

INCH POUND

MIL-U-28946B(MC)

23 May 1994

SUPERSEDING

MIL-U-28946A(MC)

4 May 1981

MILITARY SPECIFICATION

UNIFORM, WOMAN'S: WHITE; DRESS (OFFICER'S)

This specification is approved for use by the U. S. Marine Corps, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the requirements for a woman's white dress uniform, consisting of coat and skirt.

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

Schedule of Sizes

<u>Short</u>	<u>Regular</u>	<u>Long</u>
X0	X0	X0
2	2	2
4	4	4
6	6	6
8	8	8
10	10	10
12	12	12
14	14	14
16	16	16
18	18	18

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commander (PSE-C), Marine Corps Systems Command, Quantico, VA 22134-5010 by using the self addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 8410

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1.3 Individual orders. When uniforms are custom tailored to an individual order, this specification shall govern, except that the detail requirements of Section 3, Table I, may be modified to the extent necessary for good custom tailoring practice.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards and handbooks. The following specifications, standards and handbooks form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

A-A-50135	- Cloth, Interlining, Polyester
A-A-50186	- Cloth, Buckram, Woven and Nonwoven
A-A-50198	- Thread, Gimp, Cotton, Buttonhole
A-A-50199	- Thread, Polyester Core, Cotton or Polyester Covered
A-A-52094	- Thread, Cotton
A-A-52106	- Cloth, Twill, Polyester or Polyester Blend
V-B-871	- Button, Sewing Hole, and Button, Staple (Plastic)
V-F-106	- Fastener, Slide, Interlocking
V-T-285	- Thread, Polyester
DDD-L-20	- Label; For Clothing, Equipage, and Tentage, (General Use)
DDD-T-86	- Tape, Textile Cotton, General Purpose (Unbleached, Bleached or Dyed)

MILITARY

MIL-C-368	- Cloth, Satin, Rayon and Cloth, Twill, Rayon
MIL-B-3461	- Buttons, Insignia, Metal, Uniform and Cap
MIL-T-5237	- Tape, Textile, Webbing, Rayon
MIL-C-15062	- Cloth, Flannel, Wool, Undercollar Cloth
MIL-P-15064	- Pads, Shoulder and Sleeve-Head
MIL-C-17757	- Box, Shipping, Fiberboard, (Modular Sizes)
MIL-C-29137	- Cloth, Felt Fabric, Composite Undercollar
MIL-C-41820	- Cloth, Gabardine, Polyester and Rayon

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STANDARDS

FEDERAL

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

STANDARDS

MILITARY

- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-984 - Provisions for Size Labeling of Women's Uniform Clothing
- MIL-STD-1608 - Provisions for Evaluating Quality of Coats, Women's, Dress
- MIL-STD-1609 - Provisions for Evaluating Quality of Skirts, Women's, Dress

(Unless otherwise indicated, copies of federal and military specifications, standards and handbooks are available from the Standardization Documents Order Desk, Bldg 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094).

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

Department of Defense (DoD) Standard Color Card for Sewing Threads 1968

Department of Defense (DoD) Standard Shades for Buttons 1966

(Application for copies should be addressed to the Color Association of the United States, Inc., 200 Madison Avenue, New York, NY 10016).

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

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

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AMERICAN SOCIETY OF TESTING AND MATERIALS

ASTM D 3951 - Standard Practice for Commercial Packaging

(Application for copies should be addressed to American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103).

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents may also be available in or through libraries or other informational services).

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption had been obtained.

3. REQUIREMENTS

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

3.2 First article. When specified (see 6.2), the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.4 and 6.4).

3.3 Materials.

3.3.1 Basic material. The basic material shall be cloth gabardine, polyester-rayon, 8 ounce, white shade 2400 (see 6.4), conforming to type III, class I of MIL-C-41820.

3.3.2 Lining. The material for lining the coat and skirt shall be cloth, rayon twill, 3.7 ounce, white shade 2414 conforming to class 1 of MIL-C-368.

3.3.3 Interlining. The material for interlining the coat fronts and shoulder straps shall be cloth, polyester, 3.4 ounce, white color conforming to A-A-50135.

3.3.4 Undercollar material. The undercollar material shall be cloth, wool flannel conforming to MIL-C-15062. The material shall be dyed a shade approximating the shade of the basic materials specified in 3.3.1, and shall show good colorfastness to wet (dry) cleaning. The acidity (pH) requirement and colorfastness to perspiration and crocking requirements shall not apply. As an alternate, a composite undercollar fabric conforming to MIL-C-29137 may be used in a shade approximating the shade of the basic material specified in 3.3.1.

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3.3.5 Collar interlining material. The collar interlining material for all classes shall be cloth, cotton buckram, natural or white shade conforming to type I, class 2 of A-A-50186, except that the test for shrinkage shall be in accordance with Method 5580 of FED-STD-191.

3.3.6 Polyester twill. The material for the simulated pocket stay, armhole seam and shoulder seam of the coat and the top ply of the watch pocket and waistband interlining of the skirt shall be cloth, polyester twill, shade white, conforming to class 1 of A-A-52106. Cloth shall be bias cut for shoulder and armhole stays.

3.3.7 Bias binding. The binding for the underarm shields, bottom turnup, and for making coat and skirt hangers shall be bias cut from the lining material specified in 3.3.2. The binding shall be cut 5/8 to 3/4 inch wide and shall have sized edges.

3.3.8 Tape rayon. The material for finishing the bottom edge of the skirt and for reinforcing the folded edge of pocket welt shall be tape, textile, webbing, rayon, 1/2 inch wide, white, conforming to type I of MIL-T-5237.

3.3.9 Cotton tape. The cotton tape used for armholes, bridle tape and fronts shall conform to type III, class 1 of DDD-T-86, and shall be 1/4 inch wide.

3.3.10 Shoulder pads. Shoulder pads shall conform to type III, class 4 of MIL-P-15064 and they shall be white in color.

3.3.11 Thread.

3.3.11.1 Polyester thread. The polyester thread for machine seaming and stitching and for hand felling shall be white, soft finish, size A, 3-ply, conforming to type I, class 1 of V-T-285.

3.3.11.2 Cotton thread. The cotton thread for making eyelets and buttonholes shall be white (bleached) mercerized finish ticket No. 36, 2-ply conforming to type III of A-A-52094. The thread for sewing on buttons shall be ticket No. 24, 4-ply conforming to type I or II of A-A-52094. Thread for basting shall be a good commercial grade. As an alternative for cotton thread, a polyester cotton covered thread conforming to A-A-50199, ticket No. 50, 2 or 3 ply may be used.

3.3.12 Gimp. The buttonhole gimp shall be cotton thread, white (bleached) soft or glazed finish conforming to type I or II, size 8 of A-A-50198.

3.3.13 Buttons.

3.3.13.1 Insignia buttons. The insignia buttons shall be metal, gold plated, conforming to type I, style 3, class A, subclass 1 of MIL-B-3461. Buttons shall be 40-line for front closure of coat, and 27-line for shoulder straps, all regular shank.

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3.3.13.2 Sewing hole buttons. The sewing buttons for the skirt shall be melamine formaldehyde composition, 27-line, conforming to type II, class D, style 4 of V-B-871. The color of the buttons shall be white shade BA, Cable No. 62031 and shall have a glossy finish.

3.3.14 Slide fastener. The slide fastener for the skirt shall be brass, white metal finish, 7 inches in length, interlocking nonseparating automatic lock, open top stop, closed bottom stop, single slider with short tab pull conforming to type I, style 3, size 1, of V-F-106. The tape shall be cotton and the color shall be white.

3.3.15 Labels. Each coat and skirt shall have a combination identification-instruction label, and a size label. The uniform is intended to be "Dry Cleaned Only" and the labels shall show fastness to dry cleaning.

3.3.15.1 Identification-instruction label (combined). The identification-instruction label shall conform to type VI, classes 1 and 3 (combined) of DDD-L-20 and shall measure not less than 5-1/2 by 2-1/2 inches. The content and format shall be as follows:

Nomenclature (item description)
Contract number
Name of contractor
Fiber Contents Act information where required

NOTE: It is recommended that the uniform be dry cleaned only.

3.3.15.2 Size label. The size label shall conform to type VI, class 2 of DDD-L-20 except the stock number is not required. The inscription on the size label shall conform to MIL-STD-984; Table II Body Dimensions for Marine Corps, Table III Height Ranges and Figure 2. Examples of labels are as follows:

Hip Circ 36"
Waist Circ 25 1/2"
Height 63-1/2 to 67" (R)
 (Size Code 6)

3.4 Design. The uniform consisting of coat and skirt, shall be of the U. S. Marine Corps design shown in Figures 1 through 6 and as follows:

3.4.1 Coat. The coat shall be the U. S. Marine Corps design shown in Figures 1, 2 and 3, four button, single breasted, semifitting, and fully lined; with four front panels and four back panels with center back vent; breast pocket with outside welt; worked eyelets in shoulders and left front for removable insignia buttons; shoulder straps to button, ornamental sleeve cuffs; notched collar and lapel with worked eyelet in each end of collar for branch of service insignia. The coat shall have a sword slit cut in the left front panel at the waist, when required by the contract or purchase order.

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3.4.2 Skirt. The skirt shall be a gore style and fully lined, with three front panels and two back panels, having an opening at the top of the center back with slide fastener closure, and one piece set-on waistband with both ends to button at the center back opening. The skirt shall have a center back pleat and the bottom shall be pinked. Figures 4, 5 and 6 show design.

3.5 Patterns. Standard patterns will be furnished by the Government. The standard patterns shall not be altered in any way and shall be used as a guide only for cutting the contractor's working patterns. The contractor's working patterns shall be identical to the standard patterns. The standard patterns provide the following seam allowances:

Coat 1/

Seams at edges of lapels, shoulder straps, collar and front edges of the coat.	3/16 inch
Front and back seams.	3/8 inch
Side seams.	3/4 inch
Center back seam.	5/8 inch

Skirt

Front and back seams.	3/4 inch
Side seams.	1 inch
Bottom turnup allowance.	3 inches

1/ 3/8 inch allowance for all other seams except as otherwise specified in Table I.

Standard patterns show size and seam allowances and are marked and notched for proper cutting, placement and assembly of component parts.

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3.5.1 List of pattern parts. The uniforms shall be cut from the materials specified herein in accordance with the pattern parts indicated below:

<u>Pattern nomenclature</u>		<u>No. of</u>
<u>Item</u>	<u>Material: Cloth, polyester rayon</u>	<u>cut parts</u>

Coat

1.	Front	2
2.	Side front	2
3.	Front facing (right)	1
4.	Front facing (left)	1
5.	Center back	2
6.	Side back	2
7.	Top collar	1
8.	Topsleeve	2
9.	Undersleeve	2
10.	Sleeve cuff	2
11.	Shoulder straps	4
12.	Breast pocket welt	1
13.	Underarm shield	2
14.	Sword slit tab	1

Material: Cloth, polyester rayon

Skirt

15.	Center front	1
16.	Side front	2
17.	Back	2
18.	Waistband	1
19.	Placket piece	1
20.	Watch pocket (Bottom ply)	1

Material: Cloth, twill, rayon (lining)

Coat

21.	Front	2
22.	Right center back	1
23.	Left center back	1
24.	Side back	2
25.	Top sleeve	2
26.	Under sleeve	2

Skirt

27.	Front	1
28.	Left back	1
29.	Right back	1

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Material: Cloth, interlining, polyester

Coat

30.	Front	2
31.	Shoulder strap	2

Material: Twill, Polyester and Cotton

Coat

32.	Breast pocket stay	1
33.	Inside breast pocket	2

Skirt

34.	Watch pocket (Top ply)	1
35.	Waistband interlining	1

Material: Cloth, Wool Flannel

36.	Sword slit patch	<u>coat</u>	1
37.	Undercollar		1

Material: Cloth, Cotton Buckram

38.	Undercollar	<u>coat</u>	1 or 2
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Shapers (Coat)

39.	Finished lapel and collar shaper
40.	Undercollar shaper
41.	Lapel working shaper
42.	Left vent shaper

Markers (Coat)

43.	Breast pocket welt marker
44.	Sleeve cuff marker
45.	Collarstand marker
46.	Right front marker

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3.6 Construction. The uniform shall be manufactured in accordance with the operations and the stitch, seam and stitching types specified in Table I. The contractor is not required to follow the exact sequence of operations as listed in Table I but all operations specified shall be used to manufacture the uniform.

3.6.1 Stitches, seams and stitchings. The stitch, seam and stitching types specified in Table I shall conform to FED-STD-751. The number of stitches per inch as specified in Table I indicates the minimum and maximum number permitted.

3.6.1.1 Thread breaks and ends of seams. Ends of seams and stitching produced with 301 type stitch, when not caught in other seams or stitching, shall be backtacked not less than 1/4 inch. Thread breaks (all stitch types) shall be secured by stitching back of break not less than 1/2 inch. The ends of a continuous line of stitching shall be overlapped not less than 1/2 inch.

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

- (a) Corrosive metal fastening devices.
- (b) Adhesive-type tickets whose adhesive shows discoloration and which leaves residue of the adhesive material upon removal of the tickets.
- (c) Any marking medium that would tend to leave a permanent mark.

3.6.3 Pressing. All pressing operations specified in Table I shall be accomplished with a heated pressing iron or pressing machine set at medium (low) temperature (285°F maximum).

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1	<p><u>Cutting.</u></p> <p>a. Cut the uniforms in strict accordance with patterns furnished by the Government, which show directional lines for cutting and marks and notches for proper assembly of components.</p> <p>b. Cut all materials in direction indicated by the directional lines on the pattern.</p> <p>c. Cut all polyester/rayon gabardine parts of the coat and skirt from one piece of basic fabric, except the following parts may be cut from ends: underply of shoulder straps, underarm shield, placket piece and bottom ply of watch pocket for the skirt.</p> <p>d. Cut the front and back linings for the coat and front and back lining for the skirt from one piece of nylon lining material. All other nylon lining parts may be cut from ends. When pairs of sleeve linings are cut from ends, the shade of the linings comprising each pair shall match.</p> <p>e. Cut the material for interlining the coat fronts from the polyester cloth specified in 3.3.3 in accordance with pattern furnished.</p> <p>f. Cut the twill interlining for the pocket stay in accordance with the pattern. The armhole, back neckline and shoulder seam on the bias, 3/4 inch long and 4 to 4-1/2 inches long.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1	<p><u>Cutting.</u> (cont'd)</p> <p>g. Dress the right vent in accordance with the vent shaper.</p> <p>h. The right front shall be dressed in the front shaping operation only (see oper. 40.a.).</p> <p>i. The use of drill holes is prohibited.</p>					
2	<p><u>Replacement of defective components.</u></p> <p>a. During the spreading, cutting and manufacturing process, remove from production all components having material defects or damages that are classified as defects in MIL-STD-1608 and MIL-STD-1609. Replace defective/damaged components with nondamaged and properly matched components.</p>					
3	<p><u>Shade/size marking.</u></p> <p>a. Mark all component parts, except those parts cut from ends (see 1.c and 1.d), to insure a uniform shade, size, and proper assembly throughout the uniform.</p>					
4	<p><u>Make coat hanger.</u></p> <p>a. Fold the 3/4 inch wide strip of bias binding in half lengthwise, turning edges to the inside to finish 1/4 inch wide, and seam 1/16 inch from turned edges.</p> <p>b. Cut the hanger 3-1/4 \pm 1/4 inches long.</p>	301	SSc-1	10-14	A	A

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TABLE 1 MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
5	<u>Make shoulder eyelet covers.</u> Finished appearance. The shoulder eyelet covers shall finish $1-3/4 \pm 1/8$ inch wide and $1-1/2 \pm 1/8$ inch long. a. Turn under the side edges of each cover and stitch $1/8$ inch from the folded edges, catching the turned under portions in the stitching. b. Fold each cover in half across the width and stitch $1/16$ inch from the folded side edges. Continue stitching across the folded end.	301 301 301	EFa-1 (each side edge) SSc-1 (each side) OSf-1 (folded end)	10-14 10-14 10-14	A A A	A A A
6	<u>Make shoulder straps.</u> Finished appearance. The shoulder strap shall be uniformly stitched and shall finish smooth and flat, without twists, gathers or puckers. The buttonhole shall be clean cut, well made, properly positioned, well worked over gimp to fit a 27-line insignia button and the stitching shall be securely caught in the basic material. The gimp shall be pulled through to the underside of the buttonhole and the purling of the buttonhole shall be on the outside of the strap. The shoulder strap may be fused. a. The shoulder straps shall be made of two ply of basic material and one ply of interlining. b. Fold side edges, face to face, and seam together with a $1/4$ -inch seam.	 301	 SSe-2 (a)	 10-14	 A	 A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
6	<u>Make shoulder straps.</u> (cont'd)					
	c. Press seam open with a heated pressing iron or pressing machine.					
	d. Stitch pointed end of straps with a 1/4 inch seam.	301	SSe-2 (b)	10-14	A	A
	e. Trim points and turn the straps.					
	f. Fold the edges in accordance with the notches and topstitch the straps uniformly 1/8 inch from the edge.	301	BSm-2 (a)	10-14	A	A (Silk)
	g. Make a horizontal, eyelet end, square bar type, cut first button hole, 3/4 inch long, in each strap through all plies midway between the back and front edges with the inside edge of the eyelet placed so that in the finished coat, the edge of the shoulder strap button will be 1/4 to 1/2 inch from the edge of the collar. The purling shall finish on the outside of the strap.	Buttonhole		38 Per buttonhole (minimum) (not including bartack)	A	A
	h. The buttonhole shall be well worked over gimp and the ends of the gimp shall be pulled through to the underside.					
	i. Securely bartack the ends of the buttonhole and trim the ends of the thread and gimp.	Bartack		21 Per bartack (minimum)	A	A
7	<u>Make undercollar.</u>					
	a. The undercollar assembly shall consist of one piece of undercollar cloth and a single piece of interlining material.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
7	<u>Make undercollar.</u> (cont'd)					
	b. Pad the interlining to the undercollar with 6 to 7 rows of blindstitching. Press undercollar flat.	103	SSm-1 (each row)	4-6	A	
	c. Mark and trim undercollar in accordance with the shape of the pattern. Trim the interlining 1/8 inch back from the neck edge of the undercollar and collar ends.					
	d. Mark the breakline of the undercollar with the collarstand marker.					
	e. Stitch the breakline in accordance with the mark and stitch the undercollar to interlining 1/2 inch from outer and end edges.	301 or 401	SSa-1	10-14	A	A
8	<u>Assemble topcollar and undercollar.</u>					
	Finished appearance. The collar shall be uniform in appearance and shall finish smooth and flat without twists, gathers, puckers, pleats or raw edges (outer and sides). The felling shall not be too tight or loose and the collar material shall be securely caught in the stitching. The eyelets shall be well worked with the purling on either side of the collar and shall finish with a 1/8 inch diameter opening.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
8	<u>Assemble topcollar and undercollar.</u> (cont'd)					
	a. Position topcollar between undercollar and interlining with the outer edge abutting the undercollar-interlining seam and with notches aligned. Join topcollar to interlining with a row of stitching 3/16 inch from the lapped edge of the topcollar.	301	LSa-1	6-8	A	A
	b. Join topcollar to undercollar at outer edge with zigzag stitching, properly distributing the fullness between notches. The zigzag stitching shall extend to the end of the collar.	304	LSa-1	8-10	A	A
	c. Turn the topcollar to the inside, face to face with the undercollar, folding even with the top edge of the interlining. Stitch the ends of the undercollar to the topcollar with a 1/8 inch seam. Trim the ends and the corner of the seam and turn assembly, forcing out the collar points.	301	SSa-1	8-10	A	A
	d. Baste the top edge and ends, forcing out the points of the outer corners of collar and baste along the breakline with the two rows of basting stitches.	101 or Hopper				
	e. Press the collar smooth and flat with a heated pressing machine. Edges and corners shall be smooth, flat and uniformly even.					
	f. Trim the neck edge of the topcollar to provide for proper seaming to the coat, and cut a guide notch in the lower edge of the topcollar at the center.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
8	<u>Assemble topcollar and undercollar.</u> (cont'd)					
	g. Make one eyelet at each end of the collar 1 inch from the end and outer edge, respectively. The eyelet shall be well worked, and shall finish with a 1/8 inch opening.	Eyelet		20 Per eyelet (minimum)	A O	A (Silk) O (Silk)
9	<u>Make welt.</u>					
	a. The welt shall be made of a single piece of basic material, folded in half and reinforced on the inside at the folded edge with 1/2 inch wide nylon tape.					
	b. Position the tape on the underside of the welt piece with one edge even with the fold notches and seam 1/16 inch from the edge of tape next to the fold line.	301	SSaa-1	10-14	A	A
	c. Fold the welt on the notches with the tape on the outside and close the ends with a 1/4 inch seam.	301	SSe-2 (a)	10-14	A	A
	d. Turn the welt to the right side, completely working out the seamed edges and corners. Edgestitch the welt 1/8 inch from seamed and folded edges. The welt shall finish with the nylon tape stitched to the inside of the welt.	301	SSe-2 (b) (ends) OSf-1 (folded edge)	10-14	A	A
	e. Press the welt smooth and flat.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
10	<u>Make armhole shields.</u>					
	a. Bind the rounded edges of shield with bias binding, turning under the outside raw edge of the binding only, and catching the turned under portion in the stitching 1/16 inch from folded edge.	301	BSb-1	10-14	A	A
11	<u>Make sleeve cuff.</u>					
	a. Fold the cuff lengthwise, face to face, at the point, and stitch the point 1/8 inch from the raw edges.	301	SSa-1	10-14	A	A
	b. Turn the cuff, completely working out the point.					
	c. Turn under the upper edge of the cuff 5/16 to 3/8 inch and crease with a heated pressing iron, forming the finished edge to conform to the shape of the pattern.					
	or					
	The turned under portion at the upper edge of cuff may be basted.	Hand or 101				
12	<u>Seam sleeves at forearm.</u>					
	a. Position the top and under sleeve face to face with notches matching. Join at the forearm with 3/8 inch seam.	301	SSa-1	10-14	A	A
	b. Spread open the seam and press smooth and flat.					
	c. Overedge stitch the raw edge of each seam allowance at the forearm.	503 or 504	EFd-1	6-10	A	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
13	<u>Join cuffs to sleeve.</u> a. Mark the sleeve in accordance with the pattern marker for positioning the cuffs with notch on the marker matching the forearm seam line and the lower edge of pattern in line with the bottom raw edge of the sleeve. b. Position the upper edge of cuffs at the mark and seam to the body of the sleeve 3/16 inch from the upper edge. Trim the ends of the cuff even with the backarm edges of the sleeves if necessary.	301	LSd-1	10-14	A	A
14	<u>Seam sleeve at backarm.</u> a. Position the top and undersleeve with edges even. Join together at the backarm with a 3/8 inch seam, catching the ends of the cuff in the seam, with the top edge of cuffs aligned. b. Spread open the backarm seam and press smooth and flat. c. Overedge stitch the raw edges of the forearm and backarm seam allowances, respectively.	301 502 or 503	SSa-1 SSa-1 SSa-1	10-14 6-10 6-10	A A A	A A A
15	<u>Fell cuff to sleeve.</u> Finished appearance. On the finished coat the length of the cuff shall be $2\frac{3}{4} \pm \frac{1}{4}$ inches at the forearm and backarm seam lines, and $4\frac{3}{4} \pm \frac{1}{4}$ inches at the point. The felling stitches shall not penetrate the cuff to the outside.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
15	<u>Fell cuff to sleeve.</u> (cont'd)					
	a. Smoothly turn cuff over the end of the sleeve and baste turnup through all plies.	Hand				
	b. Fell the raw edge of the turnup to the body of the sleeve with blindstitching. Stitches shall not be exposed on outside of sleeve cuff.	103	SSm-1	4-6	A	
16	<u>Make sleeve lining.</u>					
	Finished appearance. The sleeve lining shall be uniform in appearance. The sleeve lining shall be uniformly stitched and shall finish smooth and flat without twists, gathers, puckers or pleats. The seam shall start and finish evenly.					
	a. Position the top and undersleeve lining pieces in accordance with notches on pattern. Join the forearm and backarm seams respectively, with 3/8 inch seams.	301	SSa-1	10-14	A	A
	b. Overedge stitch the raw edges of the backarm seam allowances.	502 or 503	SSa-1 SSa-1	6-10 6-10	A A	A A
17	<u>Assemble sleeve and sleeve lining.</u>					
	Finished appearance. The sleeve lining shall be positioned and seamed or tacked to sleeve without twists, gathers, puckers or pleats.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
17	<u>Assemble sleeve and sleeve lining.</u> (cont'd) a. Position the under sleeve lining on the undersleeve with the top notch in the under and backarm sleeve lining aligned with the upper edge of the under and backarm of the sleeve respectively. The lining shall extend not less than 3/4 inch above the armhole edge of the sleeve. b. Seam or tack by hand, the forearm and backarm sleeve lining seam allowance to the respective seam allowance of the sleeve, properly distributing the fullness in the lining. The stitching shall extend from approximately 5 inches above the finished bottom of the sleeve up to approximately midway to the armhole edge of the under and backarm edge. c. Turn sleeve lining on the sleeve.	301 or Hand	SSa-1 (1-2 inches in length)	6-10	A (Commercial)	A
18	<u>Fell turnup of sleeve lining and press sleeve.</u> Finished appearance. The sleeve lining shall not be short, tight or twisted. a. Turn under the bottom edge of sleeve lining to finish 1 to 1-1/4 inches above the finished bottom edge of sleeve and baste to the sleeves. b. Fell the folded edge of sleeve lining to the sleeve with blindstitching.	101 or Hand	EFm-1	6-8 8-10	C C (Silk)	C

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
18	<u>Fell turnup of sleeve lining and press sleeve.</u> (cont'd) c. Turn sleeves right side out and assemble in pairs. Insert a sleeve pad in the sleeve to avoid creasing the front and back edges and press smooth and flat with a heated pressing machine.					
19	<u>Stitch darts in front lining.</u> Finished appearance. The darts shall be tapered to a point at upper ends. a. Sew the darts with a 3/8 inch seam, tapering the dart to a point at the upper ends and securely back tack.	301	OSf-1	10-14	A	A
20	<u>Make inside pocket.</u> Finished appearance. The pocket shall be uniformly stitched and finish smooth and flat without causing distortion. a. The pocket shall be made of two plies of polyester/twill material 5" wide X 6 1/2" long. b. Position both plies of pocketing material face to face with notches matching and stitch together from the top notch across the top, back, bottom and up the front to the bottom notch with a 3/8 inch seam leaving a 4 1/2 inch opening for the pocket.	301	SSa-1	10-14	A	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
20	<u>Make inside pocket.</u> (cont'd)					
	c. The notch for placing the inside pocket shall be in line with the third buttonhole from the top. Attach the front pocket openings in accordance with the notches to the right front facing and the right lining respectively with a 3/8 inch seam leaving a 4-1/2 inch pocket opening.	301	SSa-1	10-14	A	A
	d. Raise stitch the pocket material on to the facing and lining respectively with a 1/16 inch topstitch.	301	SSc-1	10-14	A	A
21	<u>Seam front lining to facing and sew on label.</u>					
	Finished appearance. The lining shall be carefully seamed to the facing so that in the finished coat, the lining shall be smooth and flat along the facing without creases, bulges, overlapping of excess material, or other defect or distortion.					
	a. Position the lining on the facing with notches matching and seam the front edge of the lining to the back edge of the facing 3/8 inch from the edge. The stitching shall extend from top (shoulder) edge of facing to the bottom notch of facing approximately 1-1/4 inches from the bottom edge.	301 or 401	SSa-1	10-14	A	

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21	<u>Seam front lining to facing and sew on label.</u> (cont'd) b. Sew the identification label to the left front lining with a single row of stitching 1/16 inch from each edge of the label. The label shall be positioned horizontally with the lower edge of label 3 inches above the bottom edge of the finished coat. The ends of the label stitching shall overlap not less than three stitches.	301	SSbj-1	10-14	A	A
22	<u>Press front lining and waist darts.</u> a. Press the facing joining seams and waist darts smooth and flat with a heated pressing iron or pressing machine. b. The facing-lining joining seam shall be pressed with the raw edge of the seam allowance toward the back. The waist darts shall be pressed with the edge towards the back.					
23	<u>Join back lining parts.</u> Finished appearance. Back linings shall be carefully joined without pleats, puckers or gathers. The seam shall start and finish evenly at seam line. a. Position back linings with notches matching and join together at the center with a 3/8 inch seam, stopping at the top of the vent.	301	SSa-1	10-14	A	A

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TABLE 1 MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
23	<u>Join back lining parts.</u> (cont'd)					
	b. Position left and right side back linings to the respective center back linings, matching notches and join with a 3/8 inch seam.	301	SSa-1	10-14	A	A
24	<u>Join back and front linings.</u>					
	Finished appearance. The linings shall be carefully joined without pleats, puckers or gathers. The seam shall start and finish evenly at seam line.					
	a. Position the back and front linings together and join at the sides with a 3/4 inch seam.	301	SSa-1	10-14	A	A
25	<u>Press lining seams and darts.</u>					
	a. Press the facing-lining joining seams, side and back seams and the waist darts smooth and flat with a heated pressing iron or pressing machine.					
	b. The facing-lining joining seams, side seams and left and right back seams shall be pressed with the raw edges of the seam allowance toward the back. The lining shall be folded face to face along the center back seam and the seam pressed flat. The waist darts shall be pressed with edges toward toward the back. Fold back and press flat the facing and lining seam allowance of the unstitched portion of the lining-facing joining seam at the bottom edge.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
26	<u>Join backs.</u> Finished appearance. The side and center backs shall be joined without gathers, puckers or pleats. The folded edge of the left vent shall be in vertical line with the center back seam. a. Stitch the 1/4 inch wide stay tape to the inside of left center back along the vent, with the edge of the tape positioned approximately 1/8 inch in front of the fold notch of the vent. b. Position the center backs with edges even and join with a 5/8 inch seam from the top edge of the backs to approximately 3/4 inch below top end of the vent, and from that point continue to stitch diagonally across the top end of the vent. c. Turn the left vent to the inside of the left center back, in accordance with the notches, and edge stitch uniformly 1/8 inch from the folded edge. The folded edge of vent shall be in line with the center back seam line. d. Join the left and right side backs to the respective center backs with a 3/8 inch seam. e. Seam the 3/4 inch wide poly/cotton twill stay to the underside of back neckline 1/8 inch from the outer edge of neckline.	301	SSaa-1	10-14	A	A
		301	SSa-1	10-14	A	A
		301	OSf-1	10-14	A	A
		301	SSa-1	10-14	A	A
		301	SSaa-1	10-14	A	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
27	<u>Press back seams.</u> a. The side and center back seams shall be pressed with a heated pressing iron or pressing machine. b. Notch the top end of the right vent diagonally from the juncture point of the vent and the center back to the lower end of the stitching for the center back seam. c. Spread open the side and center back seams, respectively, and press flat.					
28	<u>Topstitch top end of vent.</u> Finished appearance. The edge of right side of vent shall extend beyond the center seam allowance of the left back part. a. Stitch and backstitch across the top end of vent through all plies from the back center seam to the edge of the vent, for a distance of 1 inch.	301	SSa-1	10-14	A (Silk)	A
29	<u>Join front and side front.</u> Finished appearance. Bust lines on both sides shall be alike. Fronts and side fronts shall be carefully joined without puckers or gathers. The seams shall start and finish evenly at the seam line. The contour of the waist and hip line shall be maintained in the seaming. a. Sew the dart with a 3/8 inch seam, tapering to a point at the upper end, and securely back tack.	301	SSa-1	10-14	A	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
29	<u>Join front and side front.</u> (cont'd)					
	b. Position front and side fronts with notches matching and join together with 3/8 inch seams.	301 or 401	SSa-1	10-14	A	A
	c. Spread open the front seam and waist darts and press flat with a heated pressing iron, maintaining contour.					
	d. Tape gorge line on underside with 1/4 inch tape from shoulder to 1/4 inch below top of lapel.	301	SSaa-1	10-14	A	A
30	<u>Seam reinforcement stay to armhole and shoulder.</u>					
	Finished appearance. The polyester and cotton twill reinforcement stays shall be sewn to the armhole and shoulder edges of the front without gathers, puckers or pleats. The top end of the armhole stay and lower edge of the shoulder stay shall form a right angle at the armhole without the stays overlapping each other.					
	a. Seam the 3/4 inch wide polyester and cotton twill stays to the underside of the fronts along the shoulder edge and upper front edge of the armhole, respectively, 1/8 inch from the outer edges.	301	SSaa-1	10-14	A	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
31	<p><u>Assemble simulated breast pocket welt on left front.</u></p> <p>Finished appearance. The simulated breast pocket shall be smooth and flat with the ends of the welt uniformly stitched and with no puckering. In the finished garment, the breast pocket welt shall be horizontal with the bottom edge of coat.</p> <p>a. Mark the left front in accordance with breast pocket marker for position of breast pocket welt. Mark welt seam line on the underside 1 inch from folded edge for proper seaming to front.</p> <p>b. Position the polyester and cotton twill stay piece for the pocket on the underside of the front. Position the welt on the outside of the left front, with marks on welt and front matching and with folded edge of welt towards the bottom edge of coat. Seam top ply of welt to the front at the mark through the stay piece.</p> <p>c. Turn the welt with the folded edge of the welt towards top of front. Topstitch both ends of welt to the front, 1/8 inch from the seamed edges of welt. The line of stitching shall extend from the lower seamed line of the welt up to the folded edge of welt. The welt shall be blindstitched to the body of the coat and the stitching shall not be visible on the outside of welt.</p>	301	LSbj-1	10-14	A	A
		301	SSe-2 (b) (both sides)	10-14	A (Silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR						
31	<u>Assemble simulated breast pocket welt on left front. (cont'd)</u> d. On the outside of the finished coat, the welt for the simulated pocket shall measure $1 \pm 1/16$ inch in height, and the width for each size coat, measured along top edge of welt, shall be as follows: <table><tr><td><u>Coat size</u></td><td><u>Width of Welt (inches)</u></td></tr><tr><td>X0 through 10</td><td>3-1/2</td></tr><tr><td>12 through 18</td><td>4</td></tr></table>	<u>Coat size</u>	<u>Width of Welt (inches)</u>	X0 through 10	3-1/2	12 through 18	4					
<u>Coat size</u>	<u>Width of Welt (inches)</u>											
X0 through 10	3-1/2											
12 through 18	4											
32	<u>Join fronts and back at sides.</u> Finished appearance. The fronts and side backs shall be joined together without puckers or pleats. The seams shall start and finish evenly at seam line. The contour of the waist and hip line shall be maintained in the seaming. a. Position side fronts to the side backs at the sides and join with 3/4 inch seams.	301 or 401	SSa-1	10-14	A	A						
33	<u>Press side seam.</u> a. Spread open the side seams and press flat with a heated pressing iron.											

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
34	<u>Tape armholes.</u>					
	a. Sew the 1/4 inch wide stay tape to the inside at the lower edge of the armhole, starting from approximately 1 inch above the notch in the fronts and continuing to side seam. Cut the tape and continue stitching tape along bottom and back edge to lower notch holding tape taut. Continue to stitch tape to back armhole to 1-1/4 inches from the shoulder.	301 or 401	SSaa-1	10-14	A	A
	b. From the lower back notch, continue stitching the tape, holding the tape taut along the back edge of armhole to 3/4 inch from the shoulder.	301	SSaa-1	10-14	A	A
	c. Press armhole tapes and shoulder blade smooth and flat with a heated pressing iron.					
35	<u>Interline fronts.</u>					
	a. Position the left and right fronts on the respective coat front interlining and baste along the front seams, properly distributing the fullness over the breast area. The basting shall extend from approximately 3 inches from the shoulder edge of fronts to approximately 1-1/2 inches from the bottom edge.	101 Hopper				
	b. Baste the left front along the welt-joining seam line on the outside, with the front and interlining lying smooth and flat.	101 Hopper				

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TABLE 1 MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
35	<u>Interline fronts.</u> (cont'd)					
	c. Tack the front and back ends of the simulated pocket stay to the coat front interlining. The tacking shall be as close as possible to the corners of the pocket.	101 Hopper or Hand				
	d. Baste horizontally along the shoulder, allowing room for setting shoulder pads and working the fullness on the front towards the armhole. Baste along the front of armhole approximately 1-1/2 inches from the edge and continue to baste down the back edge of interlining to approximately 1-1/2 inches from bottom edge of front.	101 Hopper				
	e. Baste along the breakline of lapel, starting at the gorge, and continue basting along the front edge below the breakline to approximately 1-1/2 inches from bottom edge of front.	101 Hopper				
	f. Baste along the top and front edge of lapel down to the lower end of lapel.	101 Hopper				
36	<u>Baste bridle tape to lapel.</u>					
	a. Position the 3/8 inch wide bridle tape on the interlining side of the fronts along the breakline of lapel, with the front edge of the tape in line with notch in the gorge.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
36	<u>Baste bridle tape to lapel.</u> (cont'd)					
	b. Baste tape through the interlining and the front of coat along the breakline of lapel evenly and smoothly, holding the tape taut and properly distributing the fullness. The tape shall extend from the gorge notch to approximately 1-1/2 inches from the lower edge of lapel.	101 or Hand		6-8		
37	<u>Pad lapels.</u>					
	a. Pad the lapels with seven to eight rows of blindstitching, from approximately 3/4 inch from front edge to the breakline, properly distributing the fullness of the interlining between the rows of stitching to roll the lapels.	103 or 314	SSm-7 or 8 SSm-7 or 8	4-8 4-8	A or 00 A or 00	A 00
	b. Blindstitch both edges of bridle tape to interlining.	103 or 314	SSm-2 SSm-2	4-8 4-8	A or 00 A or 00	A 00
38	<u>Press chest and lapels.</u>					
	a. Roll press the lapels, shrinking to eliminate the fullness from the interlining, on a suitable type heated pressing machine.					
	b. Press the fronts individually on a suitable type heated pressing machine to conform to the shape of the body to eliminate excess fullness in the breast.					

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TABLE 1 MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
39	<p><u>Shape fronts.</u></p> <p>a. Mark and shape the front edge of the coat. Mark and shape the lapels in accordance with the shaper furnished.</p> <p>b. Mark the coat 1-1/4 inches from the bottom edge for the bottom turnup.</p> <p>c. Trim the coat front interlining 1/4 inch back from the front edge of the fronts and top edge of the lapel. Trim bottom of interlining to approximately 1/4 inch above the mark for the bottom turnup.</p> <p>NOTE: In-process inspection of this operation shall take place at this point before going to the next operation.</p>					
40	<p><u>Baste facing-lining assemblies to fronts.</u></p> <p>a. Position the facing-lining assembly on outside of respective fronts and baste along the break line, distributing the fullness in the breast area and continue to baste along the front and bottom edge. Baste front along top and front edges of lapel down to the lower end of lapel, working the fullness towards the center of lapel.</p>	101 Hopper				

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TABLE 1 MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
41	<u>Join facings and fronts with tape.</u>					
	a. Join the facings and fronts together 3/16 inch from the top and front edges of lapel and front edges of coat, with the stay tape, 3/8 inch wide for all classes positioned on the interlining side of fronts. The edge of the tape shall be 1/8 inch from the front edges and caught in the stitching. Continue stitching along the lower edge of coat 3/16 inch above the front cutout with the tape properly positioned and caught in the stitching.	301	SSab-1	10-14	A	A
	b. The tape shall extend from the lapel notch to 1-1/2 to 2 inches from the side seams at the bottom of coat, except the tape is not required along the step of the left front. The tape shall be sewn with normal tension along the top and front edges of lapel and with slight tension along front and bottom edges of coat.					
	c. <u>Alternate.</u> When fusible front construction is used, position tape 1/8 to 3/16 inch from the edge of coat and stitch 1/16 to 1/8 inch from edge of tape, across top of lapel, down front and across bottom to back of facing. Press edge seam flat toward front; pull basting thread.	301	SSa-1	8-10	A	A
42	<u>Fell tape to interlining.</u>					
	a. Fell the back edge of the stay tape to the coat front interlining from the collar notch on top of lapel to the end of the tape at the bottom edge.	103	SSm-1	4-6	A	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
42	<p><u>Fell tape to interlining.</u> (cont'd)</p> <p>b. Press the fronts and tape at the top and front edges of lapel, and front and bottom edges of coat, smooth and flat with a heated pressing iron or pressing machine.</p> <p>c. Remove all basting stitches. Trim lower front corner and corner of lapels. Notch lapel for proper turning.</p> <p>d. Spread open the front facing seam from lapel notch to the bottom edge of coat and press smooth and flat with a heated pressing iron.</p>					
43	<p><u>Baste fronts and bottom edge of coat.</u></p> <p>a. Turn the facing-lining assemblies to the inside of the fronts, working the corners of lapels out completely. Turn up the bottom of coat, lapping the back edge of facing on the ends of the bottom turnup and working the front corners out completely.</p> <p>b. Baste along the top and front edges of the lapel, including the step of the left front and finished bottom edges of the coat, working the seams to the edges of the coat.</p>	101 or Hand		4-6		

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
44	<u>Baste facing (second time).</u>					
	a. Baste facing to front approximately 1-1/4 inches from the top and front edges of lapel and front and bottom edges of the coat, holding the lower corners of the coat in such a manner as to cause the lower front edge of front to roll inward.	101 or Hand				
	b. Baste along the breakline of the lapel, properly placing the fullness to allow the lapel to roll.	101 or Hand				
	c. Baste the lapel diagonally from the corners to the breakline, properly placing the fullness to allow the lapel to roll.	101 or Hand				
	d. Baste the facings to the front as close to the facing-lining seam as possible, placing the proper fullness over the breast area. The basting shall extend approximately 1-1/2 inches from the bottom edge of the coat to approximately 3 inches from the shoulder edges of facings.	101 or Hand				
45	<u>Tack facings at back edge to interlining.</u>					
	a. Raise the lining and tack the seam allowance at back edge of the facings to the coat front interlining with blindstitching, starting approximately 2 inches from the bottom edge of the coat and tacking to approximately 2-1/2 inches from the shoulder edge of the interlining. Tacking shall be through seam allowance of facing and linings.	103 or 314 or Hand	SSa-1 SSm-1	4-6 4-6 4-6	A A C (Silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
46	<u>Blindstitch bottom turnup.</u>					
	a. Blindstitch the bottom turnup.	103 or 306 or Hand	EF1-1	4-6 4-6 4-6	0 (Silk) 0 (Silk) 0 (Silk)	0
47	<u>Join lining to vent.</u>					
	a. Position the right and left back lining on the respective right and left vent opening, face to face, with notch of lining even with the top of the vent and joining each side respectively with a 3/8 inch seam to 3/4 inch above bottom turnup.	301	SSe-2 (a)	10-14	A	A
	b. The left vent corner shall be finished with a mitre corner (Do not cut corner).	Hand or Machine		4-6	0 (Silk)	
	<u>Alternate:</u> The left vent corner may be piped for a distance of 1-1/2 to 2 inches and turned up 1-1/4 inches at the hem and stitched by hand or machine.	103 or 306 or Hand	EF1-1	4-6	0 (Silk)	
	c. Edgestitch the right vent with a 1/8 inch seam from folded edge of vent ensuring the lining is not exposed on the outside.	301	SSe-2 (a)	10-14	A (Silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
48	<u>Baste body lining to coat.</u> (cont'd)					
	e. Baste the back lining along the lower edge of armhole, approximately 2 inches from the edge, and continue up and across the shoulders and neckline down to the other armhole. Leave ample room with basting to permit insertion of the shoulder pads.	101 or Hand				
49	<u>Fell bottoms.</u>					
	a. Fell the lining turnup to the bottom turnup.	Hand or Machine		4-6	0 (Silk)	0
50	<u>Trim front lining and interlining.</u>					
	a. Trim the excess coat front interlining and front lining at the armhole.					
	-or-					
	When the shoulder lining seams are joined by machine, trim excess coat front interlining and front and back lining at shoulders to allow insertion of shoulder pads.					
	b. Trim the lining even with the back at the neck.					
51	<u>Baste shoulder pads.</u>					
	a. Insert shoulder pad between interlining and chest padding of coat front interlining, in line with the armhole edge, and securely tack the pad to the interlining and chest padding only.	101 or Hand				

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
51	<u>Baste shoulder pads.</u> (cont'd) b. When type XIII or type XV of MIL-C-15065 is used, place shoulder pad on under side of interlining in line with armhole and securely tack on interlining only.	101 or Hand		4-6		
52	<u>Seam shoulders.</u> Finished appearance. The shoulders shall be evenly joined with the front and back seam lines matching, working in the proper fullness on the backs in order that the shoulder may be properly shaped. a. Join fronts and backs together at the shoulder with a 3/8 inch seam, equally distributing the fullness of the back in the shoulder seam. b. Spread open the shoulder seam and press flat with a heated pressing iron or pressing machine over a suitable block, holding the shoulder short. Care shall be exercised in pressing the shoulder seam in order that the shoulders shall not have a distorted appearance in the finished coat.	301 or 401	SSa-1	10-14	A	A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
53	<u>Baste lining at shoulders and neckline.</u> a. Position shoulder interlining at neck. Baste upper part of each shoulder on the outside and turn the coat on the inside. Turn under and lap the shoulder edge of the lining on the front lining. Baste lining to coat along the folded edge with top end of chest pleat caught in the basting at the shoulders. Baste the lining to the back at the neck, from shoulder seam to shoulder seam.	Hand or 101 or Hopper				
54	<u>Stitch hanger and label to coat.</u> a. Stitch the ends of the hanger and upper edge of the size label to the neck of coat at the inside center back. b. The hanger opening, in the finished coat, shall be $1-1/2 \pm 1/8$ inches long when measured along the neck edge of the collar.	301	SSa-1	10-14	A	A
55	<u>Set collar.</u> Finished appearance. The seam joining top collar to facing at the gorge shall be of uniform gage and shall finish smooth and flat without twists, puckers, pleats, or other distortions. a. Mark the coat on the outside around the neck from shoulder seam to shoulder seam, $5/8$ inch from the top edge, and continue to mark along the gorge with the line of marking tapering to $3/8$ inch at the lapel notch.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
55	<u>Set collar.</u> (cont'd)					
	b. Join the top collar to the facing at the gorge, from the collar notch to a point not less than 1 inch in back of the lapel breakline.	301	SSa-1	12-16	A	A
	c. Clip the facing at the back end of joining seam.					
56	<u>Tack top collar to fronts at gorge.</u>					
	a. Spread open the seam joining top collar to facing and tack the seam allowance of the top collar to the front at the gorge, from the collar notch to the back end of the seam, catching the top end of bridle tape in the tacking.	Hand or 301	SSa-1	2-4 12-16	C (Silk) A	A
57	<u>Baste undercollar to coat.</u>					
	Finished appearance. Fullness in the collar along the neck edge shall be properly placed over the shoulders so that the collar will not be tight along the outer edge over the shoulders.					
	a. Turn the collar to the outside with the lower edge of the undercollar lapped on the outside of the coat at the mark.					
	b. Securely tack the corners of the undercollar across the juncture point of the collar and the lapel.	Hand		8-10	C (Silk)	
	c. Baste the undercollar to the fronts and backs, placing proper fullness over shoulder.	Hand				

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TABLE 1 MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
57	<u>Baste undercollar to coat.</u> (cont'd) d. In the finished coat, the ends of the collar shall be $1-3/8 \pm 1/8$ inches for all sizes when measured from the juncture of the collar and lapel to the finished edge.					
58	<u>Tack coat to collar interlining.</u> a. Raise the lower (neck) edge of the top collar and tack the neck edge of coat to the undercollar interlining with overcast stitches, or blindstitching by machine, catching the back lining in the tacking from shoulder seam to shoulder seam.	Hand or 103	SSm-1	2-3 3-4	C (Silk) A	
59	<u>Baste top collar to coat.</u> a. Turn under the lower edge of the top collar and baste from gorge seam to gorge seam. -or- b. In lieu of operations 60.a, and 61.a, join lower edge of top collar from gorge seam to gorge seam.	Hand or 101		4-6		
		301	SSa-1	10-14	A	A
60	<u>Fell collar to coat.</u> a. Fell the neck edge of the undercollar to the fronts and backs from collar notch to collar notch.	Hand or Machine (hand type felling) or 306	LSa-1	8-12 8-12	C (Silk) C (Silk)	
			LSa-1	8-12	C (Silk)	O

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TABLE 1 MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
60	<u>Fell collar to coat.</u> (cont'd)					
	b. Fell the folded edge of the top collar to the coat from gorge seam to gorge seam, catching the top edge of the size label and the ends of the coat hanger in the stitching.	Hand		8-10	C (Silk)	
61	<u>Edgestitch coat.</u>					
	a. Edgestitch the coat 1/8 inch from the front edges of the coat, the front and top edges of the lapels, the edges of the collar and the left edge of center back vent.	301	SSe-2 (Front edges of coat front and top edge of lapels finished seam for collar)	10-14 SSb-1	A shows	A
62	<u>Set shoulder straps.</u>					
	Finished appearance. The shoulder straps shall be uniform in length and setting. In the finished coat, the straps shall be $2\frac{1}{4} \pm \frac{1}{8}$ inches wide at the armhole seam and shall taper to $1\frac{1}{2}$ inches $\pm \frac{1}{8}$ inches at the buttonhole eyelet end.					
	a. Position the shoulder straps with the pointed end of the strap facing toward the edge of the neck and with the raw edge in line with the armhole. The back finished edge of the strap shall be 1/2 inch behind and in line with the shoulder seam. Correct position of the button shall be in alignment with shoulder strap buttonhole and when buttoned, there will be no distortion of strap or shoulder.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
62	<u>Set shoulder straps.</u> (cont'd)					
	b. Stitch the shoulder straps to the coat 3/16 to 1/4 inch from the armhole edge. Trim the shoulder straps even with the armhole where necessary.	301 or 401	SSa-1	10-14	A	A
63	<u>Set sleeves.</u>					
	Finished appearance. The sleeves shall be properly and carefully set and shall be uniformly stitched without twists, gathers, pleats, puckers or raw edges.					
	a. Position the outside of the sleeves on the outside of the coat with notches matching and with the sleeve lining turned back from the armhole edge.					
	b. Join the sleeves to the coat with a 3/8-inch seam, evenly distributing the fullness between notches and catching the end of the the shoulder strap in the stitching.	301 or 401	SSa-1	10-14	A	A
	c. Press the armhole smooth and flat with a heated pressing iron to remove the fullness. Care shall be exercised in pressing the armhole seam in order not to stretch the rmhole.					
64	<u>Baste armhole.</u>					
	a. Baste around inside armhole, positioning yoke lining, shoulder pad, and front lining in place and distributing fullness evenly. Turn the coat on the outside.	101 or Hand				

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
64	<u>Baste armhole.</u> (cont'd)					
	b. Baste around outside armhole adjacent to the armhole seam, forcing out the armhole in the basting. The basting shall extend the entire circumference of the armhole.	101 or Hand				
65	<u>Baste underarm shield to coat.</u>					
	a. Position the underarm shield on the lining side of the coat at the base of armhole, and baste the shield to the coat along the armhole and outer (convex) edges.	101 or Hand				
66	<u>Tack armhole and stitch sleeve head pads.</u>					
	a. Position the sleeve head pad on the sleeve, with the folded edge of the pad approximately 1/8 inch back from the raw edge of the armhole seam and with the front end of the pad matching the notch in the fronts.					
	b. Stitch the sleeve head pad from end to end to the sleeve through the armhole sleeve seam allowance, 1/8 inch from the folded edge of the pad, catching the front and back linings, shields at the base of armhole and shoulder pad in the stitching. Continue stitching the lining around the remainder of the armhole. Trim away the excess material.	Hand		4 Per tack (minimum)	C (Silk)	

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
67	<u>Tack underarm shields to lining.</u> a. Tack bottom edge of underarm shields on the underside to lining. As an alternate, the underarm shield may be joined to the lining by superimposing the seam on the seam joining the binding to the shield. b. In the finished coat, the shields shall measure not less than 2 inches in length from the folded edge of sleeve lining.	Hand		4 Per tack (minimum)	C (Silk)	
68	<u>Join back lining and facing-lining assembly at shoulders.</u> a. Fell the back lining and facing-lining assembly together at the shoulders, securing the top end of the shoulder pleat in the felling. The felling shall be placed over the folded edge of the back lining. -or- Join the back lining and facing lining assembly at the shoulders, securing the top of shoulder pleat in the seam.	Hand		8-10	C (Silk)	
		301 or 401	SSa-1	10-12	A	A
69	<u>Fell sleeve lining at armhole.</u> a. Position the sleeve lining at the armhole, with the back and forearm seam of the sleeve and sleeve lining matching.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
69	<u>Fell sleeve lining at armhole.</u> (cont'd)					
	b. Turn under to top raw edge of the sleeve lining and lap 1/4 to 3/8 inch onto the armhole seam allowance over the front and back lining and underarm shield. Fell the sleeve lining to the coat around the entire armhole, placing the stitching over the folded edge of sleeve lining and distributing the fullness in accordance with good commercial practice. Back stitch 1/8 inch from the felled edge of sleeve lining along the lower armhole from approximately 1-1/2 inches above the forearm seam line in sleeve lining to the side seam line in the body lining.	Hand		8-10	C (Silk)	
	- or -					
	c. Machine stitch lower edge of sleeve lining, at the armhole on the inside, from forearm seam to backarm seam and hand fell the remaining portion as specified in operation 66.b above.	301	SSa-1	12-16	A	A
	d. Machine stitch lower edge of sleeve lining, at the armhole, on the inside from forearm seam to backarm seam and stitch remaining portion of the sleeve lining at the armhole with machine simulated hand felling. A Strobel or Durkoff sleeve felling machine is authorized.	Machine simulated		8-10	C (Silk)	

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
69	<p><u>Fell sleeve lining at armhole.</u> (cont'd)</p> <p>As an alternate, the armhole lining may be felled utilizing a sleeve lining machine that consists of a feed off the arm machine equipped with a lower and upper feed (review specification requirements for felling of sleeve lining in relation to appropriate turn under).</p> <p>(1) Stitch sleeve lining to armhole on inside from front sleeve notch to backarm seam across undersleeve.</p> <p>(2) Stitch the top sleeve lining to armhole on inside from the front armhole notch to top back arm lining seam across the crown of the top sleeve lining.</p> <p>(3) Close the previous left opened forearm seam 1/16 to 3/32 inch from edge.</p> <p>NOTE: It is required that the simulated hand felling produced by machine shall be equal to or better than hand felling.</p>					
		301	SSa-1	10-14	50	50
		301	SSa-1	10-14	50or mer- cer- ized cot- ton 50/2 or3 or ny- lon A	50or mer- cer- ized cot- ton 50/2 or3 or ny- lon A
		301	SSc-1	10-14	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
70	<p><u>Make buttonholes.</u></p> <p>Finished appearance. The buttonholes shall be cut-first type, clean cut, well made and well worked over gimp to fit a 40-line insignia button. The stitching of the buttonholes shall be securely caught in the basic material. The gimp shall be pulled through to the underside of the front. The purling of the buttonholes shall be on the outside.</p> <p>a. Mark the right front in accordance with the marks on the pattern for the locations of four buttonholes. The buttonholes shall be evenly spaced.</p> <p>b. Make one horizontal eyelet-end, square-bar type buttonhole, 1-1/4 inches long at each of the marks. The inside edge of the eyelet end of the buttonhole shall be 5/8 inch from the front edge of the coat.</p> <p>c. Securely bartack the ends of each buttonhole, catching the ends of the gimp in the bartack. Trim the ends of the gimp.</p>					
		Buttonhole		54 Per button (minimum) not including bartack	E (Silk)	F
		Bartack		21 Per bartack	A (Silk)	A
71	<p><u>Clean coat.</u></p> <p>a. Pull and remove all basting thread. Trim all ends of stitching and remove all loose ends of thread from the coat. Remove all spots, stains and shade tickets and markings without injury to the material.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
72	<p><u>Press coat.</u></p> <p>a. The coat shall be well pressed throughout with a heated iron or pressing machine of a type suitable to obtain the desired shape and appearance in accordance with good manufacturing practices.</p> <p>b. Block the shoulders to remove the fullness and press shoulders smooth on a shoulder shaping machine with shoulder straps properly positioned over shoulder seam and pressed flat.</p> <p>c. Press the armholes solid from the inside, creasing the sleeve lining at the edge of the armhole seam allowance in the front, back and armpit of the lower armhole. The armpit and the back of the armhole shall be held short while pressing.</p> <p>d. Block the armholes on a pressing block, shrinking in top sleeves. Sleeves shall not be creased.</p> <p>e. Press the lapels smooth and flat, straightening the edges and working any fullness towards the center of the lapel and removing the fullness by shrinking.</p> <p>f. Press the lapels, uniformly creasing on the lapel breakline from the gorge seam to approximately 3 inches above the top buttonhole. Then roll press the lapel to the front edge of the coat.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
72	<p><u>Press coat.</u> (cont'd)</p> <p>g. Press the collar on a collar machine, creasing on the breakline and shaping to obtain the proper contour while pressing.</p> <p>h. Press bottom edge of coat smooth and flat, exercising care that the lining is not exposed below the bottom edge.</p> <p>i. Press the sides, working the fullness towards the back.</p> <p>j. Press the back smooth and flat, removing all fullness.</p> <p>k. Insert a sleeve pad in the sleeves in order to prevent creasing, and press sleeves smooth and flat.</p> <p>l. Remove all wrinkles and impressions from under the lapels, collar and shoulder straps.</p> <p>m. Press pleats in upper front lining, center back lining and left vent lining smooth and flat.</p> <p>n. Press lining throughout with a heated pressing iron, removing all wrinkles and creases.</p>					
73	<p><u>Mark for buttons.</u></p> <p>a. Mark the location for sewing four 40-line insignia buttons to the left front of the coat, 1-5/8 inches back from the finished edge, to properly engage buttonholes in the right front.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPF
73	<u>Mark for buttons.</u> (cont'd)					
	b. Mark the location for sewing one 27-line insignia button to each shoulder to properly engage with the neck end of the buttonhole in the shoulder straps, in order that on the finished coat, the straps shall lie smooth and flat without twisting or bulging.					
74	<u>Sew on buttons.</u>					
	a. The buttons shall be securely sewn to the coat with the ends of the stitching securely tacked.					
	b. Sew one 27-line insignia button at the mark on each shoulder.	Hand or 301 or 101		4-6 Per button (double thread) 14-16	24/4	
	c. Sew one 40-line insignia button at each of the marks on the left front through all plies.	Hand or 301 or 101		4-6 Per button (double thread) 14-16	24/4	
	d. The insignia buttons on the front shall be sewn with the eagle upright. The shoulder buttons shall be sewn with the head of the eagle towards the edge of the collar.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
75	<p><u>Make buttonhole tab.</u></p> <p>Finished appearance. The sword slit buttonhole tab shall finish smooth and flat without distortion. The stitching shall be uniform and the buttonhole shall be properly positioned. The tab shall finish $2\text{-}3/8 \pm 1/8$ inches long and $2 \pm 1/8$ inches wide.</p> <p>a. Buttonhole tab for sword slit shall be made of one ply of basic material and one ply of rayon lining material.</p> <p>b. Seam together the lining piece and basic material at side and bottom edges of tab $3/16$ inch. Turn and topstitch $1/8$ inch from seamed edge.</p> <p>c. Seam the pieces together $1/8$ inch from raw edges at top end of tab.</p> <p>d. Make a vertical eyelet-end taper-bar type buttonhole, cut $5/8$ inch long, in center of tab with the inside edge of the buttonhole eyelet placed $5/8$ inch above the bottom edge of the tab. The buttonhole shall be well worked over gimp to fit a 22-line sewing hole button. The purling of the buttonhole shall be on the lining side of the tab.</p>	<p>301</p> <p>301</p> <p>Buttonhole</p>	<p>SSe-2 (shows finished seam)</p> <p>SSa-1</p>	<p>10-14</p> <p>12-16</p> <p>60 Per buttonhole (including tack)</p>	<p>A (Silk)</p> <p>A (Silk)</p>	

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
76	<p><u>Set sword slit tab and make opening.</u></p> <p>Finished appearance. Sword slit and tab shall finish without distortion of the coat. All stitching shall be uniform and securely caught in the fabric. The sword slit shall be properly positioned.</p> <p>a. Mark location for sword slit on left front between the back side body seam and the breast dart seam in horizontal alignment with the lower front button and buttonhole, for a distance of 2 inches. Mark sword slit tab 1-3/4 inches from the bottom finished edge for seaming to the coat.</p> <p>b. Position sword slit tab on outside of front with marked lines on tab and front matching. Seam tab to front at marked lines without catching the lining.</p> <p>c. Position welt piece for lower edge of sword slit opening on outside of front with raw edge placed under sword slit tab and abutting tab seam line.</p> <p>d. Seam welt piece to front 1/8 to 3/16 inch from raw edge through the front without catching the lining.</p>					
		301	SSa-1	12-16	40/3 or A	40/3 or A
		301	LSbj-1	12-16	40/3 or A	40/3 or A

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
76	<p><u>Set sword slit tab and make opening.</u> (cont'd)</p> <p>e. Cut the opening for the sword slit midway between the seam linings joining the tab and welt piece to the front, tongue notching each end of the opening. The notches shall be cut to a sufficient depth for proper turning of the tab and welt piece but shall not show on the outside of the finished coat.</p> <p>f. Turn welt piece through opening to inside of coat forming a 1/8 to 3/16 inch wide welt at lower edge of opening. Raise stitch lower edge of opening through the front welt seam and welt 1/16 inch below the seam line joining welt to front.</p> <p>g. Turn down sword slit tab and raise stitch the front 1/16 inch above the joining seam line through the tab seam allowance. Do not catch lining during the raise stitching.</p> <p>h. The ends of the sword slit opening shall be bartacked.</p> <p>i. Properly position left front opening and baste the lining to the front to hold in position for cutting of opening for sword slit tab. Cut opening for sword slit tab in lining to correspond with opening in front.</p> <p>j. Turn under raw edges of lining at cut opening and fell the folded edge to the front welt and top of sword slit tab.</p>	<p>301</p> <p>301</p> <p>Hand</p>	<p>SSbe-2</p> <p>LSq-2</p>	<p>12-16</p> <p>12-16</p> <p>6-8</p>	<p>40/3 or A</p> <p>40/3 or A</p> <p>C (Silk) Stitches</p>	<p>40/3 or A</p> <p>40/3 or A</p>

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
	<u>MAKE SKIRT</u>					
77	<u>Join front and back skirt panels.</u>					
	a. Join the side front panels to the center front panel with a 3/4 inch seam allowance and with notches matching. The ends of the seam shall start and finish evenly at the seam line.	301	SSa-1	12-14	50	50
	b. From the bottom of the zipper notch to the mark at the top of the kick pleat, join the back panels with a 1 inch seam allowance. The ends of the seams shall start and finish evenly at the seam line.	301	SSa-1	12-14	50	50
78	<u>Tape edges of kick pleat.</u>					
	a. The edges of the kick pleat shall be taped from the top of curve to bottom of unfinished hem. Place the left edge of tape to the top raw edge of pleat opening and stitch 1/8 inch from the edge. Turn tape to underside of basic fabric and blindstitch other edge of tape to the underside of skirt.	301	BSa-1	12-14	50	50
79	<u>Overedge seams.</u>					
	a. The raw edges of the seam allowance on the front and back parts shall be neatly overedge stitched.	501 or 503	Efd-1	8-10	70	70
	b. The center back seam shall be overedged together from the bottom of zipper (at the right side notch) to the curve at the top of the kick pleat. The seam shall be pressed to the wearer's left.	501	Efd-1	8-10	70	70

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
79	<u>Overedge seams.</u> (cont'd) NOTE: Care shall be exercised during the overedging operation to ensure that no seam allowance is reduced by more than 1/16 inch.					
80	<u>Tack the kick pleat.</u> a. The pleat shall finish left over right and shall be tacked through all plies from the center seam to the edge of the width of the pleat. (Approximately 2-3/4 inches, slanted downward 1/2 inch over total length.)	301	SSa-1	12-14	50	50
81	<u>Join front and back parts.</u> a. Join the front and back parts of skirt at the side seams with a 1-inch seam allowance and with notches matching.	301	SSa-1	12-14	50	50
82	<u>Press seams.</u> a. Spread open all seams and press smooth and flat with a heated iron or pressing machine. The edges of the back opening shall be folded back in a straight line with the back seam line and well creased.					
83	<u>Pink bottom edge of skirt.</u> a. The raw edge of the bottom of the front and back skirt shall be neatly and evenly pinked with the points of the pinking 1/8 inch in depth. NOTE: Care shall be exercised during the pinking operation to assure that the length of skirt is not reduced by more than 1/16 inch.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
84	<u>Make watch pocket.</u> a. The watch pocket shall be made of one ply of basic material and one ply of poly/cotton twill and shall finish not less than 4 inches wide and 4 inches deep. b. Position both plies of watch pocket face up and with sides and bottom edges even. Join both plies together 3/8 inch from raw edges, 1/2 inch down from top raw edges at each side. or c. The watch pocket may be joined by seaming and overedge stitching the raw edges together in one operation.	301	SSa-1	12-14	50	50
85	<u>Attach watch pocket.</u> a. Position the top inside edge of the poly/cotton twill side of pocket to the top raw edge of the right front of the skirt waist. The notch of the pocket shall be 1 inch in from the side seam. Join the pocket to the skirt waist with a 3/8 inch seam from notch to notch forming a 4 inch wide opening at the top of the waist seam. Turn the pocket up and raise stitch 1/16 inch through twill cloth and front of skirt, catching all plies. b. Notch and turn pocket to the inside and bartack each edge of opening. NOTE: Watch pocket shall be between basic fabric and lining.	301 Bartack	SSa-1	12-14 21-28	50/3 0	50/3 0

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
86	<u>Stitch darts in front and back lining.</u> Finished appearance. The darts shall be tapered to a point at the lower end and shall finish without gathers, puckers or pleats. a. Fold and stitch front and back lining waist darts in accordance with marks and notches as indicated on the pattern. The lower ends of waist darts shall be well tapered to a flat point. b. Press the darts smooth and flat with a heated pressing iron, with the inside folded edge of waist darts towards the center of the lining.	301	OSf-1	12-14	50	50
87	<u>Join lining back parts.</u> Finished appearance. The lining back parts shall be joined without gathers, puckers or pleats. a. Position the lining back parts face to face with edges even and join at the center with a 1-inch seam, from the bottom of zipper mark to bottom of lining.	301	SSa-1	12-14	50	50
88	<u>Join front and back parts of lining.</u> a. Join the front and back parts of lining at the side seam with a 1-inch seam and with notches matching. The back seam shall be joined from the bottom edge of lining to 7-1/2 inches from the top raw edge to provide for the center back opening.	301	SSa-1	12-14	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
88	<u>Join front and back parts of lining.</u> (cont'd)					
	b. The back opening shall be edge stitched 1/8 - 1/4 inch on each side.	301	EFa-1	12-14	50	50
89	<u>Press lining seams.</u>					
	a. Spread open the center back seam and the side seams and press smooth and flat with a heated iron or pressing machine.					
90	<u>Pink seams and bottom edge of lining.</u>					
	a. The raw edge of the seam allowance at the side seams, center back lining, and raw edges at the bottom of the front and back lining shall be neatly and evenly pinked with the points of the pinking 1/8 inch in depth.					
	NOTE: Care shall be exercised during the pinking operation to assure that no seam allowance is reduced more than 1/16 inch.					
91	<u>Make waistband.</u>					
	Finished appearance. On the finished skirt, the outside end of the waistband shall be pointed and the inside end shall be squared.					
	a. The waistband shall be made of a single ply of basic material and a single ply of interlining (twill or fusible).					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
91	<u>Make waistband.</u> (cont'd)					
	b. Position the interlining on the the inside of waistband with bottom edges even. Stitch the interlining to the underside of waistband along the top and bottom edges of interlining with a 1/8- inch seam. The line of stitching shall extend the entire length of waistband but the stitching shall not show on the front of the waistband.	301	SSa-1	12-14	A	A
	or					
	When fusing the interlining to the waistband, position the interlining on the inside of waistband with bottom edges even. Stay stitch is not required.					
	c. Overedge stitch the inside raw edge of waistband.	503 or 504	EFd-1	8-10	70	70
	d. Fold the waistband in half lengthwise face to face with notches matching. Join the two plies together, at the pointed end, with 3/8 inch seam, starting at the folded edge.	301	SSe-2	12-14	50	50
	e. Close the squared end by seaming the two plies together 3/8 inch inch from the bottom raw edges, starting approximately midway between the notches and the end of the waistband, then seam straight across the width of the waistband to close the end.	301	SSe-2 (a)	12-14	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
91	<u>Make waistband.</u> (cont'd)					
	f. Trim the excess material at both ends to 1/8 inch from the seams. Turn the waistband, forcing out the corners and point completely, and edgestitch 1/16 inch from the seamed edges at the pointed and squared ends.	301	SSe-2 (b)	12-14	50	50
	g. Continue to edgestitch along the length of the waistband 1/16 inch from the folded edge.	301	OSf-1	12-14	50	50
	h. The edgestitching may be performed continuously with the top stitching on the outside of the waistband in operation 96.a.					
92	<u>Assemble placket and slide fastener (see Figure 4).</u>					
	Finished appearance. The placket shall be smooth and flat. The folds of the skirt shall completely cover the slide fastener when slide fastener is closed. The stitching shall not interfere with the operation of the slider.					
	a. Fold the placket in half lengthwise, with the right side out. Baste the two plies together along the folded edge.	101	OSf-1	6-8	50	50
	or					
	b. The folded edge may be pressed.					
	c. Overedge stitch the side and bottom raw edges of placket together.	503 or 504	EFd-1	8-10	70	70

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
92	<u>Assemble placket and slide fastener (see Figure 4).</u> (cont'd)					
	d. Place the closed slide fastener on the face (overedge seam to right) side of the placket with the top end of the chain 1/2 inch below the top raw edge of the placket, and with the center of the chain 5/8 to 3/4 inches from the folded edge of placket.					
	e. Join the right half of the fastener to the placket with a single row of stitches 3/16 to 1/4 inch from the chain edge through the tape and both plies of the placket.	301	SSak-1	12-14	50	50
93	<u>Join placket assembly to skirt (See Figure 4).</u>					
	a. Open the slide fastener and place the front half of it on the inside of the right part of the skirt at the back opening, with the top end of the chain positioned 1/2 inch below the top raw edge and the chain positioned even with the creased front edge of the back opening.					
	b. Join the left half of the slide fastener to the skirt with a single row of stitches through the tape and left back panel of the skirt. The row of stitches shall extend from the top edge of the left back panel to 1/4 to 3/8 inch below the bottom end of the chain, and shall be uniformly 5/16 inch from the center edge of the back opening.	301	SSak-1	12-14	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
93	<u>Join placket assembly to skirt</u> (See Figure 4). (cont'd)					
	c. Close the slide fastener and turn the skirt right side out. Position the right back part of the skirt on the placket, holding the right edge of the opening as close as possible to the chain of the slide fastener so that in the finished skirt, the edge of the opening conceals the zipper when the skirt is worn. Join the right back to the placket assembly with a 5/16 inch seam from the folded edge of the right back opening through the slide fastener tape and the placket.	301	LSah-1	12-14	50	50
	d. Topstitch across the bottom end of the opening through the slide fastener tape and the placket with a single row of stitches. The stitching shall not extend past the finished stitching of each side opening.	301	Sv-1	12-14	50	50
94	<u>Joining lining to skirt.</u>					
	Finished appearance. The right side of lining shall be $3/4 \pm 1/8$ inch from the folded edge of placket and the left side lining shall be $1/4 \pm 1/8$ inch from the folded edge of back opening.					
	a. Join lining to the skirt at the waist with a 1/4 inch seam from the respective seams with the right side seams matching equally distributing the fullness. The back opening of the lining shall not overlap the slide fastener.	301	SSa-1	12-14	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NOL	BOB/ LPR
95	<u>Join waistband to skirt, with hangers.</u>					
	a. Fold the 3/4 inch wide strip of bias binding in half lengthwise, turning edges to the inside to finish 1/4 inch wide, and seam 1/16 inch from turned edges.	301	SSc-1	10-14	A	A
	b. The hangers shall be positioned one at the right side seamline and one at the left side seamline.					
	c. In the finished skirt, the length of the hanger loop shall be $1-5/8 \pm 1/8$ inches, measured from the bottom edge of the waistband to the end of the loop.					
	d. Position the waistband on the outside of the skirt, with notches at the pointed end of waistband even with the left back edge of skirt, with the raw edge of the waistband even with the top raw waist edge of skirt and with the notches at the square end of waistband matching the right back folded edge of skirt.					
	e. Join the outside part of the waistband to the skirt with a 3/8 inch seam, with the braid for the hanger folded in half to form a loop and with the ends of the loops placed on the inside of the skirt and the watch pocket caught in the stitching.	301	BSr-1 (a)	12-14	50	50

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
96	<p><u>Topstitch waistband.</u></p> <p>Finished appearance. The waistband shall be sewn on smoothly and evenly and shall have a flat appearance without gathers, puckers, pleats or other distortions either in the waistband, front part or back part, and shall be even width along the entire length. The waistband shall be $1\frac{1}{4} \pm \frac{1}{8}$ inch wide. The pointed end shall extend $1\frac{1}{2} \pm \frac{1}{8}$ inches beyond the center back edge of the back opening, and the squared end shall extend $2 \pm \frac{1}{8}$ inches beyond the back edge of the back opening.</p> <p>a. Turn back the waistband and topstitch the waistband to the skirt $\frac{1}{16}$ inch from the raised edge, catching the overedge stitched portion in the stitching, and with the stitching extending the entire length of the waistband.</p>	301	BSr-2 (b)	12-14	50	50
97	<p><u>Make buttonholes.</u></p> <p>Finished appearance. The buttonholes shall be clean cut, well made and correctly positioned. The stitching shall be securely caught in the basic material. The buttonholes shall be well worked over gimp to fit 27-line buttons. The purling of the buttonholes shall be on the outside of the waistband.</p>					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
97	<u>Make buttonholes.</u> (cont'd)					
	a. Make a 3/4-inch-long horizontal, eyelet-end, taper-bar type buttonhole through the center of the pointed and squared ends of waistband with the inside purled edge of the eyelet 1/2 to 5/8 inch from the finished ends to waistband.	Buttonhole		52-54 Per buttonhole (including tack)	0/3	0/3
98	<u>Clean skirt.</u>					
	a. All ends of stitching shall be trimmed and the loose threads removed from skirt. Pull and remove any basting threads.					
	b. Any spots, stains and shade tickets or markings shall be removed without injury to the material.					
99	<u>Press skirt.</u>					
	a. The entire skirt shall be pressed smooth with a heated steam pressing iron or steam pressing machine. Press marks and gloss shall be removed.					
100	<u>Sew on buttons.</u>					
	a. Close the slide fastener and mark the inside and outside ends of waistband with the location for sewing on the buttons to correspond with the eyelet of buttonholes.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
100	<p><u>Sew on buttons.</u> (cont'd)</p> <p>b. The buttons shall be positioned to engage with the eyelet end of buttonholes, so that on the finished skirt, the ends of the waistband lie smooth and flat without twisting, bulging or other distortion.</p> <p>c. Securely sew a 27-line button at each mark. The thread ends of hand sewn buttons shall be securely tacked. The button on the outside of waistband shall be sewn through all plies of waistband. The stitches for the button sewn to the inside of the waistband shall not be visible on the outside.</p>	Hand or 101 or 301		4-6 Per buttonhole (double thread) 14-16	16/4	
101	<p><u>Prepare for packing.</u></p> <p>a. Examine skirt.</p> <p>b. An envelope containing the tape for the skirt hem shall be attached by string to the left hanger loop.</p>					

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3.7 Finished measurements. The finished uniform (coat and skirts) shall conform to the measurements shown in Tables II and III.

Table II. Finished measurement 1/

Size	1/2 Bust 2/ (Short, Regular, Long)	Back Length 3/ Short Regular Long			Sleeve Length 4/ Short Regular Long		
	inches	inches	inches	inches	inches	inches	inches
X0	16-3/4	23-7/8	25-1/8	26-3/8	16-3/4	17-3/4	18-3/4
2	17-1/4	24-1/8	25-3/8	26-5/8	16-3/4	17-3/4	18-3/4
4	17-3/4	24-3/8	25-5/8	26-7/8	16-3/4	17-3/4	18-3/4
6	18-1/4	24-1/2	25-3/4	27	16-3/4	17-3/4	18-3/4
8	19	24-3/4	26	27-1/4	16-3/4	17-3/4	18-3/4
10	19-3/4	25	26-3/16	27-3/8	16-3/4	17-3/4	18-3/4
12	20-1/2	25-1/8	26-3/8	27-5/8	16-3/4	17-3/4	18-3/4
14	21-1/2	25-3/8	26-5/8	27-7/8	16-3/4	17-3/4	18-3/4
16	22-1/2	25-1/2	26-3/4	28	16-3/4	17-3/4	18-3/4
18	23-1/2	25-3/4	27	28-1/4	16-3/4	17-3/4	18-3/4

1/ Tolerance on measurements as noted below. Tolerance is on 1/2 bust measurement.

2/ Bust measurement taken with coat buttoned from folded edge to folded edge in line with pit of armhole. Tolerance $\pm 3/8$ inch.

3/ Back length measurement taken along center back seam from lower edge of the undercollar to bottom edge of coat. Tolerance -3/8, +5/8 inch.

4/ Sleeve length measurement taken along forearm seam from the armhole seam line to bottom edge of sleeve. Tolerance $\pm 3/8$ inch.

Table III - Finished measurements

Size	Short		
	Waist 1/	Seat 2/	Length 3/
X0	22-1/2	34-1/2	26
2	23-1/2	35-1/2	26
4	24-1/2	36-1/2	26
6	25-1/2	37-1/2	26
8	27	39	26
10	28-1/2	40-1/2	26
12	30	42	26
14	32	44	26
16	34	46	26

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

1. First article inspection (see 4.4).
2. Quality conformance inspection (see 4.5).

4.3 Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in MIL-STD-1608 and MIL-STD-1609.

4.4 First article inspection. When first article is required, inspection shall be made of a completely fabricated uniform for all provisions of this specification.

4.5 Quality conformance inspection. Inspection shall be performed in accordance with MIL-STD-1608 and MIL-STD-1609.

4.5.1 Testing of components. Testing of components shall be in accordance with the applicable subsidiary specifications and standards to the extent applicable, except that this specification shall govern in the event of conflict. In addition to testing provisions contained in subsidiary specifications, testing shall be performed on components listed in Table IV for characteristics noted. Wherever applicable, tests shall be conducted in accordance with methods prescribed in FED-STD-191.

4.5.2 In-process inspection. Inspection shall be performed during the manufacturing of the end item to ascertain that the operations are performed as specified herein. The Government reserves the right to determine the acceptability of construction methods not performed in accordance with specified requirements for operations or subassemblies.

4.5.3 Examination of the end item. Prior to the formation of a lot and as a final step in the contractors production control plan, each coat shall be buttoned on a model form and examined for those defects identified by an asterisk (*) and listed as elected defects in MIL-STD-1608. Any coat or skirt containing a selected defect shall not be included in the end item lot. Skirts shall be examined for those defects noted in MIL-STD-1609.

4.5.3.1 Finished measurement examination. The provisions for the finished measurement examination of the finished coat and skirt shall be as specified in MIL-STD-1608 and MIL-STD-1609 and as outlined in 3.7.

4.5.3.2 Sampling for testing. Unless otherwise specified in subsidiary specifications, testing shall be in accordance with the following. The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified.

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

4.5.4 Examination of packaging. The examination for compliance with packaging, packing and marking requirements shall be as specified in MIL-STD-1608 and MIL-STD-1609.

4.5.5 Matching coat and skirt (shade and size). Any uniform mismatched for shade or size shall be scored as a defect. Examination for matching shall be conducted after coats and skirts have been assembled and presented as a unit (one coat and one skirt) for inspection.

5. PACKAGING.

5.1 Preservation. Preservation shall be commercial as specified in ASTM D 3951.

5.2 Packing. Packing shall be commercial as specified in ASTM D 3951.

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

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory).

6.1 Intended use. The uniforms covered by this specification are intended for wear by female personnel of the U. S. Marine Corps.

6.2 Ordering data.

6.2.1 Acquisition requirements. Acquisition documents should specify the following:

- (a) Title, number and date of this specification.
- (b) Size required (see 1.2).
- (c) Whether first article is required (see 3.2).
- (d) Number of uniforms in first article (see 3.2).

6.3 Samples and shade samples. For information regarding the availability of samples of the coat and skirt and of standard shades specified, address inquiries to the acquiring activity issuing the Invitation for Bids.

6.4 First article. First article examination, test and approval shall be as specified by the contracting officer (see 3.2).

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6.5 Figures. Figures 1 through 7 are furnished for information only. To the extent of any inconsistencies between the written specification and the figures, the specification shall govern.

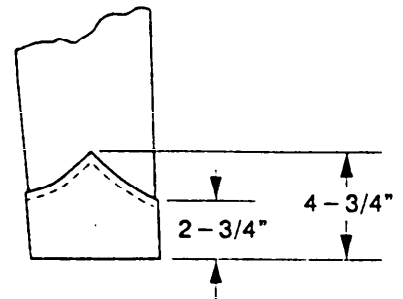
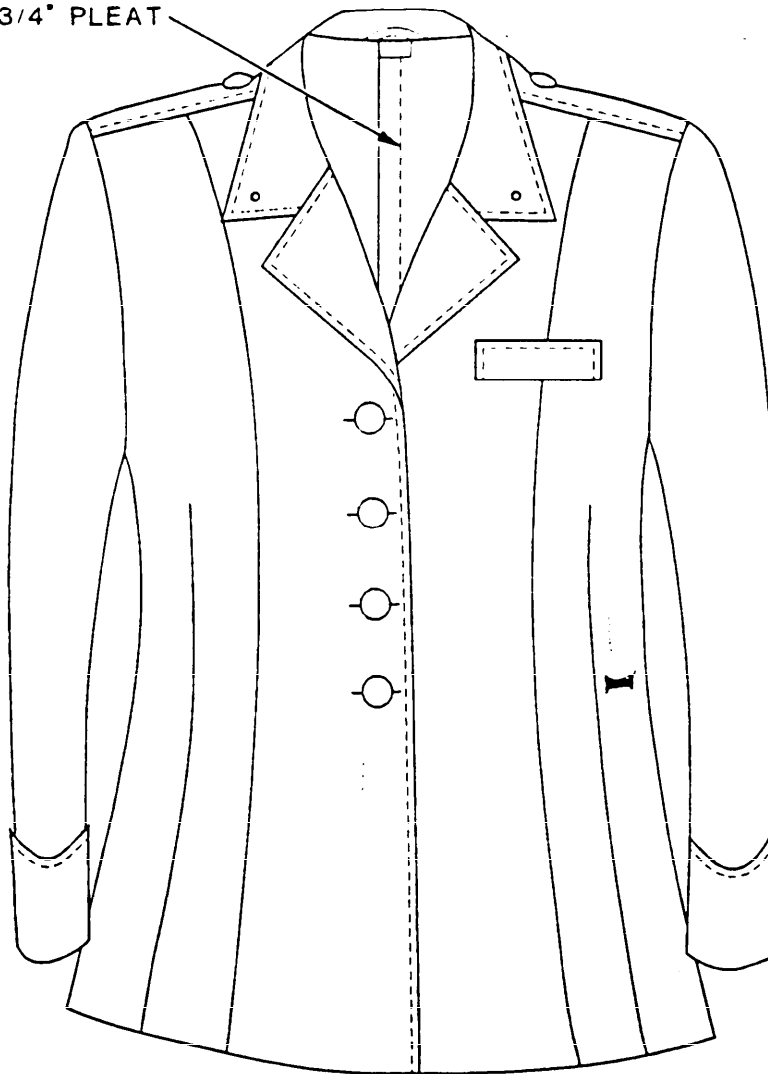
6.6 Subject term (keyword) listing.

Coat
Gabardine, Polyester/Wool
Skirt
Women's

Preparing Activity:
Navy - MC
Project No. 8410-N839

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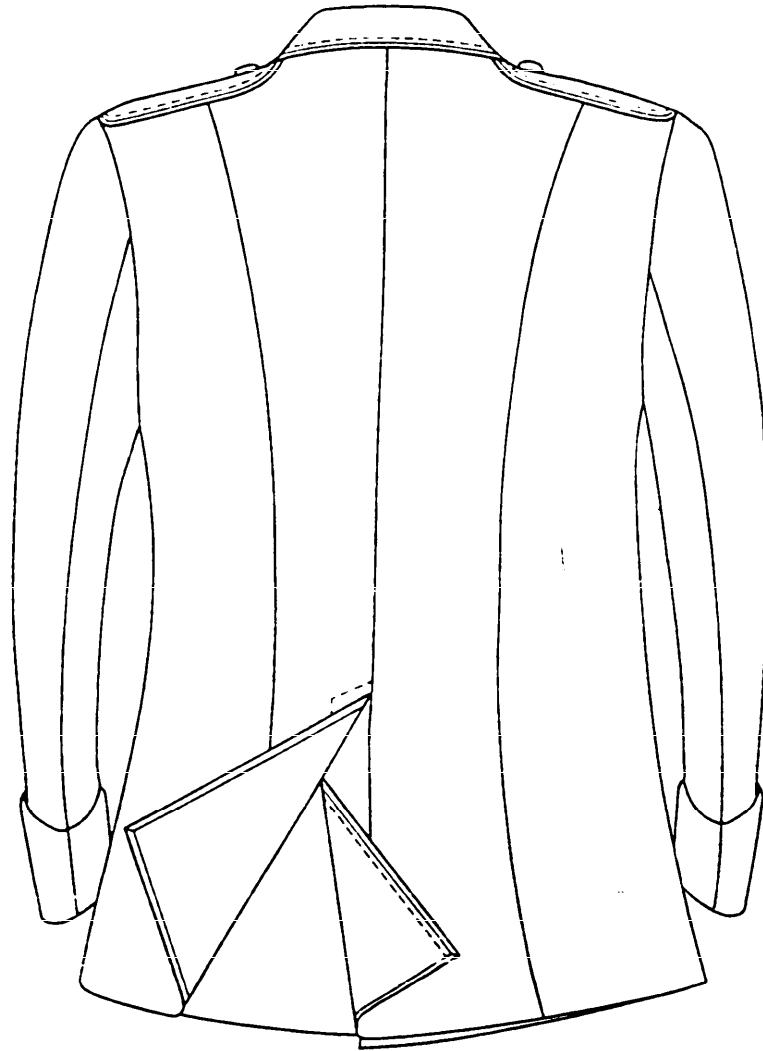
3/4" PLEAT



FRONT VIEW

Figure 1: Uniform, Woman's White

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BACK VIEW

Figure 2: Uniform, Woman's White

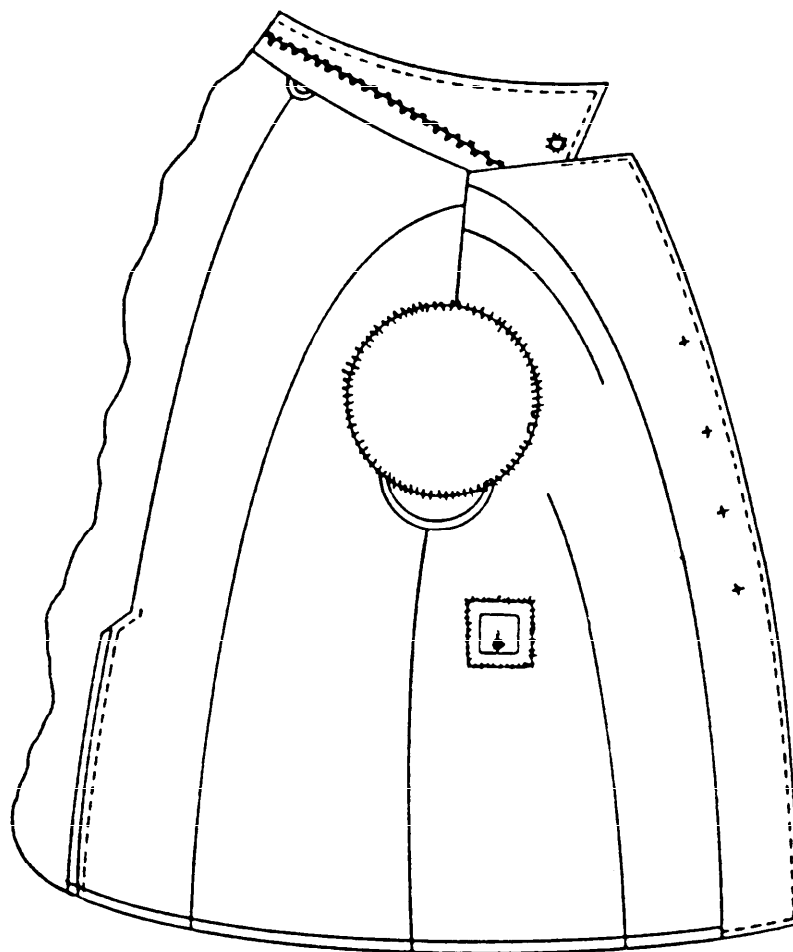


Figure 3: Uniform, Woman's White

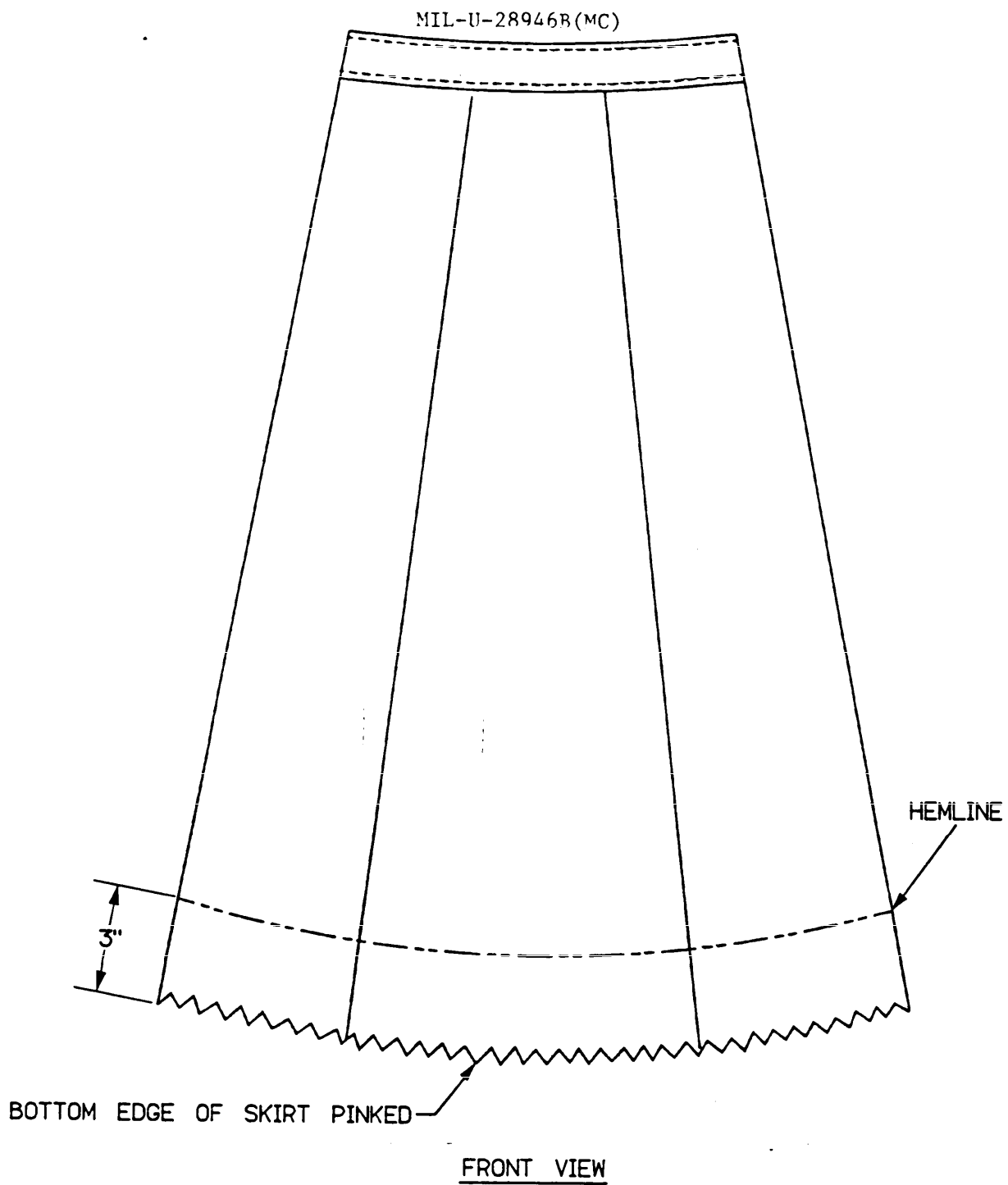
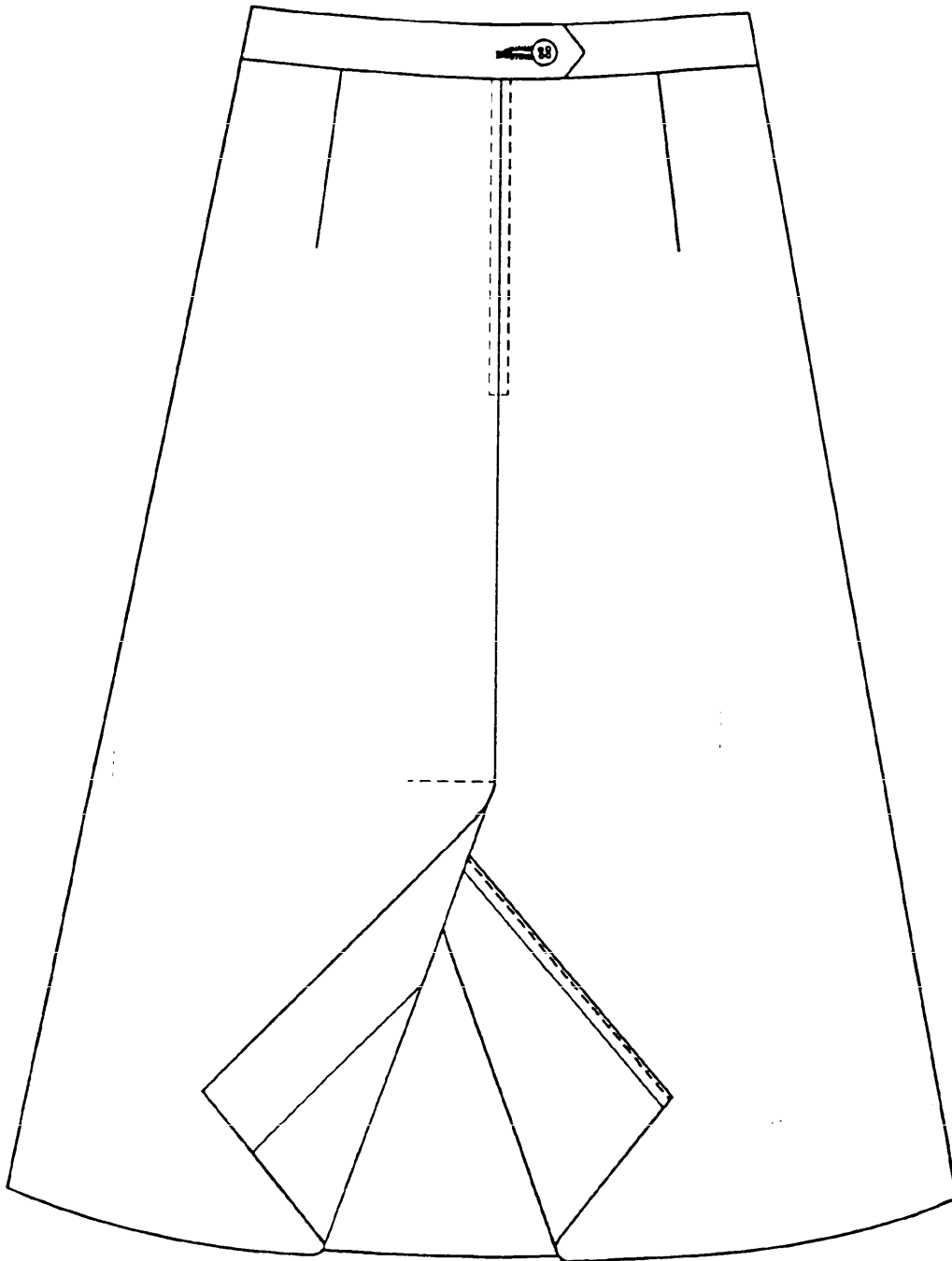


Figure 4: Uniform, Woman's White

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BACK VIEW

Figure 5: Uniform, Woman's White

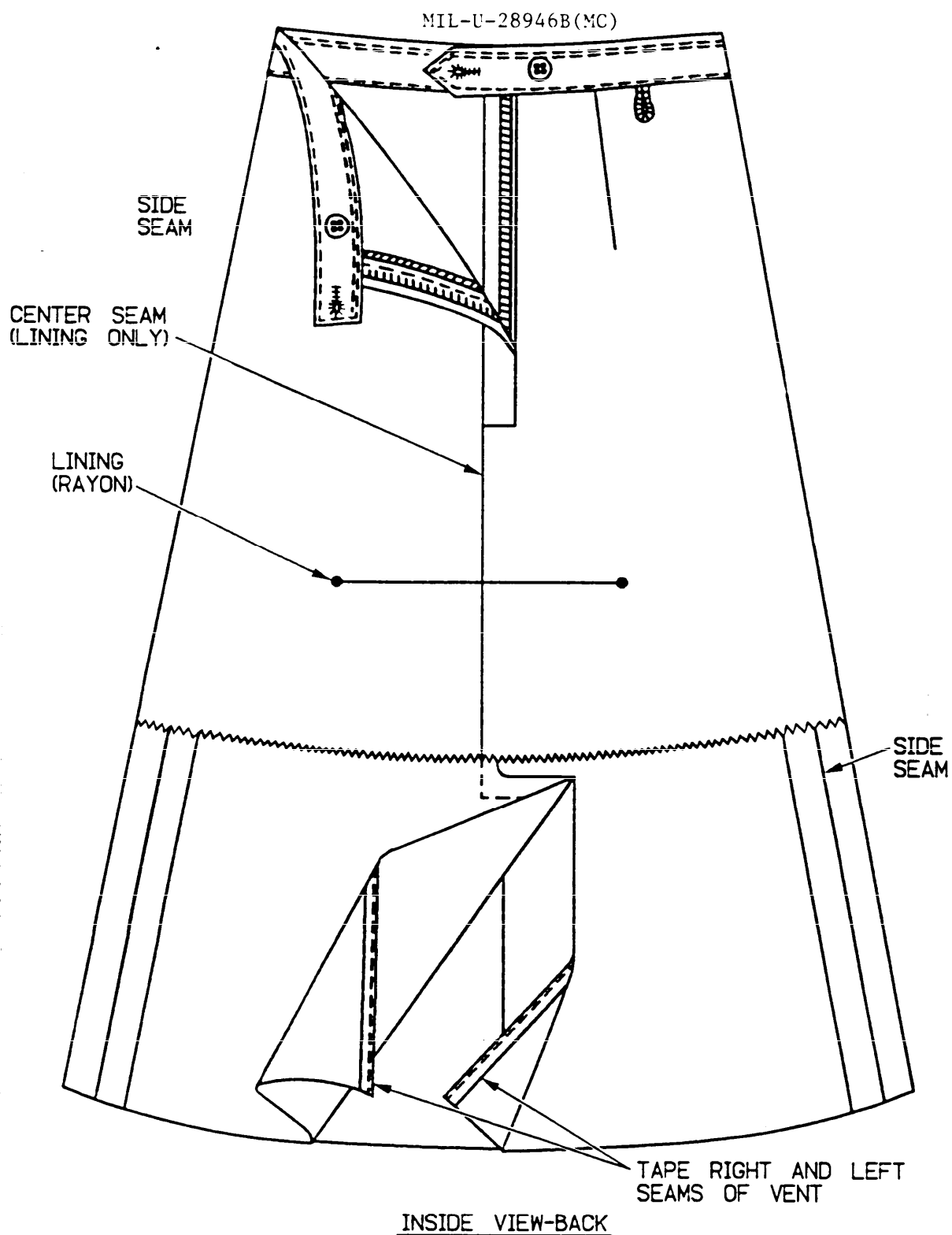


Figure 6: Uniform, Woman's, White

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

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

I RECOMMEND A CHANGE:

1. DOCUMENT NUMBER
MIL-U-28946B(MC)

2. DOCUMENT DATE (YYMMDD)
23 MAY 1994

3. DOCUMENT TITLE

UNIFORM, WOMAN'S: WHITE; DRESS (OFFICER'S)

4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)

5. REASON FOR RECOMMENDATION

6. SUBMITTER

a. NAME (Last, First, Middle Initial)	b. ORGANIZATION	
c. ADDRESS (Include Zip Code)	d. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (If applicable)	7. DATE SUBMITTED (YYMMDD)

8. PREPARING ACTIVITY

a. NAME COMMANDER	b. TELEPHONE (Include Area Code) (1) Commercial (703) 640-4584 (2) AUTOVON 278-4584
c. ADDRESS (Include Zip Code) PROGRAM SUPPORT DIRECTORATE, PSE-C/S MARCORSSCOM, 2033 BARNETT AVENUE SHITE 315 QUANTICO VA 22134-5010	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340