two belt loops. The coat size ticket shall be tacked on the outside of the right front sleeve 2 or 3 inches from bottom edge. The tickets shall be tacked on four corners by machine or hand (6 to 8 per tack by machine or 2 to 3 per tack by hand).

3.3.16 Buttons.--

3.3.16.1 Metal buttons.-- The buttons for the coat shall be uniform, gold-plated, 35-line, regular shank for left front and 35-line, short shank for right front conforming to type I, style 4, class A of MIL-B-3461. Buttons with bodkins shall be used for left front of coat only.

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3.3.16.2 Composition buttons.-- The buttons for the trouser inside fly closure and left hip pocket shall be plastic, type II, class D, style 4, 22-line; type II, class D, styles 20 and 21, 24-line for sword vent flap; and type II, class D, styles 20 and 21, 30-line for inside left front fly of coat conforming to V-B-871. The buttons shall be shade Black BT, Cable No. 62001.

3.3.17 Slide fasteners.-- The slide fastener for the trouser fly shall be interlocking, type I, style 1, cam lock, size LS, short tab pull, brass, aluminum or zinc chain, conforming to V-F-106, except that the salt spray requirement shall not apply. The fastener may be assembled as an individual length or in continuous lengths. When the fastener is a continuous length, the completely assembled fastener shall comply with requirements specified. The tape shall show fastness to wet-dry cleaning equal to or better than the standard sample. When no standard sample is available, the tape shall show good colorfastness to wet-dry cleaning. The tape shall be cotton or cotton warp and nylon filling and shall match the shade of the basic material. The slide fasteners for the various sizes shall be of sufficient length for the chain to be caught in the waistband.

3.3.18 Hook and eye.-- The hook and eye for the trouser waistband shall be nickel plated finish, North and Judd (Hook Flex H-49, K-50, H-89, and E-90); Universal Button Co. (Talon #3, #7, and #8 hook with #8 eye or #85 eye); Akim Co., or Patwin, Inc. Junior Series, type JB; Stimpson (P-536, D-4086, D-4457, D-4288; Rau (OA50, OX1256, O80415); Patwin, Inc. (Slim-Slak with MB eye, and Slik-Slak) or functionally interchangeable equivalent.

3.3.19 Adhesive shade tickets.-- Adhesive tickets, when used for shade marking, shall be of paper with a thermo-activated adhesive applied on one side that will withstand moderate steam pressing operations. The adhesive shall not discolor the material and the adhesive mass shall not adhere to the material upon removal of the tickets.

3.4 Design

3.4.1 Coat.-- The coat shall be semi-fitted, double-breasted fully line sack coat. It shall have three, 35-line Navy eagle gilt buttons on each forepart, semi-peaked lapels, front and side body, two-piece back, one welted outside breast pocket and two welted lower front pockets, and inside welt or double piped pocket at the right breast, and a sword slit with flap in side (underarm) seam of left forepart (see figure 1).

3.4.2 Trousers.-- The trousers shall be of a single needle construction, conventional design matching fabric and color of coat. It shall have a sewn-on waistband with a hook and eye closure, a slide fastener fly with a fly tab on right fly. Also included are two straight side pockets, and two double cord hip pockets with left hip pocket having a button tab closure.

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An outlet is provided at the seat seam and from crotch to knee at back inseam. It shall have seven belt loops, up to and including size 37; an extra loop shall be at the front for size 38, and upward. Leg bottoms shall be unhemmed (see figures 2, 3, 4, 5, and 6).

3.4.3 Figures.— Figures are furnished for information purposes only. To the extent of any inconsistencies between the written specification and the figures, the written specification shall govern.

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

3.5.1 List of pattern parts.— The component parts of the Uniform, Man's (Service, Blue) shall be cut from materials as specified and in accordance with the number of parts required for the manufacturing process as follows:

<u>Material</u>	<u>Pattern parts</u>	<u>Cut parts</u>
Coat Cloth, serge, wool	Front	2
	Side body	2
	Back	2
	Facing	2
	Top sleeve	2
	Under sleeve	2
	Top collar	1
	Pocket welt (hip)	2
	Pocket welt (outside breast)	1
	Pocket facing (hip)	2
	Pocket facing (outside breast)	1
	Sword vent flap	1
	Sword vent facing	1
	Underarm shield	2
	Front	2
	Back	2
Cloth, rayon, lining	Top sleeve	2
	Under sleeve	2
	Front fly (left side)	2
	Pocket welt and facing (right inside breast pocket)	1
	Sword vent flap	1

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<u>Material</u>	<u>Pattern parts</u>	<u>Cut parts</u>
Coat (cont'd)		
Cloth, cotton, silesia, type I or cloth, twill, polyester and cotton, type I or type II (see 3.3.7.1 and 3.3.7.3)	Hip pocket (inner ply) Hip pocket (outer ply) Cash pocket (right side) Outside breast pocket (inner ply) Outside breast pocket (outer ply) Inside breast pocket	2 2 1 1 1 1
Cloth, wool, flannel	Undercollar (bias)	2 <u>1</u> /
Cloth, cotton, interlining	Undercollar, canvas (bias)	2 <u>1</u> /
Cloth, cotton, wigan	Sleeve interlining (bias)	2
Shapers	Collar shaper Lapel shaper	- -
Trousers		
Cloth, serge, wool	Front Back Flies (one right and one left) Side pocket (wide facing) Side pocket (narrow facing) Hip pocket bearer Hip pocket cord Waistband Fly tab Belt loops (strip)	2 2 2 2 2 2 2 2 2 1
Cloth, cotton, silesia, type I or cloth, twill, polyester and cotton, type I or type II (see 3.3.7.1 and 3.3.7.3)	Waistband lining Right fly lining Crotch lining Side pocket stay Left fly interlining	2 1 <u>2</u> / 2 2 1
Cloth, cotton, buckram	Waistband interlining	2
Cloth, cotton, silesia, unbleached, type III (see 3.3.7.2)	Side pocket Hip pocket	2 2

1/ Pattern may be cut as one piece.

- 2/ The right front end of the waistband lining may extend to the edge of the front opening. When this optional construction is exercised, the right fly lining shall be shortened at the top. The altered right fly must be sufficiently long to extend under the waistband lining and be caught by the waistband topstitching (see operations 20 and 20A; 22b and 26A of Table II).

3.6 Construction.-

3.6.1 Stitches, seams, and stitching types.- Stitch, seam, and stitching types as specified in Tables I and II, shall conform to FED-STD-751. Wherever two or more methods for seam or stitch types are given for the same part of the operation, any one of them may be used. Where stitch type 401 or 101 is used, the looper (underthread) shall be on the inside of the trousers. Unless otherwise specified topstitching and edgestitching shall be 1/16 inch gauge from edge.

3.6.2 Thread breaks and ends of seams.- Ends of all seams and stitchings when not caught in other seams or stitchings shall be backtacked not less than 3/8 inch. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 inch. Skipped stitches or 401 stitch type thread breaks may be repaired by using 301 stitch type. Where stitch type 401 or 101 is permitted, as an option, it shall not be used unless the ends are caught in other seams or stitching, except basting and button sewing operations and bottom end of trousers.

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

3.7 Manufacturing operations requirements.- The coat and trousers shall be manufactured in accordance with the operation requirements specified in Tables I and II. The supplier is not required to follow the exact sequence of operations listed provided that the finished coat and trousers are identical to those produced by following the sequence of operations as listed in Tables I and II respectively.

3.7.1 All pressing operations referenced in Tables I and II shall be performed by using a heated pressing iron or steam pressing machine.

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Table I - Construction of coat

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
1.	<p><u>Cutting</u></p> <p>a. Cut the coat in strict accordance with patterns, which show size, shape, placement of component parts, directional lines, and notches for the proper assembly of all parts. Wax crayon for the marking of outer edges of patterns or paper markers with a felt backing is permissible for cutting the wool. Perforated paper markers are prohibited on the wool but may be used for cotton components.</p> <p>b. All component wool parts of the coat shall be cut from one piece of material except the sword vent facing, pocket facings, and underarm shields which may be cut from ends and when so cut shall approximately match the main assembly.</p> <p>c. All component lining parts of the coat shall be cut from one piece of material except bias binding for underarm shields, sword vent flap, front fly (left side), and sleeve linings which may be cut from ends and when so cut shall approximately match the main assembly. When pairs of sleeve linings are cut from ends, they shall be shade marked and shall match each other.</p> <p>d. Cut all other component parts listed in 3.5.1 as indicated by patterns from the material specified. When the undercollar is cut in two pieces the two pieces shall match each other.</p> <p>e. The coat and trousers shall be cut from the same piece of material, when purchased as a uniform, except those parts which may be cut from ends.</p>					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
2.	<p><u>Replacement of damaged parts</u></p> <p>a. Replace at time of cutting any part containing damages such as a hole, smash, multiple float or slub.</p> <p>b. Replace any part damaged during the manufacturing process by a needle chew, cut, tear, hole, mend or burn.</p>					
3.	<p><u>Shade marking</u></p> <p>a. All component parts of the basic material and linings including sleeve linings whether cut from ends or in the main lay shall be marked or ticketed to assure a uniform shade throughout the coat. Other parts cut from ends need not be shade marked.</p> <p>b. The use of metal fastening devices for shade and identification marking is permitted on the wool but is prohibited on the rayon lining. When metal stapled tickets are used on the base fabric, the wire shall be aluminum.</p> <p>c. Adhesive type shade tickets, when used, shall conform to the requirements specified in 3.3.19.</p> <p>d. The use of ink pad numbering machine, rubber stamp, or pencil is acceptable provided the numbers are legible and do not show through on the outside of the coat; wherever possible, numbers shall be on the seam allowance.</p>					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
4.	<u>Make coat fronts</u> The coat fronts shall conform to the requirements of 3.3.10.					
5.	<u>Make sword vent flap</u> a. Stitch sword vent flap lining to wool sword vent flap. Turn, work out edges and point; trim where necessary and edgestitch. b. Mark and stitch in sword vent flap, a 5/8 to 3/4 inch horizontal buttonhole, eyelet end, taper bar type, worked over gimp with ends securely tacked or an eyelet end, square-bar type may be used (see operations 33a, b and d). Eyelet shall be 5/8 to 3/4 inch from point of flap. c. The finished sword vent flap shall measure 3-1/2 (+ 1/4) inches long and 2 (+ 1/8) inches deep in the center.	301 Button-hole	SSe-2 Stitches per size/ inch 5/8 3/4	12-16 Button-hole stitches 32-38 40-46 (including tack)	0/3 C (silk)	0/3 B (silk)
6.	<u>Make collar</u> a. The collar shall consist of a one-piece topcollar of basic material with a one or two-piece wool flannel undercollar and one or two-piece buckram interlining undercollar. b. Seam wool flannel undercollar face to face at center back 1/4 inch gauge. c. Press seam open and flat. NOTE: These operations shall be omitted when pattern is cut as one piece.	301	SSa-1	12-16	0/3	0/3

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
6.	Make collar (cont'd) d. Seam canvas interlining undercollar at center back overlapping the edges approximately 3/8 inch. NOTE: This operation shall be omitted when pattern is cut as one piece.	301	LSa-1	12-16	0/3	0/3
	e. Pad canvas interlining undercollar to wool flannel undercollar with seven to eight rows of blindstitching.	103	SSm-7 to 8	4-8	0/3	
	f. Press undercollar flat.					
	g. Mark and shape undercollar to conform to undercollar pattern shaper. Trim canvas interlining 1/8 to 3/16 inch from neck edge of undercollar. NOTE: Marking and shaping of undercollar may be performed with a clicker machine using dies conforming to undercollar shaper.					
	h. Mark the breakline of the finished undercollar in accordance with marks on pattern.					
	i. Seam undercollar to canvas interlining at breakline (the finished collar stand at center shall measure 1-1/4 (+ 1/8) inches).	301	SSv-1	12-16	0/3	0/3
	j. Baste top edge of finished undercollar along straight top edge of topcollar. NOTE: This operation shall be omitted when top edge of collar is machine felled (see operation 6m).	Hand or machine				
	k. Baste along breakline and ends of collar.	Hand or machine				

Table I - Construction of coat (cont'd)

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No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
6.	Make collar (cont'd)					
	l. Trim, turn, and baste edges of topcollar over interlining between undercollar and interlining.	Hand or machine				
	m. Fell corners, top and side edges of topcollar to finished undercollar by hand or top edge may be machine felled with simulated hand stitching.	Hand or machine		8-10 6-10	C (silk) O (silk)	O (silk)
	n. Trim neck edge of topcollar to allow for seaming.					
7.	Make sleeves and sleeve linings					
	a. Join forearm seam of sleeve (basic material) face to face 3/8 inch gauge distributing fullness between notches.	301	SSa-1	12-16	0/3	0/3
	b. Press forearm seam open and flat holding seam short.					
	c. Stitch sleeve interlining (wigan) to forearm seam and sides of backarm seam allowances. Bottom edge of sleeve interlining shall be 1/2 to 3/4 inch below turnip notches. Trim ends of sleeve interlining even with edges of sleeve.	301		12-16	0/3	0/3
	d. Press turnup of sleeve as indicated by notches in pattern.					
	e. Join backarm seam of sleeve face to face 3/8 inch gauge.	301	SSa-1	12-16	0/3	0/3
	f. Press backarm seam open and flat.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
7.	Make sleeves and sleeve linings (cont'd)					
	g. Blindstitch top edge of sleeve turnout to interlining.	103 or 301 or Hand	EFc-1(b) EFc-1(b)	4-8 4-8 4-8	0/3 0/3 0/3	0/3
	h. Join the forearm seam of the sleeve linings face to face 3/8 inch gauge distributing fullness between notches.	301	SSa-1	12-16	0/3	0/3
	i. Join the back arm seam of sleeve linings face to face 3/8 inch gauge.	301	SSa-1	12-16	0/3	0/3
8.	Attach sleeve lining to sleeve					
	a. The sleeve lining shall extend not less than 3/4 inch nor more than 1 inch above top of the basic material sleeve.					
	b. Tack forearm and backarm seam of sleeve lining to forearm and backarm seam of sleeves respectively distributing proper fullness in lining. Tacking shall extend from not more than 6 inches below top to not more than 6 inches above creased bottom edge. When tacking is done by hand, both ends of the stitching shall be securely backstitched with not less than three stitches.	301 or Hand		4-8 1/2 to 1-1/2 inches in length	0/3 or commercial 0/3 or commercial	0/3
	c. Pull sleeve through lining and baste turnout of sleeve lining. Sleeve lining shall have not less than 1-1/4 inches turnout. NOTE: The bottom of the sleeve lining may be felled without basting.	Hand or machine				

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
8.	Attach sleeve lining to sleeve (cont'd)	Hand or machine		6-8	A or C (silk) 0 (silk)	0 (silk)
	d. Fell bottom of sleeve lining to sleeve turnup.			6-10		
9.	e. Turn sleeves to finished position and assemble in pairs.	301	SSe-2	12-16	0/3	0/3
	Make cash pocket					
	a. There shall be a cash pocket on the inside of the right hip pocket.					
	b. Stitch cash pocket silesia piece, centered to the top edge of hip pocket (inner ply) piece, 1/4 inch gauge. Notch both ends of stitchings, turn and edge-stitch.					
	c. Fold cash pocket piece and stitch to form a pocket.					
	d. The finished cash pocket shall measure 3-3/4 (+ 1/4) inches wide and 3-3/4 (+ 1/2) inches deep.	301	SSa-1 and LSb-1	12-16	0/3	0/3
	e. Stitch inner ply of silesia pocket pieces to pocket facings 1/4 inch gauge. The cash pocket opening shall not be caught in the seam.					

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
10.	Join fronts and side body pieces and attach sword vent flap and facing					
	a. Each front shall consist of two pieces, a front and a side body.					
	b. Stitch the cut out dart front section as indicated by pattern, tapering from a point at the top end to approximately 3/8 inch in the middle and 1/4 inch at the bottom end.	301	SSa-1	12-16	0/3	0/3
	c. Press darts open and flat.					
	d. Abut edges of hip pocket openings and zigzag stitch.	304 or Hand	FSa-1	4-8 2-4	0/3 0/3	0/3
	e. Stitch sword vent flap to side (underarm) seam of left front face to face 3/8 inch gauge as indicated by notches on pattern.	301	LSq-2(a)	12-16	0/3	0/3
	f. Stitch sword vent facing to front (underarm) seam of left side body piece face to face 3/8 inch gauge as indicated by notches on pattern.	301	LSq-2(a)	12-16	0/3	0/3
	g. Join front (underarm) seam of side body pieces to the side (underarm) seam of left and right fronts, face to face, 3/8 inch gauge, leaving the prestitched sword vent flap and facing open as indicated by notches on pattern.	301	SSa-1	12-16	0/3	0/3

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
10.	Join fronts and side body pieces and attach sword vent flap and facing (cont'd)					
	h. Press each joining seam open and flat.					
	i. Turn and raisestitch sword vent flap through front and seam allowance.	301	LSq-2(b)	12-16	0/3	0/3
	j. Turn the seam allowance against the sword vent facing and raisestitch.	301	LSq-2(b)	12-16	0/3	0/3
	k. Turn vent facing to finished position and press.					
11.	l. Stitch a 3/16 to 1/4 inch bartack across each end of the sword vent opening. The bartacks shall be centered across the joining seam.	Bartack or Hand		21-28 per bartack 10-12 per tack	B (silk) B (silk)	B (silk)
	<u>Make welt pockets</u>					
	a. There shall be three welt pockets; one on the left breast and one on each hip.					
	b. Position and stitch 1/16 inch from edge a 3/16 inch wide herringbone tape to the underside of under ply of welt piece, off center 1/8 inch to stay folded edge.	301		12-16	0/3	0/3
	c. Stitch 1/4 inch gauge, face to face, the outer ply of silesia pocket piece to the under ply of welt.	301	SSa-1	12-16	0/3	0/3
	d. Stitch 1/4 inch gauge, face to face, the inner ply of silesia pocket piece to the facing.	301	SSa-1	12-16	0/3	0/3

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MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
11.	Make welt pockets (cont'd)					
	e. Fold welt in half lengthwise and stitch the ends 3/16 inch gauge, terminating the stitching at the ends of seam joining the outer ply of silesia pocket to the under ply of welt. Trim corners, turn to finished position, working out seamed edges and points of welt.	301	SSa-1	12-16	0/3	0/3
	f. Press welt flat with a heated pressing iron.					
	g. Slit ends of welt and mark width of welt in accordance with finished measurements.					
	h. Stitch top ply of welt to fronts as indicated by marks on pattern.	301	LSbj-1	12-16	0/3	0/3
	i. Clip ends of welt seam allowance.					
	j. Stitch pocket facing to front with the stitching approximately 1/2 inch from the seam joining top ply of welt to front catching a 2-1/2 inches wide silesia pocket stay on the underside.	301	LSbj-1	12-16	0/3	0/3
	k. Cut opening of pocket between the two rows of stitching and tongue notch ends.					
	l. Turn up seam allowance of top ply of welt and stitch on the underside adjacent to the welt setting seam, through under ply of welt simultaneously catching the prestitched silesia stay. NOTE: In the finished coat the welt setting seam shall be spread open.	301		12-16	0/3	0/3

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
11.	Make welt pockets (cont'd)					
	m. Turn pocket through cut opening to finished position.					
	n. Topstitch ends of welt through front, pocket facing and stay. Reinforce corners with a diagonal stitch approximately 1/4 inch in length.	301		12-16	0/3	0/3
	o. Stitch sides and bottom of pockets. (See finished measurement of pocket.)	301	SSa-1	12-16	0/3	0/3
	p. Press pocket facing-front joining seam open.					
	q. The finished outside breast pocket shall measure: <div><div><div>34-36</div><div>4-1/8</div><div>6</div></div><div><div>37-39</div><div>4-1/2</div><div>6</div></div><div><div>40-42</div><div>4-3/4</div><div>6</div></div><div><div>43-48</div><div>5</div><div>6</div></div><div><div>Tolerance</div><div>+ 1/8</div><div>± 1/2</div></div></div> <p>The finished welt shall measure not less than 7/8 or more than 1 inch wide.</p>					
	r. The finished hip pocket shall measure: <div><div><div>34-36</div><div>6-1/8</div><div>6-1/2 (S)</div><div>7 (R,L,XL)</div></div><div><div>37-39</div><div>6-3/8</div><div>6-1/2 (S)</div><div>7 (R,L,XL)</div></div><div><div>40-42</div><div>6-3/4</div><div>6-1/2 (S)</div><div>7 (R,L,XL)</div></div><div><div>43-48</div><div>7</div><div>7 (R,L,XL)</div><div>7 (R,L,XL)</div></div><div><div>Tolerance</div><div>+ 1/8</div><div>+ 1/2</div><div>+ 1/2</div></div></div> <p>The finished welt shall measure not less than 1-1/8 or more than 1-1/4 inches wide.</p>					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Loop
12.	<u>Make backs</u> a. The back shall consist of two pieces. b. Stitch back pieces face to face 3/4 inch gauge. c. Press seam open and flat.	301	SSa-1	12-16	0/3	0/3
13.	<u>Stitch tapes to front</u> a. Stitch a 3/16 inch wide herringbone tape on neck gorge of front 1/8 inch gauge. b. Stitch a 1/2 inch wide silesia cross tape strip on each front along shoulder 3/4 to 1 inch from gorge to within 1/2 to 3/4 inch from armhole. c. Stitch a 1/2 inch wide silesia cross tape strip on front of armhole from 2 to 2-1/2 inches above armhole notch to within 1/2 to 3/4 inch from shoulder. d. Stitch a 1/2 inch wide silesia cross tape strip to back neckline. e. Stitch a 3/16 inch wide herringbone tape on armholes of foreparts from approximately 3/4 inch of underarm seam to approximately 3/8 inch beyond silesia cross tape strip on armhole; holding tape taut to draw up material and working in proper fullness. f. Press tapes.	301	SSaa-1	12-16	0/3	0/3

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
14.	<p><u>Prepare front lining</u></p> <p>a. Fold and stitch dart in each lining front as indicated on pattern 3/8 inch at center and tapering to a point on both ends.</p> <p>b. Press dart to one side flat with the fold towards the side seam.</p> <p>c. Seam right front lining to right front facing face to face 3/8 inch gauge; terminate seam 1 to 1-1/2 inches above the bottom of facing-lining assembly to facilitate hem felling operation.</p>	301	OSf-1	12-16	0/3	0/3
15.	<p><u>Make inside breast pocket and attach label</u></p> <p>a. There shall be an inside breast welt pocket located on right inside breast of coat as indicated by marks on patterns.</p> <p>b. Center the inside breast pocket lining facing on and between the ends of the inside breast pocket silesia piece and turn under both edges 1/4 to 3/8 inch and stitch. Selvage need not be turned under. The bottom edge of a label shall be centered, inserted and caught under the edge of the lining facing; printing on label shall not be obscured. Stitch the remaining three sides of label. Label shall be located on the silesia ply next to lining.</p>	301	SSa-1 LSd-1 and LSbj-1	12-16	0/3	0/3

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
15.	Make inside breast pocket and attach label (cont'd)					
	c. As an alternate, stitch the four sides of label to silesia pocket piece with the bottom edge of label overlapping lining facing. Label shall be located on the silesia ply next to lining.	301	LSbj-1	12-16	0/3	0/3
	d. Fold silesia pocket piece approximately in the center of the lining facing and stitch to right facing lining assembly at the mark for the pocket opening and a silesia pocket stay on the underside forming a 1/4 inch to 3/8 inch welt.	301	Similar to LSbt-2(a)	12-16	0/3	0/3
	e. Stitch under layer of silesia pocket piece to facing lining assembly and pocket stay 1/4 to 3/8 inch above the first row of stitching.	301	LSbj-1	12-16	0/3	0/3
	f. Cut opening of pocket through pocket facing-lining assembly and stay piece midway between the row of stitching; tongue notch the ends of opening and turn silesia pocket piece through opening.					
	g. Topstitch facing-lining assembly at ends and top of pocket opening with tongue tab at each end turned under and seam allowance at top of pocket turned upward.	301	LSq-2(b) (shows finished seam at top of pocket opening)	12-16	0/3	0/3

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
15.	<p>Make inside breast pocket and attach label (cont'd)</p> <p>h. Stitch silesia pocket piece at sides securely tacking corners through tongue notch and bottom rounding corners. The back part of pocket shall be held taut to prevent gapping of pocket opening.</p> <p>i. Notch top of pocket at front edge for the full width of seam allowance and blindstitch inner ply of pocket to facing (see 3lg for alternate operation).</p> <p>j. The finished inside breast pocket shall measure $5\frac{1}{4}$ (+ $\frac{1}{4}$) inches wide, $6\frac{3}{4}$ (+ $\frac{1}{2}$) inches deep and shall extend into the facing $1\frac{1}{2}$ (+ $\frac{1}{4}$) inch.</p> <p>NOTE: As an alternate, the above pocket opening operations may be accomplished with a double piped pocket machine which stitches, cuts, and turns piped edges in one operation. When this machine is used, the welt piece may be trimmed to permit insertion into the machine. The bottom piping piece shall be raise stitched $1/16$ inch through all plies of material. The top piping piece shall be raise stitched through all plies closing top of the pocket opening. Ends of pocket opening shall be securely tacked.</p>	301	SSa-1	12-16	0/3	0/3
		103 or 301	SSm-1	2-4	0/3 0/3	0/3
		101 and 301 or 401		12-16	A/3 0/3	0/3
16.	<p>Make front fly in left front lining</p> <p>a. Position and stitch face to face $3/8$ inch gauge, front edge of front fly lining piece to inner edge of left front facing as indicated by notches on pattern. Turn to finished position and raisestitch through fly lining and seam allowance.</p>	301	LSq-2	12-16	0/3	0/3

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Loop
16.	Make front fly in left front lining (cont'd)					
	b. Position and stitch face to face 3/8 inch gauge, front edge of fly lining piece to front edge of left front lining piece. Turn to finished position and raise stitch through fly lining and seam allowance.	301	LSq-2	12-16	0/3	0/3
	c. Join left front facing to left front lining 3/8 inch gauge, leaving an opening (fly) between notches as indicated on pattern. Terminate seam as indicated in operation 14c.	301	SSa-1	12-16	0/3	0/3
	d. To complete fly opening, stitch 2-1/2 (+ 1/4) inches in from open folded edge and along top and bottom through front lining and plies of fly lining.	301	SSa-1	12-16	0/3	0/3
17.	e. Stitch underarm darts of lining pieces 3/8 inch gauge leaving an opening on left seam to accommodate sword-slit opening.	301	SSa-1	12-16	0/3	0/3
	f. Press underarm darts with a heated pressing iron flat to one side toward side seam.					
	Join back and front linings					
	a. Join sides of front and back linings face to face 3/4 inch gauge.	301	SSa-1	12-16	0/3	0/3
	b. Join lining at center back face to face 3/8 inch gauge.	301	SSa-1	12-16	0/3	0/3
	c. Press side seams flat to one side with a heated pressing iron; placing the side joining seams toward the center back.					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
17.	Join back and front linings (cont'd) d. Press with a heated pressing iron seam joining front body lining to the facings flat to one side toward side seam and pocket smooth and flat, open bottom of joining seam.					
18.	Baste interlining to coat front a. Baste interlining to coat front from top of out-side breast pocket along front dart seam to top edge of hip pocket welt, across welt to front end of opening and down to bottom of coat. Interlining shall extend well beyond the armholes and shoulders. b. Tack vertical front dart to the interlining. Tack front, back and across top of outside breast pocket stay to interlining. c. Tack hip pocket stay to interlining at front top corner. Tack front edge of hip pocket seam allowance to interlining. d. In addition, baste the interlining to coat front as follows: 1. Across shoulder allowing for placement of shoulder pads. 2. Around armhole and down back edge of interlining. 3. Along breakline of lapel. 4. Down the front edge of interlining to bottom of coat.	Hand or Machine 301 or Hand 301 or Hand Hand or Machine		1-2 1-2	0/3 or commercial 0/3 or commercial	0/3 0/3

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
18.	Baste interlining to coat front (cont'd) e. Position a 5/8 inch wide bridle stay tape adjacent to and behind breakline of each lapel from gorge to 1 to 1-1/2 inches from bottom of lapel. Baste tape even and smooth for a distance of 1-1/2 to 2 inches from gorge, then hold tape taut for a distance of 4 to 5 inches to work in not less than 3/8 inch breast fullness. The balance of the tape shall be stitched without tautness or fullness. Tape and interlining shall be stamped mark to assure amount of fullness. f. Pad (blindstitch) each lapel of coat with 6 to 8 equally spaced rows of stitching with fullness of interlining between the rows of stitching to roll lapel. g. Blindstitch bridle stay along both edges. h. After the lapels are padded, the left and right fronts shall be pressed individually on the left and right coat chest machine respectively to conform to the shape of the body.	Hand or Machine 103 or 306 103 or 306 301	SSm-6 to 8 SSm-2 SSa-1	4-8 4-8 12-16	0/3 0/3 0/3 0/3 0/3	0/3 0/3 0/3
19.	Join side bodies and back a. Join back to side bodies, face to face, 1/2 inch gauge. b. Press seams open and flat.					

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
19.	Join side bodies and back (cont'd) c. Stitch a 3/16 inch wide herringbone tape on back of armhole 1/2 to 3/4 inch from top of shoulder to approximately one inch in back of underarm seam, holding tape taut to draw up material and working in proper fullness. d. Press tape.	301	SSaa-1	12-16	0/3	0/3
20.	Shape lapels and fronts a. Position lapel shaper on breakline of lapel and mark as indicated by the shaper. NOTE: Marking and trimming of lapels, front and bottom may be performed with a clicker machine using dies conforming to the lapel shaper. b. Trim interlining along lapels, fronts and bottom edges 1/4 to 5/16 inch from (coat front) edges. c. The interlining at bottom may be cut diagonally so that the edge is not caught in the tape stitching.					
21.	Baste and join facings to coat front a. Match, fit and baste facing to each front putting in proper lapel and breast fullness. The facings shall be held slightly taut at bottom edges of foreparts. b. Tape on lapel edge shall be sewn natural and smooth without material take-up and held taut from bottom of lapel breakline to bottom edge.	Hand or Machine				

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
21.	Baste and join facings to coat front (cont'd)					
	c. Stitch a 3/8 inch wide silesia cross tape strip to edge of coat front and facing from lapel notch, across top of lapel, down front and across bottom to a point 2 to 3 inches beyond back edge of facing.	301	SSab-1 and LSBj-1	12-16	0/3	0/3
	d. Blind stitch back edge of tape to interlining on fronts and lapels.	103	SSm-1	3-4	0/3	
	e. Press edges flat and smooth, pull basting threads, and press edge seam open and flat.					
	f. Notch corners of lapels, trim around rounded corner of lapels, bottom corners and front edges. Turn facing to finished position, work out lapels and bottom corner of fronts.					
	g. Baste edge (first basting) across and down lapel and front, and the bottom width of facing.	Hand or Machine				
	h. Turn up bottom of coat to finish 1-1/4 (+ 1/8) inches and baste creased edge of hem across bottom of coat matching lengths of vent opening.	Hand or Machine				
	i. Blindstitch complete bottom turn up of coat.	103 or 306 or Hand	EFl-1	6-8	0 (silk) 0 (silk) A (silk)	0 (silk)
	j. Baste facings along lapel fronts (second basting) approximately 1 inch from edge to a point in line with top edge of breast flaps, holding lower corner of coat rolled in such a manner as to cause lower front edge of forepart to roll inward.	Hand or Machine				

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
21.	Baste and join facings to coat front (cont'd)					
	k. Baste a row of stitching diagonally from lapel break to the point of lapel placing fullness in lapel to allow lapel to roll.	Hand or Machine				
	l. Baste along breakline of lapel, allowing fullness in facing, to permit lapel to roll.	Hand or Machine				
22.	m. Baste back edge of facing putting fullness over chest.	Hand or Machine				
	Tack facing to interlining					
	a. Tack the back edge of right facing to the interlining with a row of blindstitching from not more than 2-1/2 inches from the shoulder seam to not more than 2 inches above inside breast pocket opening. Continue the tacking along outer ply of inside breast pocket seam allowance and seam allowance of facing to approximately 2 inches from bottom of coat.	103 or 306 or Hand	SSm-1 SSm-1	2-4 2-4 2-4	0/3 or commercial 0/3 or commercial 0/3 or commercial	
23.	b. Tack the back edge of left facing to interlining with a row of blindstitching from not more than 2-1/2 inches from shoulder seam to approximately 2 inches from bottom of coat.	103 or 306 or Hand	SSm-1 SSm-1	2-4 2-4 2-4	0/3 or commercial 0/3 or commercial 0/3 or commercial	
	Sew shoulder pads					
	Insert shoulder pads between interlining and felt padding and tack to shoulder in proper position.	301 or Hand		1-2 1-2	30/3 or commercial 30/3 or commercial	30/3 or commercial

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
24.	<u>Baste lining</u>					
	a. Tack upper back edge of inside breast pocket to interlining with ends of stitching tacked.	301 or Hand		4-6	0/3 or commercial	0/3
	b. Fit and baste back lining to inside of coat taking in excess material and forming a center back pleat with the fold against the left back. Continue basting across shoulder area and around armhole.	Hand or Machine		3-5	0/3 or commercial	
25.	c. Fit and baste lining to coat front taking in excess material and forming a vertical pleat at each shoulder. Baste around armhole, and down along side seams.	Hand or Machine				
	d. Fold bottom of lining approximately 1 inch and baste to hem of coat. Basting to allow for felling operation.	Hand or Machine				
	e. Trim away lining extending beyond armholes, shoulders, and neck edges of fronts and back.					
25.	<u>Join shoulder seam</u>					
	a. Join respective backs and fronts at shoulder 3/8 inch gauge working in proper fullness on backs.	301	SSa-1	12-16	0/3	0/3
	b. Press shoulder seam open and flat over a suitable block; holding shoulder seam short and shaping armhole end of seam towards the front.					

MIL-U-2416H(SA)

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
26.	<p><u>Baste shoulder</u></p> <p>Position shoulder interlining and lining and baste upper part of each shoulder on outside and turn coat to inside. Turn under edges of back lining at shoulder and baste upper part of each shoulder, continuing basting across neck at back.</p> <p>OR</p> <p>In lieu of basting the lining at the shoulder as required in operations 26, 30a and hand felling as required in operation 31b, the front and yoke lining at shoulder may be trimmed to allow for thickness of the shoulder pad and stitched on the inside.</p>	Hand or Machine	SSa-1	12-16	0/3	0/3
27.	<p><u>Set collar</u></p> <p>a. Seam topcollar to front facing at gorge to a point not less than 1 inch back of lapel breakline.</p> <p>b. Tack gorge seam open catching bridge stay in the tacking.</p> <p>c. Baste undercollar to coat putting in proper fullness over the shoulder.</p> <p>d. Tack outlet at neck to undercollar canvas interlining.</p> <p>NOTE: This operation shall not be performed when the neck edge (gorge seam to gorge seam) of the top collar is machine stitched.</p>	301 301 or Hand Hand or Machine 301 or Hand	SSa-1	12-16 12-16 2-4 4-6 2-3	0/3 0/3 or commercial 0/3 or commercial 0/3 or commercial 0/3 or commercial	0/3 0/3 0/3 or commercial 0/3 or commercial

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
27.	Set collar (cont'd)					
	e. As an alternate (when used in lieu of a braid); form a rayon (lining) hanger by folding the material in half lengthwise with the raw edges turned in face to face and stitched 1/16 inch gauge. The finished hanger loop shall measure 3/16 to 1/4 inch wide.	301	EFp-2	12-16	0/3	0/3
	f. Stitch the ends of a hanger loop (braid or rayon lining) to neck edge with the loop centered over the center back seam.	301		12-16	0/3	0/3
	g. The finished hanger loop shall measure 1-3/4 (+ 1/4) inches between inner edges.					
	h. Turn under lower edge of topcollar and baste across neck. NOTE: This operation shall not be performed when the neck edge (gorge seam to gorge seam) of the topcollar is machine stitched.	Hand or Machine				
	i. Fell undercollar to neckline of coat by hand or machine and tack corners by hand. NOTE: This operation shall be performed after the neck edge (gorge seam to gorge seam) of the topcollar is machine sewn.	Hand or Machine (hand type felling) or 306 Hand	LSa-1 LSa-1	8-10 8-10	C (silk) C (silk)	C (silk)
	j. Tack corners.		LSa-1	8-10 8-10	0 (silk) C (silk)	0 (silk)
	k. Fell or stitch lower edge of topcollar from gorge seam to gorge seam tacking ends of hanger loop.	Hand or 301	SSa-1	8-10 12-16	C (silk) 0/3	0/3

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
27.	<u>Set collar (cont'd)</u> 1. Finished collar shall measure as follows: Collar stand (underside) at center back 1-1/4 (+ 1/8) inches. Collar leaf (between top of stand and outer edge on outside) at center back 1-5/8 (+ 1/8) inches. m. In lieu of operations 27d, 27h, and 27k, stitch lower edge of topcollar across neck from gorge seam to gorge seam.	301	Similar to SSbd-1	12-16	0/3	0/3
28.	<u>Set in sleeves</u> Set sleeves matching front sleeve with front armhole notch and back arm seam with back armhole notch, distributing the fullness.	301	SSa-1	12-16	0/3	0/3
29.	<u>Press armhole seam</u> Press fullness of sleeve flat around the armhole. Press seam open across top from 3/4 to 1 inch above back arm seam 3 to 4 inches forward of shoulder seam. In pressing armhole seam care shall be taken not to stretch or distort armhole.					
30.	<u>Baste and tack armholes</u> a. Baste around outside armholes positioning front and back lining and shoulder pad and back of shoulder in place or back part of armholes may be basted from the lining side. Baste balance of shoulder lining. The shoulder edge of back lining shall be folded under and lapped over the front lining.	Hand or Machine				

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
30.	<u>Baste and tack armholes (cont'd)</u>					
	b. Bind bottom raw edge of underarm shields.	301	BSc-1	12-16	0/3	0/3
	c. Tack all around armhole through all plies of material catching underarm shields at base of armhole. NOTE: When armholes are tacked by machine, a loose but properly formed and elastic stitch may be used, and when so tacked operation 30d may be omitted. When armholes are tacked by hand, tacking shall be backstitched every other stitch from front notch to side (underarm) seam across top of armhole.	Hand or 301		2-4 4-6	30/3 or commercial 30/3 or commercial	30/3 or commercial
	d. Tack across base of armhole from sleeve notch on front to side (underarm) seam.	301	SSa-1	4-6	30/3 or commercial	30/3 or commercial
	e. Trim away excess lining, interlining and shoulder pads.					
	f. Tack sleeve head wadding to armhole from front sleeve notch to back seam of sleeve. The sleeve head wadding shall be positioned with the folded edge adjacent to the edge of armhole, backing cloth side against sleeve and in such a manner as to cause it to fold on itself. The tacking shall be properly distributed. When armhole is tacked by machine, the sleeve head wadding shall be attached in the armhole tacking operation. When sleeve head waddings are tacked by hand, every other stitch shall be backstitched.	Hand or 301		2-4 4-6	30/3 or commercial 30/3 or commercial	30/3 or commercial

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
31.	Complete felling					
	a. Hand fell lining all around armholes. Backstitch pit of armhole from forearm seam of sleeve to side seam areas. The sleeve lining shall be seam on seam with sleeve.	Hand		7 (min)	C (silk)	
	OR					
	The sleeve lining may be stitched to the armhole on the inside from forearm seam of sleeve to the back arm seam across undersleeve.	301	SSa-1	12-16	0/3	0/3
	b. Hand fell lining at shoulder.	Hand		8-10	A or C (silk)	
	c. Hand fell lining along entire opening of sword slit.	Hand		8-10	A or C (silk)	
	d. Hand fell corners of lining and facing at bottom.	Hand		8-10	A or C (silk)	
	e. Hand or machine fell lining to bottom of coat.	Hand or Machine		8-10	A or C (silk)	
	f. Hand tack bottom bound edge of underarm shields on the underside to lining.	Hand		6-10	0 (silk)	0 (silk)
	g. Front edge of inside pocket may be tacked by hand in lieu of operations 15i and 22a. Tack through facing, pocket seam allowance and interlining from corner of pocket opening and down for a distance of not less than 3 inches.	Hand		6-8 per tack 2-4	A or C (silk) A or C (silk)	

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
32.	Press left front Press left front prior to buttonhole operations.					
33.	Mark and stitch buttonholes a. All buttonholes, except where otherwise specified, shall be eyelet end, square bar, cut first type, reinforced with well worked over gimp with the stitching securely caught in the fabric and the ends of the gimp pulled through the underside. Buttonholes shall be clean, correctly positioned and the purling finishing on the outside. b. The ends of all buttonholes shall be tacked by hand or machine with 1/4 inch bartack in a separate operation from buttonhole making; securely catching ends of gimp and covering the width of the bar. c. Mark and stitch three 1 to 1-1/8 inch horizontal buttonholes on left front and one on right front to correspond with center buttonhole on left front. The inside edge of eyelets shall be 5/8 to 3/4 inch from the finished edge and positioned as indicated by marks on pattern. NOTE: Bottom buttonhole shall be located in a line midway between the depth of hip welt pockets. d. Buttonholes shall be measured from inside purled edge of the eyelet.	Bartack or Hand Button-hole	Stitches per size/ in 1 1-1/8	21 per bartack 10-12 per tack Button-hole 53-60 60-70 (not including bartack)	B (silk) B (silk) C (silk)	B (silk) B (silk)

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
34.	<u>Mark and stitch eyelets</u> a. Mark and stitch three 3/16 inch (inside diameter) eyelets in left front where buttons are to be placed; spacing of eyelets shall correspond with respective buttonholes b. Purling shall be on outside.	Eyelet		22 per eyelet	0 (silk)	0 (silk)
35.	<u>Cleaning</u> a. Remove all basting threads. b. All ends of stitching shall be trimmed and loose threads removed from the coat. c. All spots and stains shall be removed. Shade tickets shall be removed without injury to the material except one ticket which shall be used to match coat and trouser of uniform.					
36.	<u>Pressing</u> a. Press edges of lapels, fronts, collar and bottom of coat on edge pressing machine. b. Press right and left fronts on right and left breast machine respectively. c. Sleeves shall be rolled pressed. d. Press balance of fronts, side seams, and back on body machine.					

Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
36.	<p><u>Pressing (cont'd)</u></p> <p>e. Press collar on collar machine stretching outer edge of collar over shoulder area. Collar shall not be short nor too long.</p> <p>f. Press armholes and shoulders on a armhole machine.</p> <p>g. Press armhole solid from the inside creasing armhole from not less than 1/2 inch above backarm seam to not less than 4 inches of shoulder seam. The armpit and back of the armhole shall be held short and pressed flat.</p> <p>h. Press lapels. The creasing of the lapels shall extend a uniform distance from the gorge seam. The lapels shall be roll pressed from midway between the gorge seam to bottom of lapel.</p>					
37.	<p><u>Finish pressing</u></p> <p>a. Press coat lining smooth with a hand iron maintaining creased pleats at front shoulder and center back.</p> <p>b. Block armholes and shrink top sleeve.</p> <p>c. Press any wrinkle missed by previous pressing operations.</p> <p>d. Touch up any areas missed by machine pressing.</p>					

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Table I - Construction of coat (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
37.	<u>Finish pressing</u> (cont'd) e. Remove gloss, creases, and all pressing impressions. f. Place coat on hanger until thoroughly dried.					
38.	<u>Mark and sew buttons</u> a. Hand or machine sewn buttons shall have the thread ends securely tacked off with not less than two stitches and thread ends hidden. Hand or machine sewn plastic buttons shall have the thread tightly wrapped not less than four times around to form a $1/8$ ($\pm 1/16$) inch shank. b. Mark three buttons $5-1/2$ ($\pm 1/8$) inches from front edge of right front to correspond with buttonholes on left front. Sew a 35-line short shank button with eagle upright on each mark through front and interlining. c. Insert shank (regular) of a 35-line button with the eagle upright through each eyelet of left front secured with a bodkin. d. Sew a 30-line button on the left coat front lining to correspond with the buttonhole eyelet in right front. Stitching shall be caught through top ply of fly opening, or the button may be secured in the shank of the corresponding eagle button or as an alternate, the button may be sewn to the shank of the superimposed 35-line metal button.	Hand or Machine		4 per button double thread 14-16 per button 20-24 per button	12/4 or 16/4 20/4 or 20/4 20/4	20/4
		Hand or Machine		4 per button double thread 14-16 per button 20-24 per button	12/4 or 16/4 20/4 or 20/4 20/4	20/4

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Table I - Construction of coat. (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
38.	<p>Mark and sew button (cont'd)</p> <p>e. Sew a 24-line button on the left coat front lining to correspond with buttonhole eyelet in sword vent flap. Stitching shall be caught through sword vent facing.</p>	Hand or Machine		<p>4 per button double thread</p> <p>14-16 per button</p> <p>20-24 per button</p>	<p>12/4 or 16/4</p> <p>20/4 or 20/4</p> <p>20/4</p>	20/4
39.	<p>Attach size ticket (See 3.3.15.3.2).</p>					

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Table II - Construction of trousers

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
1.	<p><u>Cut trousers</u></p> <p>a. See Table I, operations 1a and 1e, as applicable.</p> <p>b. Cut all parts of the trousers including wide facings for side pockets and cord facing pieces for hip pockets out of one piece of material (see operation 1e), except narrow facings for side pockets, hip pocket bearers, belt loops, fly tab pieces, and fly pieces (right and left) which may be cut from ends. The parts cut from ends shall approximately match the main assembly.</p> <p>c. The directional lines on the fronts and backs may vary from the warp direction by not more than 1 inch. Measurements shall be taken at the top and bottom edges of the pattern from the directional line, to the selvage edge of the fabric and the difference between the two measurements shall not exceed 1 inch.</p> <p>d. Cut the stripping for belt loops and buttonhole tab of sufficient width to comply with operation 8.</p> <p>e. See Table I, operation 1e.</p>					
2.	<p><u>Cut silesia linings and buckram</u></p> <p>a. Cut the right fly lining on the straight or on the bias.</p> <p>b. Cut left fly interlining and stay for side pockets in the warp or filling direction.</p>					

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Loop
2.	<p><u>Cut silesia linings and buckram (cont'd)</u></p> <p>c. Cut crotch pieces so that the fold shall be on the bias and one of the inseam sides is in the direction of the warp.</p> <p>d. Cut the silesia for waistband linings and the buckram for the waistband interlinings on the bias and sufficiently wide to comply with operation 20.</p> <p style="text-align: center;">OR</p> <p>e. The waistband linings may be a commercial type using the silesia and buckram material specified.</p>					
3.	<p><u>Cut pockets</u></p> <p>Cut as many pockets as possible in the warp direction.</p>					
4.	<p><u>Replacement of damaged parts</u></p> <p>See Table I, operation 2.</p>					
5.	<p><u>Shade marking</u></p> <p>See Table I, operation 3.</p>					
6.	<p><u>Overedge stitching</u></p> <p>Finished appearance - When a knife is used on serging machine, care shall be exercised that the gauge is properly set so that the edge of fabric is not cut off but the raveled ends are trimmed.</p>					

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
6.	<u>Overedge stitching (cont'd)</u> a. Overedge stitch or serge the inseam and outseam of foreparts of trousers, also fly edge of right forepart. The overedge stitching on the inseam of left forepart shall extend to fly notch. The overedge stitching on outseams of foreparts shall extend from bottom notch of side pocket to bottom of trouser leg. b. Stitch on the foreparts at crotch, a folded triangular lining piece of double thickness of silesia material. The folded lining pieces may be stitched to the foreparts in the overedge operation. c. Overedge stitch or serge inseams, outseams, crotch and seat seam of the backs of the trousers. The side pocket stay piece with the bottom edge turned under may be caught to the back in the overedge operation (see operation 16). d. Overedge stitch or serge the raw edge at left end of waistband.	502 or 503 or 504 301 502 or 503 or 504 502 or 503 or 504	EFD-1 SSA-1 EFD-1 EFD-1	6-10 12-16 6-10 6-10	70/2 70/2 70/2 70/2	70/2 70/2 70/2 0/3
7.	<u>Make stripping for belt loops and buttonhole tab</u> a. Fold stripping (see 1d) with the edges abutted at center and stitch with each row of stitching not less than 1/16 inch from edge and the covering stitch on the underside. The finished stripping shall measure 5/16 to 3/8 inch wide. OR	406	EFH-1	12-16	0/3	0/3

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
7.	Make stripping for belt loops and buttonhole tab (cont'd) b. Fold stripping (see 1d) with both edges turned in and the turned-in edges abutted and with the covering stitch on the underside.	d) 103	EFae-1	12-16	0/3	
8.	Make left hip pocket buttonhole tab a. Cut a piece of the stripping (see operation 7) of sufficient length to comply with operation b. below and to measure 1-1/4 (+ 1/16) inches long when attached to the left hip pocket. b. Fold the piece in half and abut the side edges forming a point. Bartack across the abutted edges at pointed end catching the base of the triangle. Place a second bartack across the abutted edges 5/8 (+ 1/16) inch from the first tack forming a slit buttonhole. The bartacks shall be 3/8 to 1/2 inch long.	Bartack or Automatic loop tacker		28 per bartack 24-28	A or B	A or B
9.	Make fly tab a. Stitch the two fly tab pieces together along the sides and the pointed end. Trim corners and point, turn, force out point and edges and edge stitch 1/16 to 1/8 inch from edge. b. Make buttonhole (see operation 30).	301	SSe-2	12-16	0/3	0/3

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
10.	<p><u>Make side pockets and attach identification label</u></p> <p>a. Place facing and bearer on pocket and stitch along the inner edge with the raw edge turned in, and across the lower end. Selvage need not be turned in. (Ill. A, figure 3).</p> <p>b. Position the identification label on the lower end of the right pocket so that on the finished trouser the label will be on the underply and will face the trouser. Stitch on all four sides. Stitching shall not be through the printing.</p>	301	Lsd-1 and LSbj-1	12-16	0/3	0/3
11.	<p><u>Attach side pockets</u></p> <p>Finished appearance - The edges of pocket openings shall finish smooth and flat without distortion. Pocket openings shall be aligned, uniform in length and shall finish not less than 5-3/4 nor more than 6-1/2 inches between tacks. Avoid notching the pockets on underside beyond the width of the outseam allowance.</p> <p>a. Seam side pockets to fronts as indicated by marks on pattern and notch for pocket opening. Turn with the seam to the back of front edge on underside and stitch 3/16 to 1/4 inch from edge. (Ill. B & C, figure 3).</p> <p>b. Fold pocket right side out. Stitch from step to folded edge of pocket. Notch pocket and facing at top of step and turn. (Ill. D & E, figure 3).</p>	301	SSe-2	12-16	0/3	0/3
		301 or 401	SSae-2(a)	12-16	50/3 or 50/3	50/3 or 0/3 70/2

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Loop
11.	<p><u>Attach side pockets (cont'd)</u></p> <p>c. Tack the ends of opening through bearer with a 1/4 to 3/8 inch tack. The right and left pocket openings shall not be cut out of alignment by more than 1/2 inch. (Ill. F, figure 3).</p>	301		12-16	50/3 or 0/3	50/3 or 0/3
12.	<p><u>Make flies</u></p> <p>Finished appearance - The left fly and right fly shall be interlined and lined with silesia respectively.</p> <p>a. Superimpose left fly on left fly interlining. Stitch back edge of fastener tape to left fly (through interlining) with two rows of stitching. The ends of the scoops shall be 1/4 to 1/2 inch above fly notch when fastener is cut and scoops removed. In the finished trouser the edge of the chain shall be 3/8 to 5/8 inch from edge at top, tapering to 1/4 to 3/8 inch from edge at bottom. (Ill. A, figure 4).</p> <p>b. After fastener is cut and scoops removed, stitch or overedge fastener tape to back edge of right fly, with bottom ends of scoops 1/4 to 1/2 inch above the fly notch. (Ill. B, figure 4).</p> <p>c. Position and stitch fly tab to right fly front edge 3/4 (+ 1/16) inch below top raw edge. Seam lining to the front edge of the right fly to within 1 (+ 1/4) inch from top of fly with fly tab enclosed between the right fly and fly lining. Turn and stitch 1/16 to 1/8 inch from edge. (Ill. C & D, figure 4).</p>	301	ISbj-2	12-16	0/3	0/3
		301 or 504	SSa-1	12-16 6-8	0/3 70/2	0/3 70/2
		301 or 401 and 301	SSe-2(a) SSe-2(a) SSe-2(b)	12-16	50/3 or 0/3 50/3 0/3	50/3 or 0/3 70/2 0/3

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
12.	<u>Make flies (cont'd)</u> d. Overedge the back edge of the left fly and fly interlining together. (Ill. E, figure 4).	503 or 504	SSa-1	6-10	70/2	70/2
13.	<u>Sew on right and left flies</u> Finished appearance - The flies shall be of even lengths where they join the crotch seam. The fastener parts shall be so set that there is no twisting or puckering when fly is closed. The end of right fly lining shall extend not less than 1/2 inch beyond inseam. a. Sew on right fly (slide fastener and fly tab attached with notches matched). (Ill. F, figure 4). b. Sew on left fly (slide fastener attached) with notches matched. (Ill. G, figure 4). c. Turn left fly to the inside with the seam 1/16 to 1/8 inch back of folded edge and press front edge without damage to the fastener. (Ill. H, figure 4).	301 301	LSq-2(a) SSa-1	12-16 12-16	0/3 0/3	0/3 0/3
14.	<u>Stitch darts</u> Finished appearance - The darts shall be carefully tapered and properly pressed to avoid unsightly bulging. The lower end of the dart shall finish in hip pocket opening. a. Seam cut darts at back. b. Press darts open and flat.	301	SSa-1	12-16	0/3	0/3

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Loop
15.	<u>Make hip pockets</u> Finished appearance - The pockets shall be in alignment, and uniform in width and depth. Ends of openings, where the cord facings are turned, shall be neatly finished without raw edges or pleats. The top of the pockets shall extend not less than 1/2 inch into the waistband and be caught in the bottom stitching of the waistband. The finished pocket shall measure 5-1/4 (+ 1/4) inches wide and 6 (+ 1/2) inches deep.					
	a. Turn in lower raw edge of pocket bearer piece and seam to pocket at notches as indicated on pattern. When bearer piece is cut on selvage, the edge need not be turned in. (Ill. A, figure 6).	301	LSd-1	12-16	0/3	0/3
	b. Position cord facing piece on outside as indicated by pattern and seam to trouser through pocket on under side with two rows of stitching. (Ill. B, figure 6).	301	SSv-2	12-16	0/3	0/3
	c. Cut opening between rows of stitching through facing, trousers, and pocket. Turn lower part of facing through cut opening and raise stitch forming a 1/8 to 3/16 inch cord edge. (Ill. C, D & E, fig. 6).	301	SSbe-2(b)	12-16	0/3	0/3
	d. Turn in raw edge of cord facing piece and seam to pocket. When cord facing piece is cut with selvage, the edge need not be turned in. (Ill. E, figure 6).	301	LSd-1	12-16	0/3	0/3
	e. Fold pocket, seam the sides and turn to finished position. (Ill. F, figure 6).	301	SSae-2	12-16	50/3 or 0/3	50/3 or 0/3

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
15.	Make hip pockets (cont'd)					
	f. Smooth out pocket and stitch sides 3/16 to 1/4 inch from edge. Stitching may extend across the bottom folded edge. The ends of the bearer and cord facing piece shall be caught in the edge stitching only. (Ill. G, figure 6).	301	SSae-2(b) and OSf-1	12-16	50/3 or 0/3	50/3 or 0/3
	g. Form a 1/8 to 3/16 inch cord of the facing on the upper edge of pocket opening, insert buttonhole tab at center (1/8 inch off center tolerance) on left hip pocket, and raise stitch the seam through trouser, cord facing piece, pocket bearer and pocket, closing top of pocket. (Ill. H, figure 6).	301	LScc-2(b)	12-16	0/3	0/3
	h. Tack ends of pocket opening 1/4 to 3/8 inch through cord, bearer and pocket.	301		12-16	0/3	0/3
	i. Operations b and first sentence (requirement) of operation c above may be accomplished with a double piped pocket machine which stitches, cuts, and turns piped edges in one operation. When this machine is used, the welt piece may be trimmed to permit insertion into the machine and the machine manufacturer's recommended pocket stay material may be used. Raise stitch the joining seam of lower piping piece through back of trousers and piping piece only. Raise stitch the joining seam of the top piping piece through all plies closing the top of pocket. The ends of the pocket openings shall be securely tacked.	101 and 301		12-16	A/3 or 0/3 or 50/3	0/3 or 50/3

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
16.	<p><u>Join outseams</u> Finished appearance.- The outseams shall be carefully joined with notches matching to avoid twisting and puckering. The seams shall start and finish evenly.</p> <p>a. Join the outseams with notches matching, catching pocket stay pieces, with the bottom raw edge of the stay pieces turned in, if not previously caught in overedge operation (see operation 6c).</p>	301 or 401	SSa-1	12-16	0/3	50/3
17.	<p><u>Press outseams</u> Press outseams open and flat from bottom to top of trousers with the pocket stay piece folded over the open seam.</p>					
18.	<p><u>Finish side pockets</u> Turn in back edge of side pocket and stay piece and stitch 3/16 to 1/4 inch along outseam allowance with the stitching continued to folded edge at bottom with end of stitching securely backstitched. (Ill. G, figure 3).</p>	301	SSc-1 and SSae-2(b)	12-16	50/3 or 0/3	50/3 or 0/3
19.	<p><u>Seam waistband and set belt loops</u> Finished appearance - The waistband shall be sewn without fullness, gathers, or pleats. The waistband shall have the belt loops correctly positioned with one end inserted and securely caught in the stitching. The waistband shall be uniform in width and finish 1-3/4 (+ 1/8) inches wide.</p>					

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
19.	<p>Seam waistband and set belt loops (cont'd)</p> <p>a. There shall be seven belt loops for sizes up to and including 37 and eight belt loops for sizes 38 and up. Loops shall be positioned as follows: One on each front positioned in accordance with notches on patterns. One at each side seam of trousers (on backs). One centered between side seam and seat seam. One at seat seam. The extra loop for larger sizes positioned on right front $1-1/2 (+ 1/8)$ inches from back edge of right fly joining seam.</p> <p>b. Seam on left and right waistbands, catching ends of belt loops in their proper position, except center back loop.</p> <p>c. Press waistband seams open and flat.</p> <p>NOTE: The waistband lining may be attached to the waistband (operation 20) prior to setting to waist edge.</p> <p>d. Drop loops and securely stitch or bartack the loops $1/4 (+ 1/8)$ inch below waistband seam. The bartacking shall not be wider than the width of loops and shall be hidden by loops when trousers are finished.</p>	301	LSbd-2(a)	12-16	0/3	0/3
20.	<p>Make and join waistband linings</p> <p>Finished appearance - The waistband lining shall be silesia material interlined with buckram. The waistband lining shall measure not less than $2-1/4$ inches wide in the finished trousers.</p>	301 or Bartack or Automatic Loop Tacker		12-16 28 per bartack 24-28	0/3 A or B A or B	0/3 A or B A or B

Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
20.	Make and join waistband linings (cont'd) a. Overlap silesia on buckram 1 inch and stitch 1/8 to 3/16 inch from edge of silesia. Fold silesia over buckram and press. b. A commercial waistband conforming to specified requirements may be used (see operation 2e). c. Turn under top edge of waistband lining and stitch to top edge of waistband catching buckram interlining with a row of simulated hand felled stitches or waistband lining may be turned under and felled by hand. d. (Applicable when option to extend lining to right end of waistband is exercised.) Continue the stitching of the fly lining to the top of the waistband. e. (Applicable when option to extend lining to right end of the waistband is exercised.) Turn right end of the waistband lining to the outside and stitch to the front edge of the waistband.	101 or 301 or 401 304 or 404 or Hand 301 or 401 301 or 401	LSa-1 SSe-2(a) SSe-2(a)	6-10 12-16 12-16 6-8 12-16 12-16	50/3 50/3 50/3 50/3 50/3 50/3 50/3 50/3 50/3 50/3	50/3 70/2 50/3 50/3 50/3 70/2 50/3 70/2
21.	Attach hook and eye a. Position the hook on the center (1/4 inch off tolerance) of the left waistband with the rolled edge of the hook aligned with the slide fastener scoops. Attach through a suitable reinforcement. b. Position the eye on the center of the right waistband, aligned with the slide fastener scoops, to correspond with the hook of the left waistband. Attach through a suitable reinforcement.					

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
21.	Attach hook and eye (cont'd) NOTE: When hook and eye are engaged, on the finished trousers, the closure shall not bulge, pucker or twist.					
22.	Finish right and left flies. Finished appearance - The top corner of the right or left (as applicable) fly shall be neatly and completely forced out to present a smooth appearance. The right fly lining shall lie smooth and flat without pleats. Care shall be taken in finishing the top of the left fly to avoid bulkiness. The finished seaming of the left fly shall be uniform in width with the fly smooth and flat, without gathers or pleats. The joining seam of the left fly to forepart shall not be exposed on outside of trousers. The base of the fly shall be so finished so as to avoid twisting, pleating, or puckering. The crotch and seat seam shall be properly spread when the right fly lining is stitched.	301	SSe-2 (shows finished seam)	12-16	0/3	0/3
	a. Continue seaming the front edge of the right fly and fly lining to top edge of waistband across to back edge of fly lining. Trim, turn and work out corner and single stitch 1/16 to 1/8 inch from edge. The edge stitching shall conform to stitching on edge of fly. (Ill. J, figure 5).	301	LSq-2(b) (shows finished seam)	12-16	0/3	0/3
	b. Turn in back edge of right fly lining and raise stitch seam of fly through front, fastener tape and fly lining, and continue stitching on top of waistband. (Ill. J, figure 5).					

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
22.	<u>Finish right and left flies (cont'd)</u> c. Turn back end of left waistband, in line with the vertical fly joining seam and stitch across top edge of waistband, the width of the fly. Trim, turn and work out point. (Ill. K, figure 5). d. Insert end of waistband lining under the left fly and seam back edge of left fly through front from notch to top of waistband 1-1/2 (+ 1/8) inches. (Ill. K, figure 5).	301 301	SSa-1	12-16 12-16	0/3 0/3	0/3 0/3
23.	<u>Join inseams</u> Finished appearance - The inseams shall be carefully joined with notches matching to avoid twisting and puckering. The seams shall start and finish evenly. a. Join inseams with notches matching forming outlets as indicated on pattern.	301 or 401	ISr-2(a) and SSa-1	12-16	0/3 0/3	0/3 70/2
24.	<u>Press inseams</u> Press inseams open and flat.					
25.	<u>Join seat seam</u> Finished appearance - The seat seam shall be joined with stitch tension of sufficient elasticity to meet with strain encountered in sitting or stooping. The waist shall be measured before the seat seam is joined to assure correct waist size. In the joining of the seat seam the inseams shall meet. The base of the left fly shall cover the right fly on outside of the finished trousers.					

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
25.	Join seat seam (cont'd) a. Join seat seam from base of fly to end of waistband lining with a double needle seat seam with the rows of stitching 1/64 to 1/32 inch apart. The seam from the waistband joining seam to the end of the waistband lining shall be perpendicular (90° angle) to the waistband joining seam. b. Press crotch and seat seam open and flat.	401	SSa-2	8-10 each needle	0/3	70/2
26.	Finish waistband and attach size label Finished appearance - The finished waistband shall be uniform in width and the lining smooth without twisting, pleating, or puckering. The lining shall not be exposed beyond the top of waistband. a. Top of waistband shall be basted or pressed prior to top stitching of waistband seam. b. Stitch the top edge of the size label to lower edge of waistband lining above the right hip pocket. c. Topstitch the waistband seam 1/16 inch from joining seam on trousers side (not through waistband) catching waistband lining with top of pockets properly positioned and smoothed out and the ends of the waistband lining at center back folded in. Pockets may be stitched or basted to waistband seam allowance prior to the top stitching of waistband seam. The topstitching shall extend to the stitch of the left fly (not across fly) except when option to extend waistband lining to right end of waistband is exercised, the stitching shall extend across the right fly.	301 301	LSbd-2(b)	12-16 12-16	0/3 0/3	0/3 0/3

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
26.	<p>Finish waistband and attach size label (cont'd)</p> <p>OR</p> <p>d. (Applicable when option to extend waistband lining to right end of waistband is exercised.) Turn right fly lining to the inside and stitch 1/16 to 1/8 inch from the front edge; continue the stitching along front end of waistband and down to meet back of right fly; turn in raw edge of fly lining and raise stitch the fly joining seam catching the fly lining in the stitching.</p>	301	SSe-2(b) or LSq-2(b)	12-16	0/3	0/3
27.	<p><u>Assemble fasteners</u></p> <p>Finished appearance - The fasteners shall be so assembled that the ends of the chain are even.</p> <p>a. Attach slider and staple bottom of fastener together.</p>					
28.	<p><u>Stitch right fly extension piece</u></p> <p>Finished appearance - The crotch and seat seams shall be properly spread when the right fly extension piece is stitched.</p> <p>a. Turn in raw edges of right fly lining extension piece and hand fell or seam by machine to each side of crotch seam. (Ill. L, figure 5).</p>	301 or Hand	SSac-3 (b, c, d)	12-16 6-8	50/3 50/3	50/3
29.	<p><u>Attach belt loops</u></p> <p>Finished appearance - All belt loops shall measure 1-7/8 (+ 1/8) inches from tacking to folded edge of loop. The tacking shall extend the width of the loops but not beyond.</p>					

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
29.	Attach belt loops (cont'd) a. Turn in raw edges of belt loops (except center back loop) and securely seam or bartack at top of waistband. b. Turn under top end of belt loop, position over seam with the top of the waistband stitch, tack or bartack to trousers 1/16 to 1/8 inch from folded edge. c. Turn under bottom end of belt loop and bartack to trousers 1/4 (\pm 1/8) inch below waistband.	301 or Bartack or Automatic Loop Tacker	SSb-1 LSd-1	12-16 28 per bartack 24-48 12-16 28 per bartack 24-28	0/3 A or B A or B 0/3 A or B A or B	0/3 A or B A or B 0/3 A or B A or B
30.	Make buttonholes Finished appearance - Buttonhole shall be clean cut, well made and correctly positioned. Buttonhole shall be eyelet end, taper bar type, cut after, worked over gimp with the ends of the buttonhole stitching and gimp securely tacked. The stitching shall be securely caught in the fabric with the purling on the outside, except the right fly tab buttonhole where the purling shall be on the inside.	301 or Bartack or Automatic Loop Tacker	LSd-1	12-16 28 per bartack 24-28	0/3 A or B A or B	0/3 A or B A or B

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Table II - Construction of trousers -(cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
30.	Make buttonholes (cont'd) Make buttonhole at pointed end of tab, as indicated by pattern, with the inside edge of the eyelet 5/8 to 3/4 inch from point.	Button-hole		52-54 per button-hole including tack	A or B	A or B
31.	Mark or gauge and sew on buttons Finished appearance - The buttons shall be properly aligned with buttonholes. Hand or machine sewn buttons shall have the thread tightly wrapped not less than four times around to form a 1/8 (+ 1/16) inch shank. The thread ends shall be hidden and securely tacked off with not less than two stitches. a. Sew a 22-line button on left waistband lining to correspond with fly tab buttonhole. The stitches shall not be visible on the outside. b. Sew a 22-line button on the left hip pocket through facing and pocket to correspond with button-hole tab.	Hand or Machine		4 per button double thread 14-16 per button or 20-24 per button 4 per button double thread 14-16 per button or 20-24 per button	12/4 or 16/4 20/4 20/4 12/4 or 16/4 20/4 20/4	20/4 20/4

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Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
32.	<u>Bartacking</u> Finished appearance - The bartacks shall be well made and correctly placed to reinforce points of strain as specified. The bartacks at side pocket openings shall extend 1/16 to 1/8 inch beyond the outseams. a. Bartack all pockets at ends of pocket openings. The bartacks shall be perpendicular to the opening. b. Bartack at base of fly at the junction of the crotch seam and fly. The bartack may be diagonal, in line with the left stitching, or may be horizontal and extend 1/16 to 1/8 inch beyond the crotch seam. (Ill. M, figure 5). c. All bartacks on pockets and at base of fly shall be made by machine and shall be 3/8 to 1/2 inch long.	Bartack Bartack		28 per bartack 28 per bartack	A or B A or B	A or B A or B
33.	<u>Finish trouser bottoms</u> Overedge stitch or pink leg bottoms.	502 or 503 or 504	EFd-1	6-10	70/2	70/2
34.	<u>Cleaning</u> a. See Table I, operation 35, as applicable. b. Trim ends.					
35.	<u>Pressing</u> a. Press smooth the tops of trousers, including fly and pockets.					

Table II - Construction of trousers (cont'd)

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Needle	Bobbin or Looper
35.	<u>Pressing (cont'd)</u> b. Press smooth and crease the legs with the seams matching at the bottom and in the crotch; or the in-seam in the crotch may be slightly back of the out-seam.					
36.	<u>Assemble trousers</u> a. Close slide fastener, button fly tab, and left hip pocket, and secure hook and eye in waistband. b. Attach size ticket (see 3.3.15.3.2).					

3.8 Sizes and measurements.- Sizes and measurements of finished coat shall be as shown in Table III and of finished trousers as shown in Table IV and IVA (see figures 1 and 2). All measurements are expressed in inches.

Table III - Measurement of coat

Sizes	(A)		Waist (B)		Coat length (C)			Sleeve length (D)		
	Chest	Type I	Standard	Small	Type II	Short	Regular	Long	Ex-long	Short
33	36	32	30	27-7/8	29-3/8	30-7/8	32-3/8	16	17	18
34	37	33	31	28	29-1/2	31	32-1/2	16	17	18
35	38	34	32	28-1/8	29-5/8	31-1/8	32-5/8	16	17	18
36	39	35	33	28-1/4	29-3/4	31-1/4	32-3/4	16	17	18
37	40	36	34	28-3/8	29-7/8	31-3/8	32-7/8	16	17	18
38	41	37	35	28-1/2	30	31-1/2	33	16	17	18
39	42	38	36	28-5/8	30-1/8	31-5/8	33-1/8	16	17	18
40	43	39	37	28-3/4	30-1/4	31-3/4	33-1/4	16	17	18
41	44	40	38	28-7/8	30-3/8	31-7/8	33-3/8	16	17	18
42	45	41	39	29	30-1/2	32	33-1/2	16	17	18
43	46	42	40	29-1/8	30-5/8	32-1/8	33-5/8	16	17	18
44	47	43	41	29-1/4	30-3/4	32-1/4	33-3/4	16	17	18
45	48	44	42	29-3/8	30-7/8	32-3/8	33-7/8	16	17	18
46	49	45	43	29-1/2	31	32-1/2	34	16	17	18
47	50	46	44	29-5/8	31-1/8	32-5/8	34-1/8	16	17	18
48	51	47	45	29-3/4	31-1/4	32-3/4	34-1/4	16	17	18

Tolerance ± 1 ± 1 ± 1 $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$ $\pm 1/2$

NOTE: Chest, waist, and length of coat measurements shall be taken with coat fully buttoned, placed smooth and flat.

- A. Chest - Twice the measurement taken across front at the base of armholes from folded edge to folded edge.
- B. Waist - Twice the measurement taken across front at level of middle row of buttons from folded edge to folded edge.
- C. Coat length - Measurement taken from the base of undercollar (seam), down center back to bottom of coat.
- D. Sleeve length - Measurement taken from the base of the armhole, along inseam to bottom of sleeve.

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Table IV - Measurement of trousers

Coat size for pairing with trousers	Waist size (A)		(B) Seat	Inseam (unhemmed) (C)			
	Standard (Type I)	Small (Type II)		Short	Regular	Long	X-Long
33	27	25	37	32	34	36	38
34	28	26	38	32	34	36	38
35	29	27	39	32	34	36	38
36	30	28	40	32	34	36	38
37	31	29	41	32	34	36	38
38	32	30	42	32	34	36	38
39	33	31	43	32	34	36	38
40	34	32	44	32	34	36	38
41	35	33	45	32	34	36	38
42	36	34	46	32	34	36	38
43	37	35	47	32	34	36	38
44	38	36	48	32	34	36	38
45	39	37	47	32	34	36	38
46	40	38	48	32	34	36	38
47	41	39	49	32	34	36	38
48	42	40	50	32	34	36	38
<hr/>							
Tolerance	$\pm 1/2$	$\pm 1/2$	$+ 1/2$ $- 1$	$+ 1$ $- 1/2$	$+ 1$ $- 1/2$	$+ 1$ $- 1/2$	$+ 1$ $- 1/2$

NOTE: Measurements for waist and seat shall be taken with slide fastener fully closed, fly buttoned and hook and eye secured. Trousers shall be laid out smooth and flat.

- A. Waist - Twice the measurement taken across top edge of waistband from folded edge to folded edge.
- B. Seat - Twice the measurement taken 1 inch above fly bartack from folded edge to folded edge.
- C. Inseam - Measurement shall be taken from junction of seams (crotch) along inseam to bottom unhemmed trouser leg. An allowance of 3 inches for hem is included in the inseam length.

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Table IVA - Knee and bottom measurements for trousers

Coat size	Waist size		Knee (D)				Bottom (E)			
	Std.	Small	Short	Regular	Long	X-Long	Short	Regular	Long	X-Long
33	27	25	9-3/8	9-5/8	9-7/8	9-7/8	8-5/8	8-7/8	9-1/8	9-1/8
34	28	26	9-1/2	9-3/4	10	10	8-5/8	8-7/8	9-1/8	9-1/8
35	29	27	9-5/8	9-7/8	10-1/8	10-1/8	8-3/4	9	9-1/4	9-1/4
36	30	28	9-3/4	10	10-1/4	10-1/4	8-3/4	9	9-1/4	9-1/4
37	31	29	9-7/8	10-1/8	10-3/8	10-3/8	8-7/8	9-1/8	9-3/8	9-3/8
38	32	30	10	10-1/4	10-1/2	10-1/2	8-7/8	9-1/8	9-3/8	9-3/8
39	33	31	10-1/8	10-3/8	10-5/8	10-5/8	9	9-1/4	9-1/2	9-1/2
40	34	32	10-1/4	10-1/2	10-3/4	10-3/4	9	9-1/4	9-1/2	9-1/2
41	35	33	10-3/8	10-5/8	10-7/8	10-7/8	9-1/8	9-3/8	9-5/8	9-5/8
42	36	34	10-1/2	10-3/4	11	11	9-1/8	9-3/8	9-5/8	9-5/8
43	37	35	10-5/8	10-7/8	11-1/8	11-1/8	9-1/4	9-1/2	9-3/4	9-3/4
44	38	36	10-3/4	11	11-1/4	11-1/4	9-1/4	9-1/2	9-3/4	9-3/4
45	39	37	10-7/8	11-1/8	11-3/8	11-3/8	9-3/8	9-5/8	9-7/8	9-7/8
46	40	38	11	11-1/4	11-1/2	11-1/2	9-3/8	9-5/8	9-7/8	9-7/8
47	41	39	11-1/8	11-3/8	11-5/8	11-5/8	9-1/2	9-3/4	10	10
48	42	40	11-1/4	11-1/2	11-3/4	11-3/4	9-1/2	9-3/4	10	10

Toler-
ance

$\pm 1/4$	$\pm 1/4$	$\pm 1/4$	$\pm 1/4$	$\pm 1/4$	$\pm 1/4$	$\pm 1/4$	$\pm 1/4$	$\pm 1/4$
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D. The location of knee measurements shall be within 18-7/8 to 19-3/8 inches from bottom of trousers for Shorts, 19-7/8 to 20-3/8 for Regulars, 20-7/8 to 21-3/8 inches for Longs, and 21-7/8 to 22-3/8 for X-Longs. Measure from folded edge to folded edge.

E. Measure along (unhemmed) bottom edge of leg from folded edge to folded edge.

3.9 Workmanship.- The finished uniforms 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 or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier 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.

4.1.1 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 First article inspection.— The first article, submitted in accordance with 3.2, shall be inspected as specified in 4.3.2 for compliance with design, construction, workmanship and dimensional requirements.

4.3 Inspection.— Inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated.

4.3.1 Component and material inspection.— In accordance with 4.1, components and materials shall be inspected and 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 purchase document. In addition, the supplier shall furnish a certificate of compliance for the resin treatment requirements of 3.3.3 and 3.3.12.2, the colorfastness requirements of 3.3.9 and the hook and eye requirements of 3.3.18.

4.3.2 Examination of the end item.— Examination of the end item shall be in accordance with 4.3.2.1 thru 4.3.2.3. The applicable inspection levels and acceptable quality levels (AQL's) shall be as indicated in 4.3.2.3. The lot size shall be expressed in units of uniforms. The sample unit shall be one finished uniform, coat, or trouser, as applicable.

4.3.2.1 Visual examination.— The uniforms shall be examined for defects in color, design, material, construction, workmanship and marking and the defects classified in accordance with 4.3.2.1.1, 4.3.2.1.2, and 4.3.2.1.3.

4.3.2.1.1 General defects (coat and trouser).—

Defects	<u>Classification</u>	
	Major	Minor
	A	B

BARTACKS OR BACKTACKS (except buttonhole bartacks)

a.	When bartacks or backtacks are the only means of stitching a part to a garment; missing, insecure, or misplaced not serving intended purposes:		
	-one bartack or backtack		X
	-two or more bartacks or backtacks	X	
b.	When bartack or backtack is used to reinforce a given point, missing, insecure, or misplaced not serving intended purpose:		
	-one bartack or backtack		X
	-two or more bartacks or backtacks	X	
c.	Bartack less than 3/8 inch or more than 1/2 inch long (except on belt loops and sword vent opening)		X

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Defects	Classification		
	Major	Minor	
		A	B
BUTTONHOLES AND EYELETS			
a. Stitching not securely caught in fabric, causing stitching to pull away from fabric	X		
b. Not corresponding to size of button: -too small, not permitting button to enter buttonhole -too large, 3/8 inch or more longer than the diameter of button (measured from inside edge of purling)	X		X
c. One or more omitted or added	X		
d. Bartack omitted or loose on square-bar type buttonhole: -one buttonhole -two or more buttonholes			X
	X		
e. Wrong type or uncut buttonhole			X
f. Bartack misplaced on square-bar type buttonhole not serving intended purpose on: -one buttonhole -two or more buttonholes			X
	X		
g. One or more broken stitches in: -one buttonhole or eyelet -two or more buttonholes or eyelets			X
	X		
h. More than two skipped stitches in: -one square-bar type buttonhole, or eyelet -two or more square-bar type buttonholes, or eyelets -one or more tapered-bar buttonholes			X
			X
		X	
i. Gimp omitted in one or more buttonholes or ends of gimp not pulled through underside (when applicable)			X
j. Ragged edges			X
k. Buttonhole stitching extending beyond bartack on one or more square-bar type buttonholes			X
l. One or more buttonholes or eyelets finished with the purling on the reversed side (except right fly tab of trousers)			X
m. Purling finished on outside of right fly tab of trousers			X

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Defects	Classification		
	Major	Minor	
		A	B

BUTTONHOLES AND EYELETS (cont'd)

n.	Stitches per buttonhole (not including bartack) less than the minimum specified:		
	-one or two stitches		X
	-three or more stitches	X	
o.	Ends insecurely tacked on one or more tapered-bar type buttonholes		X
p.	Any buttonhole poorly repaired		X

BUTTONS AND BODKINS

a.	<u>Coat</u>		
1.	Missing, loose, broken or defective:		
	-one button or bodkin		X
	-two or more buttons or bodkins	X	
2.	Type, size, color or finish other than specified		X
3.	Shank wrapping and tacking omitted or insecure on one or more buttons, as applicable		X
4.	One or more buttons sewn with the spread wings of the eagle other than in an upright position		X
5.	Parts of garments pleated or puckered by button sewing		X

NOTE: Metal buttons shall be considered defective if they have sharp, rough, cracked or split edges; scratches, dents, blemished, or imbedded foreign matter, loose shanks or shells, or are poorly plated or badly shaded.

b.	<u>Trousers</u>		
1.	Missing, insecurely sewn, broken or defective:		
	-one button		X
	-two buttons		X
2.	Shank wrapping and tacking omitted or insecure on inside left waistband lining or left hip pocket		X
3.	Not specified type, size, color or finish		X

CLEANNESS

a.	Any spot or stain clearly noticeable:		
	-on outside	X	
	-on inside		X
b.	Thread ends not trimmed throughout garment or one or more bastings not removed or two or more shade tickets not removed, except one on coat and trousers for matching purposes		X

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Defects	Classification		
	Major	Minor	
		A	B

CLEANNESS (cont'd)

c. Any shade markings exposed and visible on outside of uniform	X		
d. Bartack end of two or more belt loops untrimmed			X
e. Residue of monofilament synthetic thread not brushed off or removed from coat			X

COMPONENT AND ASSEMBLY

a. Any defective component or defect of assembly (not otherwise classified herein)	X		
b. Any component part or required operation omitted (not otherwise classified herein)	X		

CUTTING

Any component parts not cut in accordance with directional lines indicated on patterns or not in conformance with specification requirements

X

MATERIAL DEFECTS AND WORKMANSHIP DAMAGES

a. Hole, cut, tear, needle chew or exposed drill hole:			
1. On outside - any	X		
2. On inside (overall dimension in any direction):			
-up to 1/8 inch (inclusive)			X
-more than 1/8 inch		X	
b. Visible mend, darn or patch:			
1. On outside of coat or trousers - any	X		
2. On inside of coat or trousers			
-up to 1/4 inch (inclusive)			X
-more than 1/4 inch		X	
c. Weakening defects:			
1. Smash	X		
2. Multiple float or loose slub:			
-on outside of coat or trousers	X		
-on inside of coat or trousers		X	

MIL-U-2416H(SA)

Defects	Classification		
	Major	Minor	
		A	B
MATERIAL DEFECTS AND WORKMANSHIP DAMAGES (cont'd)			
d. Permanent crease in cloth (when crease is caught in seaming or stitching)	X		
e. Unsightly slub or shade bar:			
1. On outside of coat or trousers	X		
2. On inside of coat or trousers			X
f. Pulled or snagged thread(s):			
1. On outside of coat or trousers	X		
2. On inside of coat or trousers			X
PRESSING			
a. General (coat or trousers)			
1. Burned or scorched	X		
2. Pressing omitted		X	
3. Poorly pressed (unless otherwise classified):			
-coat		X	
-trousers			X
4. Basting or pressing impressions not removed			X
5. Gloss marks not removed throughout major portion of coat or trousers			X
b. Coat			
1. Lapel, front or collar edge bulky, or not pressed solid			X
2. Lapels not roll pressed			X
3. Armhole seam not pressed open across top as required		X	
4. Sleeve not roll pressed		X	
5. Armhole badly stretched	X		
6. Collar breakline not creased		X	
7. Armhole not blocked or improperly blocked distorting hang of sleeve		X	
8. Front dart and back pleat not pressed open		X	
9. Inside of armhole not creased or not creased solid			X
c. Trousers			
1. Legs not pressed seam on seam at bottom of trousers by more than 1/2 inch or more than 1 inch at crotch			X
2. Back darts, outseams, waistband seaming, inseams, crotch or seat seams not pressed open		X	

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
		A B
SEAMS AND STITCHING		
a. Accuracy of seaming		
1. Seams puckered, irregular, or wavy		X
2. Any part of coat or trousers caught in any unrelated operation or stitching	X	
3. Unsightly felling or blindstitching exposed and visible on the outside of coat		X
4. Ends of seams or stitchings when not caught in other seams or stitching backtacked less than 3/8 inch (301 stitch type)		X
5. Thread breaks secured by stitching back of the break less than 1/2 inch		X
6. Wrong shade of thread or various shades of thread used on outside of same coat or trousers	X	
b. Gauge of stitching (edge or raised stitching)		
1. Irregular, unevenly gauged or corresponding stitchings not uniformly gauged		X
2. Edge or raise stitching sewn too close to edge, resulting in damage to cloth		X
3. Not within range of gauge specified or varies more than 1/16 inch when no gauge is specified		X
c. Open seams		
1. On outside of coat:		
a. Gorge seam, lapel and front edge or seam joining welt to front:		
-less than 1/8 inch		X
-1/8 inch or more but not more than 1/4 inch		X
-more than 1/4 inch	X	
b. All other seams:		
-less than 1/4 inch		X
-1/4 inch or more but not more than 1/2 inch		X
-more than 1/2 inch	X	
2. On inside of coat:		
a. Seam joining inside pocket to facing-lining assembly:		
-1/8 inch or less		X
-more than 1/8 inch but not more than 1/4 inch		X
-more than 1/4 inch	X	
b. All other seams (except machine or hand felling):		
-1/4 inch or more but not more than 1/2 inch		X
-more than 1/2 inch		X
c. Machine or hand felling:		
-1/2 inch or more but not more than 1 inch		X
-more than 1 inch		X

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
		A B
SEAMS AND STITCHING (cont'd)		
3. Trousers		
a. On seat or crotch seam:		
-1/8 inch or less on one row of stitching		X
-more than 1/8 inch but not more than 1/4 inch on one row of stitching		X
-more than 1/4 inch on one row of stitching	X	
-any open seam on both rows of stitching at the same place	X	
b. All other seams:		
-1/8 inch or more but not more than 1/4 inch		X
-more than 1/4 inch but not more than 1 inch		X
-more than 1 inch	X	
d. Raw edges		
1. On outside of coat:		
-less than 1/8 inch		X
-1/8 inch or more but not more than 1/4 inch		X
-more than 1/4 inch	X	
2. On the inside of coat (excluding raw edge of bindings):		
-1/4 inch or less on the inside pocket in joining to facing-lining assembly		X
-more than 1/4 inch on inside pocket in joining to facing-lining assembly	X	
-more than 1/4 inch except on inside pocket in joining to facing-lining assembly		X
-raw edge of binding (sweat shield) more than 1/2 inch		X
3. On the outside of trousers:		
-more than 1/4 inch but not more than 3/4 inch		X
-more than 3/4 inch	X	
4. On the inside of trousers:		
-more than 1 inch		X
-any raw edge on inside caused by the omission of overedge stitching for a distance of more than 3 inches		X
e. Seam and stitch type		
1. Seam type or stitch type not as specified	X	
2. Looper thread or 401 or 406 stitch type finishing on outside of trousers	X	

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Defects	Classification	
	Major	Minor
	A	B

SEAMS AND STITCHINGS (cont'd)

f. Stitch tension		
1. Loose tension resulting in a loose seam	X	
2. Loose tension on edge, top or raise stitching resulting in loosely exposed bobbin thread or top thread		X
3. Tight tension (stitches break when normal strain is applied to seam or stitching)	X	
g. Stitches per inch (to be scored only when the condition exists on major portion of seam or stitching):		
1. Less than the minimum specified (except on felling, serging, and label stitching)		X
2. More than the maximum specified		X
3. On felling, serging, and label stitching: -one or more stitches less than the minimum specified		X
h. Stitches skipped or broken (on edge, top or raise stitching, when seam is seamed, turned and stitched):		
-1/4 inch but not more than 1/2 inch		X
-more than 1/2 inch	X	

SHADED PARTS

a. Any outside part shaded (except parts which may be cut from ends)	X	
b. Any lining part shaded (except sleeve lining)		X
c. Sleeve lining parts badly shaded or pair of sleeve linings not matching each other		X
d. Badly shaded belt loops:		
-one belt loop		X
-two or more belt loops	X	
e. Other parts cut from ends badly shaded		X

4.3.2.1.2 Detailed defects (coat).- Assembled coat. Examine, holding coat in hands, spread out on table or place on form when available.

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B

ALIGNMENT OF FRONT BUTTONS AND BUTTONHOLES

- | | | |
|--|---|---|
| a. Not aligned causing a noticeable bulge or twist on front when buttoned | | X |
| b. Buttons on left front not in horizontal alignment with buttons on right front by: | | |
| -1/2 inch or more but not more than 1 inch | | X |
| -more than 1 inch | X | |

LENGTH OF BUTTONED FRONTS

- | | | |
|--|---|---|
| a. Left front shorter than right front at bottom corner by: | | |
| -1/8 inch or more but not more than 1/4 inch | | X |
| -more than 1/4 inch | X | |
| b. Left front longer than right front at bottom corner by: | | |
| -more than 1/4 inch but not more than 3/8 inch | | X |
| -more than 3/8 inch | | X |
| c. Bottom corner of right front exposed beyond bottom edge of left front by: | | |
| -more than 1/8 inch | | X |

CONSTRUCTION OF FRONTS

- | | |
|---|---|
| a. Fronts not properly shaped or constructed, causing left fronts to fall at an angle either forward or backward of intended position | X |
| b. Left front rolling outward below bottom front button, when buttoned | X |

COLLAR (construction and setting)

- | | |
|--|---|
| a. Collar setting | |
| 1. Short, i.e., causing puckers on back or fronts or pulling lapel breakline causing fronts to roll out | X |
| 2. Long, i.e. setting away from neck, collar not fitting neck; or lapel rolling higher than 2 inches above top front button or buttonhole edge | X |
| 3. Collar not properly set, causing a decided curve or bulge on creaseline at joining to gorge seam | X |
| 4. Tight at joining to gorge seam or across back, causing fullness on lapels, or fullness or pleats across outside of back | X |

MIL-U-2416H(SA)

Defects	Classification		
	Major	Minor	
		A	B
COLLAR (construction and setting) (cont'd)			
b. Collar edge			
1. Collar edge short across shoulders, causing collar to rise above creaseline by:			
-1/4 inch or more but not more than 1/2 inch		X	
-more than 1/2 inch	X		
2. Irregular			X
3. Undercollar exposed along collar edge (to be scored only when the condition exists along major portion of seam)	X		
4. Undercollar edge more than 1/8 inch from topcollar edge (to be scored only when the condition exists along major portion of seam)			X
5. Tacking on corners of undercollar to lapel omitted or insecure		X	
c. Collar ends			
1. Collar ends uneven in length by:			
-1/4 inch or more but not more than 1/2 inch		X	
-more than 1/2 inch	X		
2. Pointed corners of collar poorly shaped, not of uniform shape or size		X	
d. Topcollar			
1. Tight, i.e., causing edges to curl or bulging on undercollar	X		
2. Twisted, i.e., having a diagonal twist	X		
3. Full, i.e., having puckers or fullness	X		
4. Full, i.e., topcollar folds 1/8 inch or more from edge of undercollar		X	
5. Finished collar width at center back less than 1-1/2 inches or more than 1-3/4 inches (measured from creaseline to the outer edge)		X	
e. Undercollar			
1. Interlining pleated, affecting smoothness of topcollar	X		
2. Interlining tight or twisted, causing puckers on undercollar		X	
3. Row of stitching along creaseline through interlining omitted or insecure			X
4. Width of collar stand less than 1-1/8 inches or more than 1-3/8 inches (measured from creaseline to bottom edge of undercollar)		X	
5. Undercollar seam not pressed open when two-piece undercollar is used		X	
6. Tight at joining to fronts or backs causing puckers or pleats at neck of coat	X		

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B
COLLAR (construction and setting) (cont'd)		
e. Undercollar (cont'd)		
7. Tacking of interlining to back neck outlet and lining omitted or insecure		X
8. Center seam from center back seam when two-piece undercollar is used:		
-1/4 inch or more but not more than 3/8 inch		X
-more than 3/8 inch	X	
f. Gorge seam		
1. Not straight		X
2. Any portion of seam not spread open		X
3. Tacking omitted or insecure		X
LAPELS		
a. Lapel facings		
1. Twisted, short or tight causing lapel to curl out, or twist on facing	X	
2. Fullness or puckers	X	
b. Lapel edges		
1. Irregular or not properly forced out, causing crooked edges		X
2. Front part exposed on lapel edge (to be scored only when condition exists along major portion of seam)		X
3. Tape set on too tight causing puckering at edges		X
4. Bulky or wavy		X
c. Bridle stay		
1. Not held taut, causing lapel breakline not to lie flat, or misplaced, i.e., stay extending beyond breakline on lapel side		X
2. Tight, causing puckers or pleats along breakline		X
d. Collar and lapel shapes		
1. Not uniform, i.e., left and right top edge of lapels or lower ends of collar vary in length by:		
-1/4 inch or more but less than 1/2 inch		X
-1/2 inch or more	X	
2. Lapels poorly shaped or not of uniform shape or size		X
3. Pointed corners of lapels poorly shaped or not of uniform shape or size		X
4. Length and width of shaped lapels uniform, but varying from pattern shaper by:		
-1/4 inch or more but not more than 3/8 inch		X
-more than 3/8 inch	X	

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B

SHOULDER

a. Construction

1. Improperly joined or set, causing shoulder or back to twist X
2. Shoulder seam curved towards back at armhole seam from normal position:
 - more than 3/16 inch but not more than 3/8 inch X
 - more than 3/8 inch X
3. One or both shoulder seams not pressed open X

b. Shoulder pads

1. Not properly set on shoulder causing shoulder to twist or pucker or causing shoulder lining or pads to bulge excessively X
2. Misplaced, not serving intended purpose, i.e., too far back or too far forward X
3. Not completely caught in armhole tacking or around edges to canvas interlining X

WELT POCKETS

a. Construction and setting

1. Top edge of welt short, causing puckers in front or too loose causing welt to gap X
2. Tape along creased edge omitted X
3. Tape stitching exposed and visible on outside surface X
4. Poorly shaped or not uniform in shape or size X
5. Irregular in width by more than 1/8 inch X
6. Diagonal reinforcing row of stitching on corners of welt, omitted or insecure X
7. Cash pocket on inside right lower pocket:
 - omitted X
 - misplaced, i.e., more than 1 inch from center of pocket X
8. Notch exposed beyond outside end of welt or not securely caught within the row of stitching at end of welt. NOTE: Pressure shall be applied in order to ascertain whether the notch at end of welt is secured or exposed. X
9. Any portion of welt setting seam on one or more pockets not spread open X

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B
WELT POCKETS (cont'd)		
b. Pocket alignment and dimensions		
1. Hip welt pockets out of horizontal alignment by: -more than 3/8 inch but not more than 5/8 inch -more than 5/8 inch	X	X
2. Positioned more than 3/4 inch from equal distance of side seams		X
3. Finished depth of hip pockets less than 6 inches for shorts, 6-1/2 inches for regular, long and extra long or more than 7 inches for shorts, 7-1/2 inches for regular, long and extra long		X
4. Finished width of hip pocket opening less than 6 inches for sizes 34-36, 6-1/4 inches for sizes 37-39, 6-5/8 inches for sizes 40-42, and 6-7/8 inches for sizes 43-48, or more than 6-1/4 inches for 34-36, 6-1/2 inches for 37-39, 6-7/8 inches for 40-42 and 7-1/8 inches for sizes 43-48		X
5. Finished width of welt on hip pockets less than 1-1/8 inches or more than 1-1/4 inches		X
6. Finished depth of outside breast pocket less than 5-1/2 inches or more than 6-1/2 inches		X
7. Finished width of outside breast pocket less than 4 inches for sizes 34-36, 4-3/8 inches for 37-39 4-5/8 inches for 40-42 and 4-7/8 inches for sizes 43-48 or more than 4-1/4 inches for 34-36, 4-5/8 inches for 37-39, 4-7/8 inches for 40-42 and 5-1/8 inches for sizes 43-48		X
8. Finished width of welt on outside breast pocket less than 7/8 inch or more than 1 inch		X
9. Finished width of cash pockets less than 3-1/2 inches or more than 4 inches		X
10. Finished depth of cash pocket less than 3-1/4 inches or more than 4-1/4 inches		X

ARMHOLE

a. Construction		
1. Badly stretched	X	
2. Tape set too tight causing puckering around armhole	X	
3. Crooked seam		X
4. Tacking of linings and interlinings to armhole seams omitted on one or both armholes	X	
5. Armhole not securely tacked		X
6. Tape stitching exposed and visible on outside surface of coat (to be scored only when the condition exists along major portion of seam)		X

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Defects	Classification	
	Major	Minor
	A	B

ARMHOLE (cont'd)

a. Construction (cont'd)

7. Armhole tacking stitches exposed and visible on outside

X

b. Sleeve head wadding

- Not completely tacked to armhole, or misplaced, not serving intended purpose

X

SLEEVE

a. Construction and hang

1. Sleeve fullness misplaced X
2. Sleeve tight at armhole, i.e., roll effect not present on front or back of sleeve or causing fold of undersleeve or on armhole at base of sleeve X
3. Lower part of top sleeve tight causing bulge, break or twist on front base of armhole X
4. Sleeve too far front or back, i.e., front rolled edge of sleeve away from center of lower hip pocket welt:
 -by more than 1 inch but not more than 2 inches X X
 -by more than 2 inches X
5. Hang of sleeves in opposite directions, i.e., one sleeve too far forward and one sleeve too far back tolerance of 1 inch but not exceeding 1-1/2 inches from center of lower hip pocket welt X
6. Sleeve backarm seams unequal distance from shoulder seams (outside) by 1/2 inch or more X
7. Forearm seam formed with an outlet X

b. Sleeve lining

1. Twisted, tight or short causing bulge or twist on outside of sleeve X
2. Sleeve lining too long, causing lining to sag at bottom more than 1/2 inch X
3. Sleeve lining seam out of alignment more than 3/4 inch with sleeve seam at armhole X

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Defects	Classification	
	Major	Minor A B
SLEEVE (cont'd)		
c. Construction of sleeves		
1. One or both wool sleeve seams not pressed open		X
2. Wigan twisted, tight or pleated causing ridges or puckering on outside of sleeve		X
3. Blindstitching on bottom turn-up omitted or insecure		X
4. Tacking of sleeve lining seams to sleeve seams omitted, insecure or incomplete for a distance of more than 6 inches from top end or more than 6 inches from bottom edge of sleeves on one or more seams		X
5. Bottom turn-up of lining less than 1-1/4 inches		X
6. Sleeve bottom edge uneven by: -1/4 inch or more but not more than 3/8 inch		X
-more than 3/8 inch	X	
7. Blindstitching of turn-up to wigan or felling of sleeve lining to turn-up caught on outer part of sleeve bottom		X

FRONT FACINGS

- a. Short, tight, or twisted, causing fullness or twist on fronts X
- b. Facing long, causing bottom corner of fronts to curl up X

FRONT AND BOTTOM EDGES

- a. Front edge stretched X
- b. Tape set too tight, causing puckering on front or bottom edge X
- c. Front edge is irregular not properly forced out, causing crooked or curved edges X
- d. Facing exposed on right edge (to be scored only when the condition exists along major portion of seam) X
- e. Bottom corner of left front poorly shaped X
- f. Bottom edge stretched or uneven X
- g. Tape along bottom edge extending less than 2 inches or more than 3 inches beyond back edge of facing X
- h. Facing exposed on left front edge (to be scored only when the condition exists along major portion of seam) X

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Defects	Classification	
	Major	Minor
	A	B
BODY (outside)		
a. Fitting of body lining Tight, short or twisted, causing fullness or twist on outside of coat	X	
b. Fitting of front interlining		
1. Tight, short, or twisted, causing fullness or twist on outside of coat	X	
2. Canvas front too full, causing coat front to have a wavy appearance or not to lie smoothly	X	
FRONT BUTTONHOLES (position spacing from edge and spacing from each other)		
a. Bottom buttonhole placed 1/4 inch or more from center of hip pocket welt		X
b. Position from finished front edge: -less than 5/8 inch but not less than 1/2 inch or more than 3/4 inch but not more than 7/8 inch -less than 1/2 inch or more than 7/8 inch		X
c. Front buttonholes		
1. Unevenly spaced from finished front edge by: -1/8 inch but not more than 1/4 inch -more than 1/4 inch	X	X
2. More than 1/4 inch from equal spacing		X
FRONT BUTTONS (position from edge, vertical alignment and secure sewing)		
a. Position from finished front edge to center of its circumference: -less than 5-3/8 inches but not less than 5-1/4 inches or more than 5-5/8 inches but not more than 5-3/4 inches -less than 5-1/4 inches or more than 5-3/4 inches		X
b. Out of vertical alignment by: -1/4 inch or more but not more than 3/8 inch -more than 3/8 inch	X	X
c. Stitching on right front not caught through interlining on one or more buttons		X
d. Top right front button caught through both plies of inside breast pocket; restricting use of pocket		X

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Defects	Classification	
	Major	Minor
	A	B
SWORD SLIT OPENING AND FLAP		
a. Omitted or incorrectly placed	X	
b. One or both ends insecurely tacked		X
c. Finished length of opening less than 3-1/4 inches or more than 3-3/4 inches		X
d. Assembly reversed, i.e., sword vent facing stitched to side (underarm) seam of left forepart and sword vent flap stitched to front (underarm) seam of left side body piece	X	
e. Flap too large causing puckers or pleats on foreparts		X
f. Finished width of flap less than 1-7/8 inches or more than 2-1/8 inches at center		X
g. Flap button stitching not caught through sword vent facing		X
h. Finished buttonhole less than 5/8 inch or more than 3/4 inch from point of flap		X
i. Button and buttonhole not aligned causing a noticeable bulge or twist on fronts when buttoned		X
j. Flap lining tight or twisted, causing fullness or twist on outside of flap		X
k. Flap stitched to side (underarm) seam of left forepart with only one row of stitching		X
l. Flap button sewn on outside of coat		X
FRONT DART		
Seam not pressed open		X
SIZE TICKET ON OUTSIDE OF RIGHT FRONT SLEEVE		
a. Missing, incorrect, or illegible		X
b. Tacking of ticket insecure or the tacking at any one of the four corners missing		X

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B

Inside of coat

FACINGS, FRONT

a. Fullness on facings between buttons, buttonholes or between front edge and buttons and buttonholes		X
b. Tacking on back of one or both facings to interlining insecure or incomplete for a distance of more than 2-1/2 inches below shoulder seam, more than 2 inches above pocket opening, or more than 2 inches above bottom of coat		X
c. Tacking stitches caught to fronts causing impression marks	X	
d. Felling at bottom corner of facings omitted	X	
e. Tacking along front edge of silesia pocket through facing and interlining (when applicable):		
-omitted	X	
-incomplete for a distance of 3 inches		X

INSIDE POCKET

a. Tacking stitches of inside pocket to facing and interlining through pocket, restricting use of pocket	X	
b. Tacking outer ply of silesia pocket to interlining canvas omitted or insecure (when applicable)		X
c. Tacking inner ply of silesia pocket to facing omitted or insecure (when applicable)		X
d. Front end of opening extending into facing less than 1/4 inch or more than 3/4 inch		X
e. Silesia stay piece not caught in armhole tacking	X	
f. Corners of opening not securely tacked	X	
g. Tacking on upper back corner to canvas interlining omitted or insecure		X
h. Opening badly gapped		X

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B

INSIDE POCKET (cont'd)

- | | |
|---|---|
| i. Finished width of pocket opening less than 5 inches or more than 5-1/2 inches | X |
| j. Finished depth of pocket opening less than 6-1/4 inches or more than 7-1/4 inches from finished welt of pocket opening | X |
| k. Topstitching across ends and upper pocket opening omitted or insecure or seam allowance at top of pocket turned downward | X |
| l. Finished width of welt less than 1/4 inch or more than 3/8 inch | X |

BREAST POCKET AND HIP POCKETS

- | | |
|---|---|
| a. Breast pocket stay piece insecurely tacked to interlining across top and at front and back corner | X |
| b. Hip pockets stay piece at top front corner or seam allowance of hip pockets insecurely tacked to interlining | X |

LINING SIDE OF ARMHOLE

- | | |
|--|---|
| Backstitching at armpit of armhole from forearm seam to side seam area omitted | X |
|--|---|

HANGER LOOP (braid or rayon)

- | | |
|--|---|
| a. Omitted or ends not securely stitched | X |
| b. Misplaced, 1/2 inch or more off center with center back seam | X |
| c. Finished width less than 3/16 inch or more than 5/16 inch (when applicable) | X |
| d. Finished length less than 1-1/2 inches or more than 2 inches | X |

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B

IDENTIFICATION LABEL

a. Missing, incorrect or illegible	X	
b. Not stitched on four sides		X
c. Reversed, i.e., bottom edge not facing towards pocket opening or not located on silesia ply next to lining		X

SWEAT SHIELDS

a. Placed so that front edge covers inside pocket opening 1/4 inch or more or 1/2 inch or more back of forearm seam of sleeve lining		X
b. Top edge not securely caught in armhole tacking		X
c. Tacking at bottom edge to lining omitted or insecure		X
d. Badly puckered, pleated, or twisted		X
e. Binding not securely caught in fabric, causing binding to pull away from fabric easily		X
f. Omitted or insecurely attached		X
g. Constructed with other than basic material		X

FRONT AND BACK LINING

a. Too full		X
b. Twisted affecting smoothness on outside surface of front or back		X
c. Pleat at shoulder or center back omitted	X	
d. Too long, causing lining to be exposed below bottom edge of coat	X	
e. One or more seams not turned to one side and pressed		X
f. Front shoulder lapped over back shoulder seam	X	

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Defects	Classification		
	Major	Minor	
		A	B
FRONT AND BACK LINING (cont'd)			
g. One or both shoulder pleats not facing toward armhole			X
h. Sleeve lining at base of armhole full or twisted			X
i. Front or underarm dart omitted		X	
j. Felling at bottom corner of front lining omitted or insecure			X
LEFT FRONT FLY			
a. Omitted		X	
b. Raised stitching along front edges omitted			X
c. Width of fly stitching from open edges: -less than 2-1/4 inches but not less than 2 inches or more than 2-3/4 inches -less than 2 inches			X X
d. Anchor button misplaced, causing distortion of fronts when buttoned		X	
BOTTOM HEM			
a. Irregular in width by more than 3/16 inch			X
b. Twisted affecting smoothness on outside of coat			X
c. Width of finished hem less than 1-1/8 inches or more than 1-3/8 inches			X
4.3.2.1.3 Detailed defects (trousers).-			
WAISTBAND			
a. Excessive fullness, twists; puckered or pleated: -outside -lining		X	X
b. Lining exposed on outside of trousers above top of waistband		X	

MIL-U-2416H(SA)

Defects	Classification	
	Major	Minor
	A	B
WAISTBAND (cont'd)		
c. Width of waistband less than 1-5/8 or more than 1-7/8 inches		X
d. Width of waistband lining less than 2-1/4 inches		X
e. Waistband not uniform in width by 1/4 inch or more	X	
f. Top stitching of waistband joining seam on waistband side of trousers	X	
g. Top stitching of waistband joining seam extends across left fly		X
h. Waistband hook off center by more than 1/4 inch	X	
i. Waistband hook and eye not aligned		X
j. Ends of lining at center back not turned in		X
k. Waistband joining seam staggered at center back by more than 1/16 inch		X
l. Hook and eye missing, defective, mismatched, or not as specified	X	
SIZE LABEL		
a. Omitted, incorrect or illegible	X	
b. Not positioned above right hip pocket		X
c. End(s) of stitching if not backtacked, extends less than 1/2 inch beyond each end of label		X
d. Stitched through the printing		X
BELT LOOPS		
a. One or more omitted (7 on trousers up to size 37 and 8 on sizes 38 and larger)		X
b. One or more set on crookedly (1/4 inch or more from the perpendicular)		X

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Defects	Classification	
	Major	Minor A B
BELT LOOPS (cont'd)		
c. Covering stitch on the outside of one or more		X
d. Bottom end of loop(s) (except center back loop) not caught in waistband seam		X
e. Position:		
-front loop(s) more than 1/2 inch from pattern notch		X
-front edge of side loop(s) positioned 1/2 inch or more back of outseam or positioned on trousers front (do not score if on side seam)		X
-back loop(s) placed more than 1 inch from midway between outseam and seat seam		X
-center back loop not over seat seam		X
-extra loop (size 38 and up) placed less than 1-1/4 or more than 1-3/4 inches from right fly joining seam		X
f. Tacking or bartacking:		
1. Omitted:		
-on top end of loop(s)		X
-on center back loop		X
-on bottom end of loop(s)		X
2. Length not as specified:		
-not the full width of loop by 1/16 inch or more		X
-extends beyond end(s) of loop(s) by more than 1/8 inch		X
g. Less than 5/16 or more than 3/8 inch wide		X
h. Length of loops (i.e., clearance between tacked ends):		
-less than 1-3/4 inches but not less than 1-5/8 inches, or more than 2 inches but not more than 2-1/8 inches		X
-less than 1-5/8 inches or more than 2-1/8 inches		X
i. Top ends extending 1/8 inch or more above, or more than 3/16 below top edge of waistband		X
j. Tacking or bartack at bottom of loops less than 1/8 or more than 3/8 inch below edge of waistband		X

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Defects	Classification	
	Major	Minor
	A	B
FLY CLOSURE		
a. Fly twisted, puckered, or bulky when closed	X	
b. Left fly facing exposed beyond front edge (to be scored only when condition exists on a major portion of the seam)		X
c. Closed fly uneven in length by: -1/4 inch or more but not more than 3/8 inch -more than 3/8 inch	X	X
d. Right fly lining exposed beyond front edge		X
e. Right fly or right fly lining twisted, puckered or pleated		X
f. Stitching on left fly (1-1/2 ± 1/8 inch) exceeding the tolerance by: -not more than 1/8 inch -more than 1/8 inch		X
g. Seam joining right fly to front exposed when fly is closed	X	
h. Ends of fly not caught in stitching of crotch seam		X
i. Left slide fastener tape stitched through fly lining with less than two rows of stitching		X
j. Staple on slide fastener not securely clinched at end of chain	X	
k. Ends of slide fastener chain uneven at top or bottom		X
l. Top of slide fastener tape not securely caught in waistband joining seam		X
m. Slide fastener chain less than 3/8 inch or more than 5/8 inch from edge of fly at top, or less than 1/4 inch or more than 3/8 inch from edge of fly at bottom		X
n. Slide fastener defective, affecting function	X	
o. Slide fastener defective, not affecting function		X

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Defects	Classification		
	Major	Minor	
		A	B
FLY CLOSURE (cont'd)			
p. Stitching too close to metal edge preventing slider from moving freely	X		
q. Slide fastener tape set too close or too tight causing a bulge		X	
r. Bartack at base of fly: -not placed horizontally or diagonally in line with left fly stitching or extends beyond crotch seam -placed below junction of crotch seam and fly -placed more than 1/4 inch above junction of crotch seam and fly		X	X X
s. Fly extension piece extending beyond inseam less than 1/2 inch			X
t. Raw edges of fly extension not turned under, or the turned edges not/stitched or felled to inseam		X	
u. Crotch seam stitching at base of fly more than 1/4 inch beyond fly bartack		X	
v. Fly tab buttonhole and button out of alignment causing twist or bulge on outside of trousers		X	
w. Interlining in left fly omitted		X	
x. Left fly not overlapping right fly joining seam or overlapping seam by 1/4 inch or more at start of crotch seam			X
DARTS			
a. One or both not properly tapered, causing bulge, twist or fullness		X	
b. Lower end(s) extending below or above pocket opening			X
POCKETS			
a. General (all pockets):			
1. Notch exposed at end(s) of opening	X		
2. Facing(s) not caught in bartacks at end(s) of opening	X		

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Defects	Classification	
	Major	Minor
	A	B
POCKETS (cont'd)		
a. General (all pockets) (cont'd)		
3. Opening(s) stretched or distorted		X
4. Any pocket placed 1/2 inch or more from location indicated on pattern		X
5. Top(s) of pocketing not properly inserted under waistband (twisted or distorted)		X
6. Pleat or raw edge on opening(s)		X
b. Side pockets:		
1. Length of opening(s) less than 5-3/4 inches or more than 6-1/2 inches		X
2. Left and right pocket out of alignment by more than 1/2 inch	X	
3. Facing(s) exposed on outside		X
4. Facing(s) twisted, affecting smoothness of outside	X	
5. Pocket stay(s) not extending above and below bartacks	X	
6. Bottom end of stay(s) not turned under		X
7. Side pocketing(s) notched more than 1/4 inch beyond width of outseam allowance on the underside		X
c. Hip pockets:		
1. Length of opening(s) less than 5 inches or more than 5-1/2 inches		X
2. Less than 5-1/2 inches or more than 6-1/2 inches deep	X	
3. Left and right pocket out of alignment by more than 1/2 inch	X	
4. Upper or lower cords less than 1/8 inch or more than 3/16 inch wide	X	
5. End(s) of cord(s) or bearer(s) not caught in the edge stitching of pocketing (when partially caught, do not score as a defect)	X	
6. Button(s) and buttonhole(s) or buttonhole tab (as applicable) out of alignment causing twist on outside of trousers	X	
7. Buttonhole tab less than 1-3/16 inch or more than 1-5/16 inches long		X
8. Slit buttonholes (spacing between bartacks) on buttonhole tab less than 9/16 inch or more than 11/16 inch long	X	

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Defects	Classification	
	Major	Minor
	A	B
SEAMS		
a. Seat seam or inseam outlet omitted		X
b. Seat seam stitched with one row of stitching	X	
c. Width of seat seam outlet less than 1-3/4 inches (measured at top edge)		X
d. Width of inseam outlet(s) less than 1 inch (measured at crotch)		X
e. Crotch lining piece twisted, puckered or pleated		X
f. Crotch seam extending above fly notch		X
g. Inseams staggered at crotch more than 3/8 inch		X
h. Inseams not pressed open		X
CROTCH LINING PIECE		
a. Constructed of one ply		X
b. Not extending above fly notch		X
c. One ply not caught in overedge stitching		X
d. Omitted on one or both sides		X
LEG BOTTOMS		
a. Not overedge or pinked		X
b. Bottom edges irregular		X

4.3.2.2 Dimensional examination.— The uniforms shall be examined for defects in dimensions in accordance with the following:

- a. Any measurement deviating from nominal dimensions and tolerances specified in Tables III, IV and IVA shall be scored as a measurement defect.
- b. Sleeve lengths unequal in length by more than 1/2 inch shall be scored as a size measurement defect.
- c. Inseam lengths unequal in length by more than 3/4 inch shall be scored as a size measurement defect.

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4.3.2.3 Matching of coat and trousers.— The uniforms shall be examined for defects in matching in accordance with the following:

- a. Any size mismatched uniform, i.e., coat and trousers not same size.
- b. Any shade mismatched uniform, i.e., coat and trousers not same shade.

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

	<u>AQL's</u>	<u>Inspection Level</u>
For examination in 4.3.2.1.1 and 4.3.2.1.2		
Major	1.5	III
Major and Minor A, combined	10.0	III
Total (Major, Minor A and Minor B, combined)	40.0	III
For examination in 4.3.2.1.1 and 4.3.2.1.3		
Major	1.5	III
Major and Minor A, combined	10.0	III
Total (Major, Minor A and Minor B, combined)	25.0	III
For examination in 4.3.2.2		
One class - coat	4.0	S-3
One class - trousers	4.0	S-3
For examination in 4.3.2.3		
One class	0.25	S-3

4.3.3 Examination of preparation for delivery.— An examination shall be made to determine that packaging, packing and marking complies with Section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be sealed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be on the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per hundred units.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted, incorrect, illegible, or improper size, location, sequence, or method of application.
Materials	Any component missing, damaged or not as specified.

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ExamineDefect

Workmanship

Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling; bulged or distorted container.

Content

Number of uniforms per intermediate package is more or less than required. 1/ Number of intermediate packages per shipping container is more or less than required. Size shown on uniforms not as specified on intermediate package or shipping container. 1/

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

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A.-

5.1.1.1 Trousers.- Each pair of trousers, with inseams meeting, shall be folded from the leg bottom up toward the waistband to an overall length of approximately 23 inches. Before folding the regular, long, and extra long trousers to the required length, the leg bottoms shall first be folded up approximately 2 to 4 inches. To prevent creasing, crumpled tissue paper of the type and class specified in 5.1.1.3 shall be placed across the folded area of the trousers.

5.1.1.2 Coat.- Each coat shall be laid back down and a 0.040 inch thick bending or non-bending paperboard form conforming to figure 7 inserted into the coat so as to fit snugly into the shoulders. A padding of tissue paper of the type and class specified in 5.1.1.3 shall be placed on top of the form as a support in maintaining the shape of the shoulders. The coat shall be fully buttoned. The sleeves shall be folded in half by bringing the bottom of the sleeves up to the neckline. The coat shall be folded in half by bringing the bottom of the coat up to the neckline. To prevent creasing of the body of the coat and sleeves, crumpled tissue paper shall be placed across the folded areas of the coat.

5.1.1.3 Uniform.- Each folded uniform with the coat placed on top of the trousers, shall be completely wrapped in tissue paper conforming to type I, class 1 or 2 of UU-P-553. Each wrapped uniform shall be packaged in a fiberboard box with the length of the trousers and the width of the coat placed parallel to the lengthwise dimension of the box. The fiberboard

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box shall conform to style OPF, type CF (variety SW) or SF, class domestic, grade 125 of PPP-B-636. The outside dimensions of the box shall be 23-3/8 inches in length, 15-3/8 inches in width, and 2-1/4 inches in depth. Unless otherwise specified (see 6.2.1), one ounce of naphthalene flakes shall be uniformly distributed throughout the contents of each box. The boxes shall be sealed along the center length of the top, bottom, and both ends of the box with minimum 3 inch wide gummed paper tape conforming to type II, grade B of PPP-T-45.

5.1.2 Level C.- Uniforms shall be packaged to afford adequate protection against deterioration and physical damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets these requirements.

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

5.2.1 Level A.- Three uniforms, of one type, size, and length only, packaged as specified in 5.1.1, shall be packed in a fiberboard shipping container assembled, closed and reinforced conforming to class weather-resistant, grade V2s, size 2 of MIL-B-17757. Level A packages shall be packed flat, one in length, one in width, and three in depth within the shipping container. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes and lengths may be packed within the same shipping container.

5.2.2 Level B.- Three uniforms, of one type, size and length only, packaged as specified in 5.1.1, shall be packed in a fiberboard shipping container assembled and closed conforming to class domestic, grade 275, size 2 of MIL-B-17757. Level A packages shall be packed flat, one in length, one in width, and three in depth within the shipping container. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes and lengths may be packed within the same shipping container.

5.2.2.1 When specified (see 6.2), the shipping container shall be a grade V3c or V3s fiberboard box fabricated in accordance with MIL-B-17757 and closed in accordance with the appendix of the box specification. The shipping container material may also be grade V4s of PPP-F-320.

5.2.3 Level C.- Uniforms, 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 Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

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

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5.3.1 Labels, mixed sizes.- Each shipping container, packed with mixed sizes only, shall have securely attached to the end and side, directly under the printing or stencilling, a white paper label 5 by 4 inches with the words "MIXED SIZES" plainly stamped or printed thereon and under these words shall be legibly stamped or printed the correct quantity and sizes contained therein.

6. NOTES

6.1 Intended use.- The uniforms are intended for wear by male Naval Officers, Chief Petty Officers, Officer Candidates and JNROTC as a service dress uniform.

6.2 Ordering data.- Procurement documents should specify the following:

- a. Title, number and date of this specification.
- b. Types, sizes, and lengths required (see 1.2).
- c. Whether first article sample is required (see 3.2).
- d. Levels of packaging and packing required (see 5.1 and 5.2).
- e. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.1).

6.2.1 The naphthalene flakes requirement is not applicable when Government furnished material has been mothproof treated (see 5.1.1.3).

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

Custodian:
Navy - SA

Preparing activity:
Navy - SA

Project No. 8405-N321

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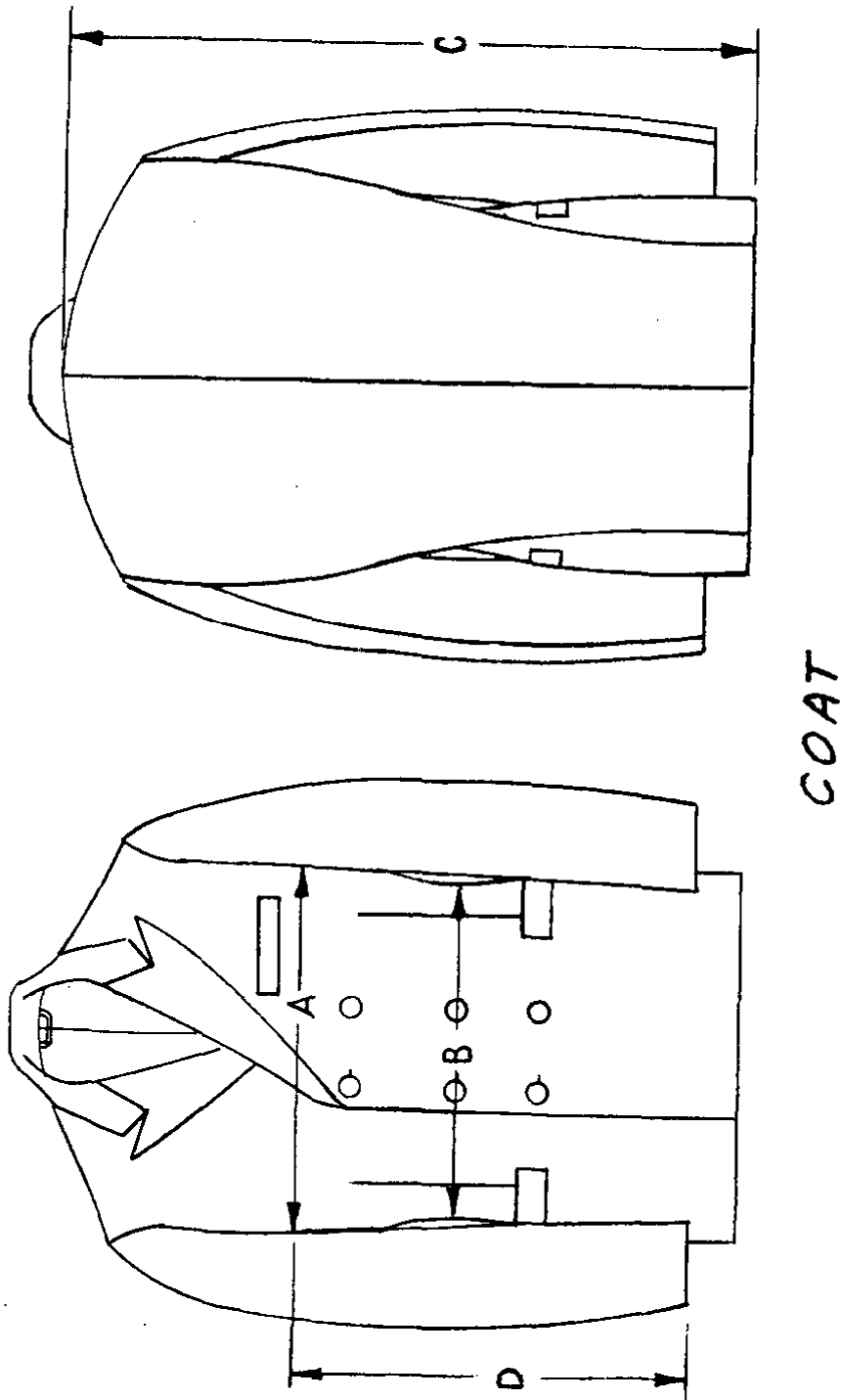
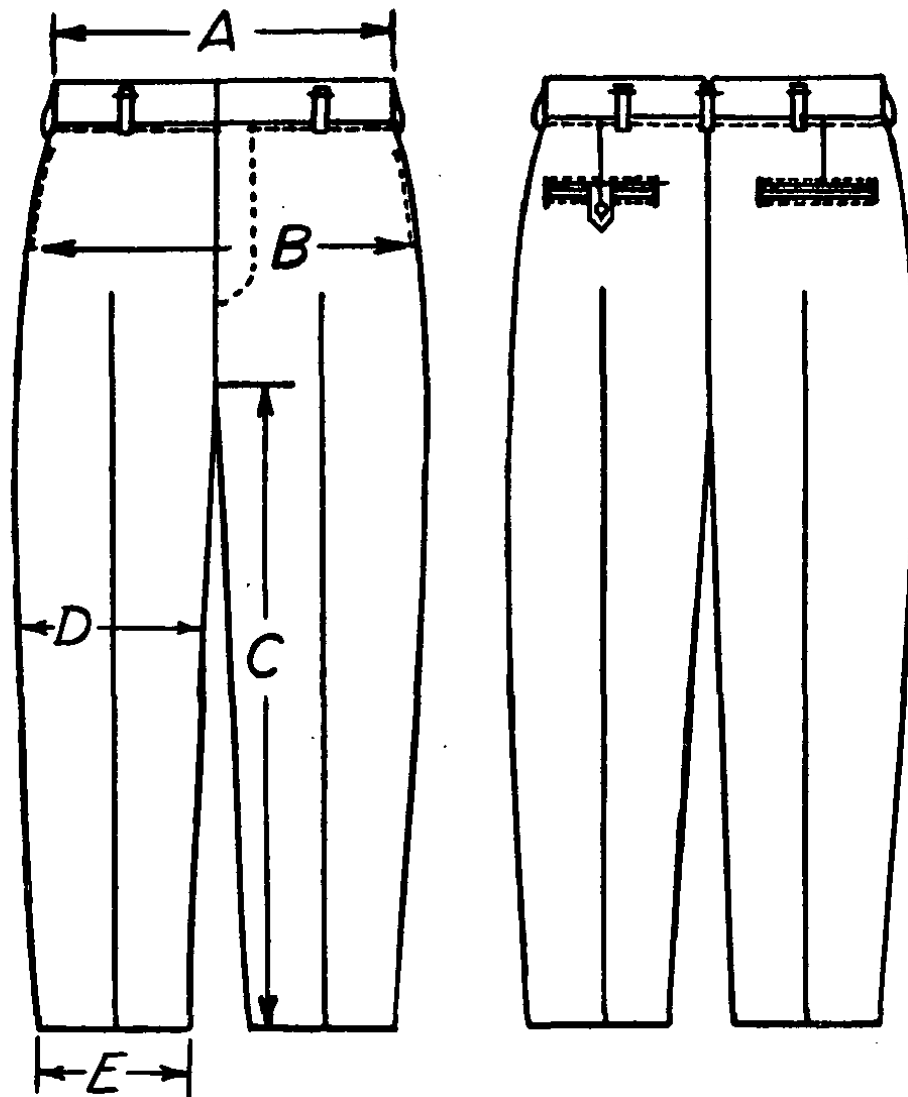


FIGURE 1-UNIFORM, MAN'S (SERVICE, BLUE)

MIL-U-2416H(SA)



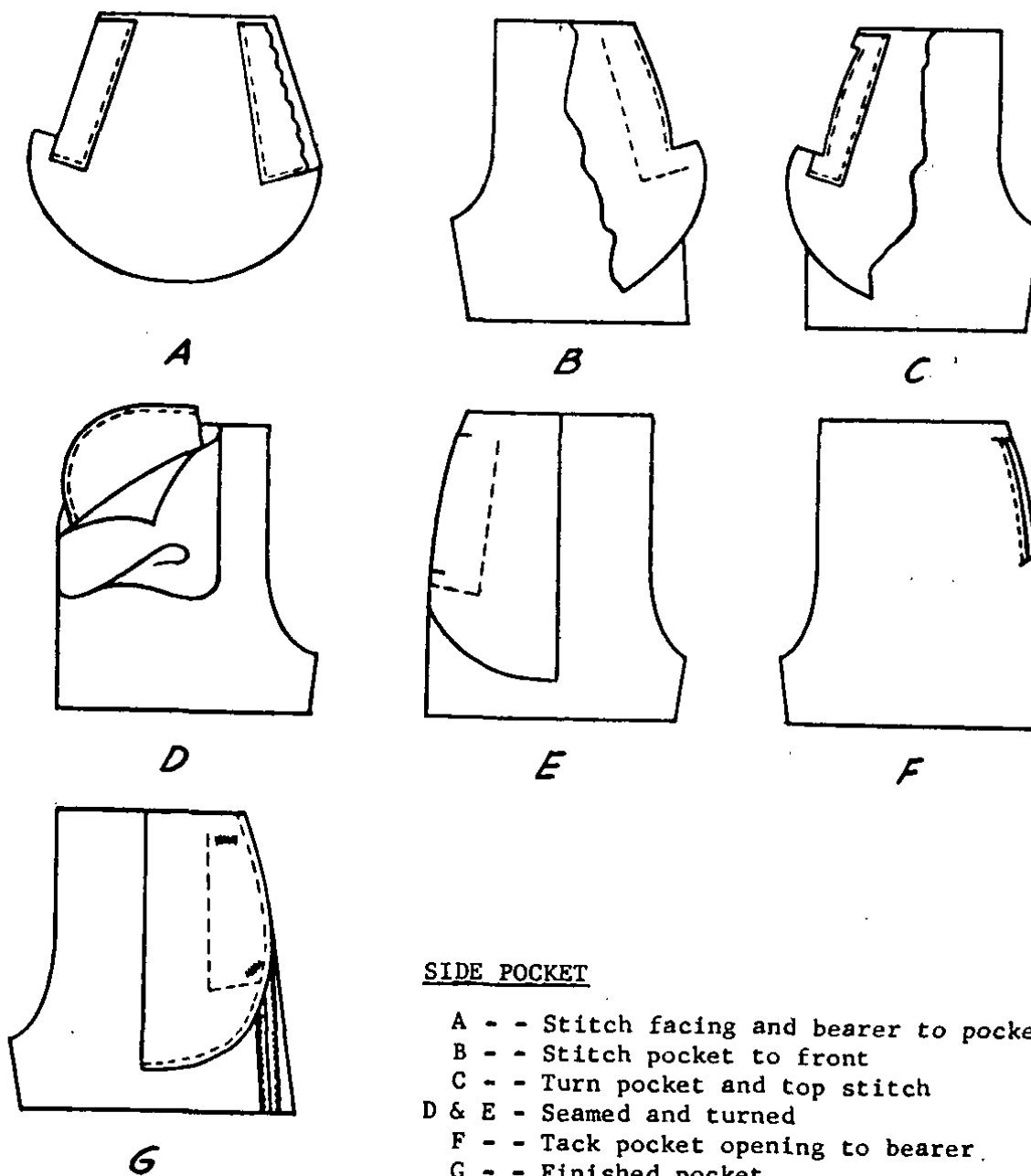
FRONT

BACK

TROUSERS

FIG. 2 UNIFORM, MAN'S
(SERVICE, BLUE)

MIL-U-2416H(SA)

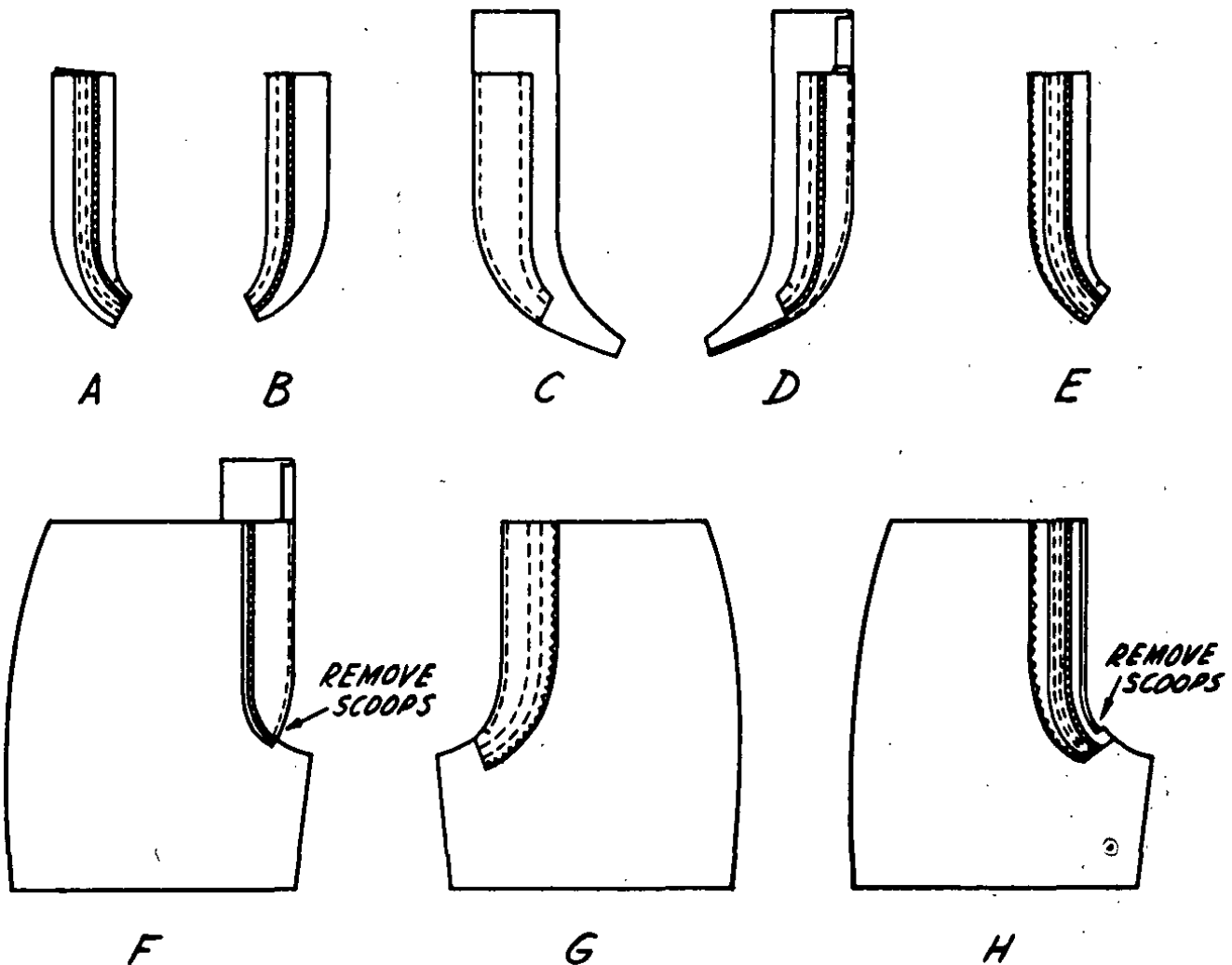


SIDE POCKET

- A - - Stitch facing and bearer to pocket
- B - - Stitch pocket to front
- C - - Turn pocket and top stitch
- D & E - Seamed and turned
- F - - Tack pocket opening to bearer
- G - - Finished pocket

FIGURE 3 - UNIFORM, MAN'S (SERVICE, BLUE)

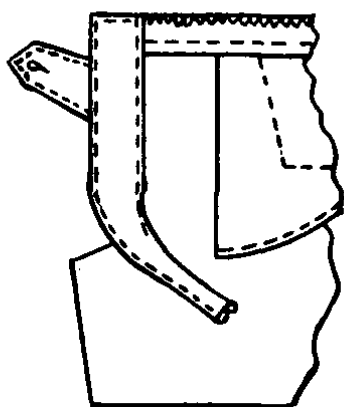
MIL-U-2416H(SA)

FLY (RIGHT AND LEFT)

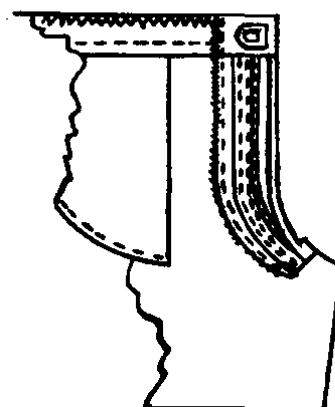
- A - - Double stitch fastener tape to left fly through lining
- B - - Seam fastener tape to right fly
- C & D - Seam lining to right fly, turn and raise stitch
- E - - Overedge left fly
- F - - Join right fly to trousers
- G & H - Join left fly to trousers and press

FIGURE 4 - UNIFORM, MAN'S (SERVICE, BLUE)

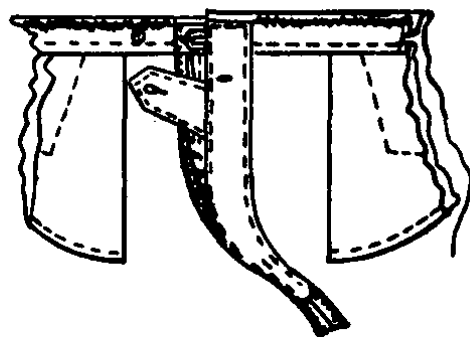
MIL-U-2416H(SA)



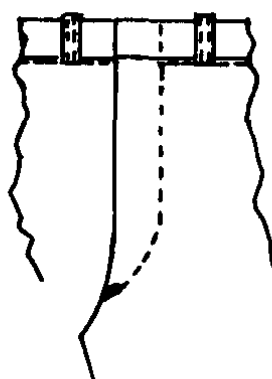
J



K



L



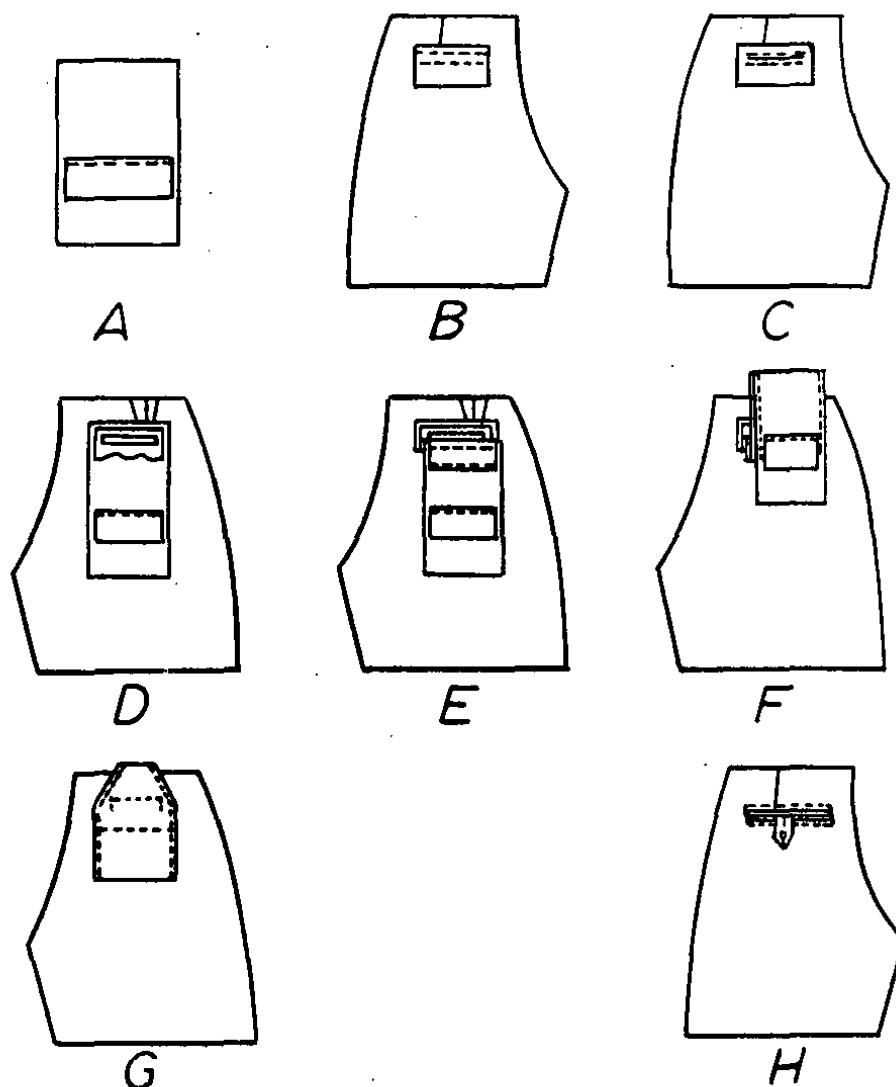
M

FLY (RIGHT AND LEFT)

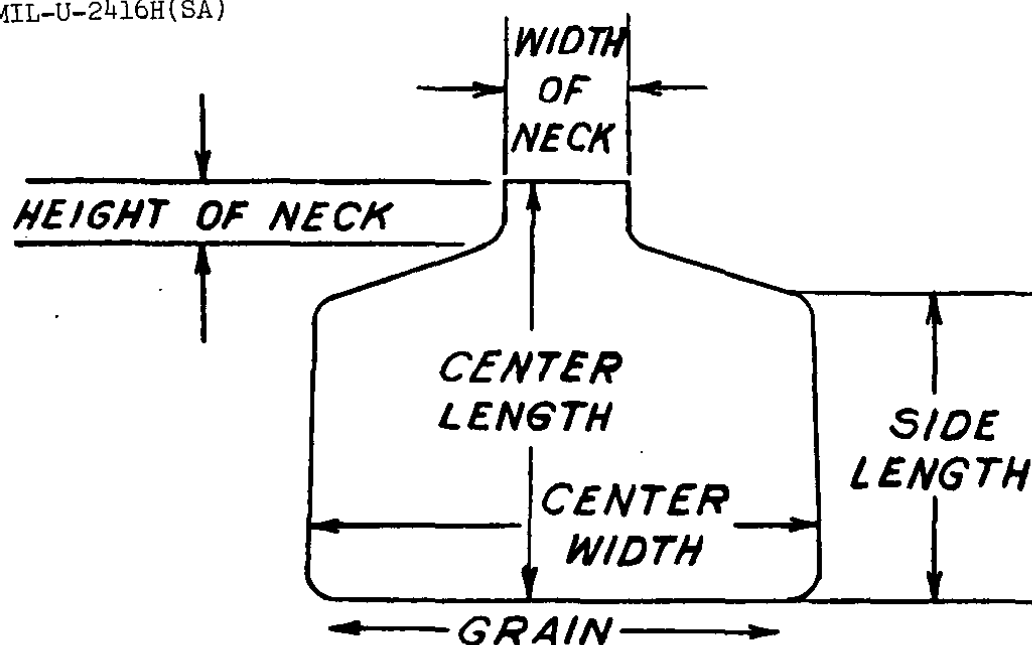
- J - RAISE STITCH RIGHT FLY CATCHING LINING
- K - RAISE STITCH BACK EDGE OF LEFT FLY THROUGH TROUSER
- L - FINISH END OF RIGHT FLY LINING
- M - BARTACK BASE OF FINISHED FLY

FIG. 5 UNIFORM MAN'S
(SERVICE, BLUE)

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**HIP POCKET****A-BEAKER ON POCKET****B-CORD FACING PIECE ON
OUTSIDE OF TROUSERS****C-CUT THROUGH CORD
PIECE AND NOTCH****D-CORD PIECE TURNED INSIDE****E-MAKE CORD****F-POCKET PULLED THROUGH
AND CLOSED****G-POCKET PULLED****THROUGH TO INSIDE AND TOP
STITCHED ON SIDES****H-TOP POCKET OPENING****STITCHED THROUGH POCKET
AND FACING PIECE WITH
BUTTONHOLE TAB INSERTED****FIG. 6 UNIFORM, MAN'S
(SERVICE, BLUE)**

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LEGEND

SIDE LENGTH	10-1/2 INCHES
CENTER LENGTH	14 INCHES
CENTER WIDTH	18 INCHES
WIDTH OF NECK	4-3/8 INCHES
HEIGHT OF NECK	2 INCHES

NOTE

SLOPE SO THAT NO CORNERS WILL TEAR CLOTHING.
ALSO ROUND CORNERS OFF AT BOTTOM OF FORM
TO PREVENT TEARING OF CLOTHING.

SHOULDER FORM

FIG. 7 UNIFORM, MAN'S (SERVICE, BLUE)

FOLD

DEPARTMENT OF THE NAVY

POSTAGE AND FEES PAID
NAVY DEPARTMENT

Officer in Charge
Navy Clothing and Textile Research Unit
Natick Laboratories
Natick, Mass. 01760

OFFICIAL BUSINESS

Officer in Charge
Navy Clothing and Textile Research Unit
Natick Laboratories
Natick, Massachusetts 01760

FOLD

3ND PPSO 12502

Stock No. IIA 0101 807 2000

SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 119-R004	
<p align="center">INSTRUCTIONS</p> <p>This sheet is to be filled out by personnel either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity (as indicated on reverse hereof).</p>			
SPECIFICATION			
MIL-U-2416H(SA); Uniform, Man's (service, Blue)			
ORGANIZATION (Of submitter)		CITY AND STATE	
CONTRACT NO.	QUANTITY OF ITEMS PROCURED	DOLLAR AMOUNT	
MATERIAL PROCURED UNDER A		\$	
<input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT			
1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?			
A. GIVE PARAGRAPH NUMBER AND WORDING.			
B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES.			
2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID			
3. IS THE SPECIFICATION RESTRICTIVE?			
<input type="checkbox"/> YES <input type="checkbox"/> NO IF "YES", IN WHAT WAY?			
4. REMARKS (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)			
SUBMITTED BY (Printed or typed name and activity)		DATE	

DD FORM 1426
1 APR 63

REPLACES NAVSHIPS FORM 4863, WHICH IS OBSOLETE

3ND PPSO 12502