

INCH-POUND

MIL-V-29389A(MC)

14 April 1994

SUPERSEDING

MIL-V29389(MC)

17 November 1980

MILITARY SPECIFICATION

VEST, MAN'S: SCARLET, DRESS (GENERAL OFFICER'S)

This specification is approved for use by 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 scarlet vest for wear by general officers.

1.2 Classification. The vest 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>	<u>X-Long</u>
36	36	36	36
38	38	38	38
40	40	40	40
42	42	42	42
44	44	44	44
	46	46	

1.3 Individual orders. When the vest is custom tailored to an individual order, this specification shall govern, except the detailed 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.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to the Commander (PSC), 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 8405

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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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-50196	- Thread, Silk
A-A-50198	- Thread, Gimp, Cotton, Buttonhole
A-A-52094	- Thread, Cotton
DDD-L-20	- Label, For Clothing Equipage, and Tentage, (General Use)
DDD-T-86	- Tape, Textile, Cotton, General Purpose (Unbleached, Bleached or Dyed)
PPP-B-676	- Boxes, Setup

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MIL-C-368	- Cloth, Satin, Rayon and Cloth, Twill, Rayon
MIL-B-3461	- Buttons, Insignia, Metal, Uniform and Cap
MIL-C-17757	- Box, Shipping, Fiberboard (Modular Sizes)
MIL-C-21115	- Cloth, Tropical, Wool, Polyester/Wool
MIL-C-44296	- Cloth, Fusibles

STANDARDS**FEDERAL**

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

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MIL-STD-105	- Sampling Procedures and Tables for Inspection By Attributes
MIL-STD-129	- Marking for shipment and Storage

(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 Lexington Avenue, New York, NY 10016).

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(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).

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 has 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, wool, tropical, scarlet shade 2502 (see 6.3), 10.5 ounce, conforming to type I, class 1 of MIL-C-21115.

3.3.2 Lining. The material for the back, face interlining, hanging pockets, back straps and eyelet opening and for lining the fronts shall be cloth, rayon, scarlet shade 2506 (see 6.3), 4.5 ounce, conforming to class 3 of MIL-C-368.

3.3.3 Front interlining. The material for interlining the vest fronts and pocket welts shall be cloth, fusible, conforming to class 3 of MIL-C-44296.

3.3.4 Tape. The tape for the breakline for the lapel front, button edge and for reinforcing the folded edge of the pocket welt and front armholes shall be cotton, unbleached, 1/4 inch wide conforming to type III, class 1 of DDD-T-86, except the requirement for nonfibrous material shall not apply.

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3.3.5 Thread.

3.3.5.1 Silk thread. The silk thread shall conform to A-A-50196 except the requirement for extractable material shall not apply; type I, ticket No. A, 3-ply for eyelets, bartacking and top and edgestitching; ticket No. B and F, 3-ply for buttonholes, needle and bobbin respectively; type III, ticket No. C, 2-ply for handfelling.

3.3.5.2 Cotton thread. All inside seaming and stitching shall be accomplished with cotton thread conforming to type IC2, ticket No. A, 3-ply of A-A-52094. The thread for basting shall be of good commercial grade.

3.3.5.3 Color and colorfastness. All thread except basting thread shall be dyed scarlet shade W, Cable No. 66040, and shall show good fastness to wet (dry) cleaning and, in addition, the silk thread shall show good fastness to light. All colorfastness tests shall be conducted as specified in the applicable thread specification. Basting thread shall be white or unbleached.

3.3.6 Gimp. The buttonhole gimp shall be cotton, No. 8, soft or glazed finish, conforming to type I or type II of A-A-50198. The color of the gimp shall be scarlet shade W, Cable No. 66040, and shall show good fastness to wet (dry) cleaning.

3.3.7 Buttons. The buttons shall be metal, gold plated, insignia, officers' design, 22-line, regular shank, conforming to type I, style 4, class 4, subclass 1 of MIL-B-3461.

3.3.7.1 Toggles, ring. The insignia buttons specified in 3.3.7 shall be secured to the vest with ring type toggles conforming to the requirements of MIL-B-3461.

3.3.8 Buckle. The buckle shall be made of a rust-resistant metal, nickel plated, with outside overall dimensions of 1 inch by 7/8 inch. Inside opening for width of strap shall be 3/4 inch and inside opening for thickness of strap shall be 1/4 inch. Length of double prongs shall be 11/32 inch to 13/32 inch.

3.3.9 Labels. Each vest shall have an identification label and a size label conforming to DDD-L-20 as specified herein. The vest is intended to be dry cleaned, therefore, the labels shall show fastness to dry cleaning.

3.3.9.1 Identification label. The identification label shall be type I, class 1 of DDD-L-20 and shall measure not less than 2-1/2 by 1-1/2 inches. The content and format shall be as follows:

Nomenclature (Item description)
Contract Number
Name of Contractor
Wool Products Information Act

NOTE: Size of characters for "Name of Contractor" shall be minimum 6 point, approximately 1/16 inch.

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3.3.9.2 Size label. The size label shall be type I, class 2 of DDD-L-20 and shall measure not less than 1-1/2 inches by 1 inch. The label shall consist of the numerical size designation specified in 1.2, followed by the letter S, R, L or XL for Short, Regular, Long or Extra Long respectively, as shown by the following example:

40 R

3.4 Design. The vest shall be in the U. S. Marine Corps design shown on figures 1 through 3 (see 6.5), a fully lined, four button, single breasted vest with four worked eyelets in the right front for detachable buttons, front and back waist darts, two-piece back, two hanging pockets with welts shawl type lapel and adjustable back straps to buckle.

3.5 Patterns. Standard patterns will be furnished to the contractor by the Government. The standard patterns shall not be altered in any way and shall be used only as a guide for cutting the contractor's working patterns. the contractor's working patterns shall be identical to the standard patterns. The standard patterns provide 3/8 inch allowance for joining front and side front, shoulder, bust dart and back seam and 1/4 inch allowance for all other seams, with a side outlet according to the pattern. Standard patterns show size and are marked and notched for proper cutting, placement and assembly of component parts.

3.5.1 List of pattern parts. The vests shall be cut from the specified materials in accordance with the pattern parts as follows:

Item	Pattern Nomenclature	No of Cut Parts
Material: Cloth, Tropical, Wool		
1.	Front	2
2.	Front facing	2
3.	Pocket welt	2
Material: Cloth, Rayon (Lining)		
4.	Back	4
5.	Front	2
6.	Pocket	4
7.	Eyelet opening lining	1
8.	Facing interlining	1
9.	Strap, adjustment	2
Material: Cloth, Nonwoven Fusible		
10.	Front	2
11.	Pocket welt	2
	Marker	
12.	Eyelet	

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3.6 Construction.

3.6.1 Manufacturing requirements. The vests shall be manufactured in accordance with the operations and the stitch, seam and stitching type specified in Table I. The contractor is not required to follow the exact sequence of the operations as listed in Table I, but all operations specified shall be used to manufacture the vests.

3.6.1.1 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 indicate the minimum and maximum number permitted.

3.6.1.2 Tacking and backstitching. Ends of seams and stitching produced with 301 type stitch, when not caught in other seams or stitchings 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.

3.6.2 Shade marking. The component parts of the vest, except those parts which may be cut from ends (see 1.d), shall be shade marked to insure a uniform shade size throughout the garment. Any method of shade marking may be used except:

- (a) Corrosive metal fastening devices.
- (b) Sew-on shade tickets.
- (c) Adhesive type tickets where adhesive causes discoloration or whose adhesive mass adheres to the material upon removal of the tickets.
- (d) Any marking medium which would tend to leave a permanent mark.

3.6.3 Fusing operations. The fusing operations for fusing the fusible interlining specified in 3.3.3 to the basic fabric of the outer shell specified in 3.3.1 should be performed on a fusing press. Specific settings (see 6.6) for the particular fusing style and press to be used should be obtained from the supplier of the fusible material so that optimum results can be obtained. Test shall be as specified in 4.5.4.

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TABLE I. MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
1	<u>Cutting.</u> a. Cut vest in strict accordance with patterns furnished. b. Cut all materials in the direction indicated by the directional lines on the patterns. c. Cut all wool components of the vest from one piece of basic material. d. Cut front lining, backs and adjustment straps from one piece of rayon material. All other rayon parts may be cut from ends. e. Cut the vest front and pocket welt interlining in accordance with the pattern furnished. f. The use of drill holes is prohibited.					
2	<u>Replacement of damaged parts.</u> a. Replace at time of cutting any part containing damages such as holes or seriously weakening defects such as smashes, multiple floats, and slubs likely to develop into holes. b. Replace any part damaged during the manufacturing process by needle chews which may be expected to develop into a hole, scissor or knife cuts, tears, mends or burns.					
3	<u>Shade marking.</u> a. Mark all component parts cut from one piece of basic and lining materials, to insure uniform shade and size throughout the vest. b. The use of tickets with metal fastening devices is prohibited on the rayon material.					

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
3	<u>Shade marking.</u> (cont'd) c. Adhesive type shade ticket, when used, shall be adhered to the inside of the vest.					
4	<u>Labeling.</u> Finished appearance. The labels shall be correctly positioned and securely attached. a. Position the identification label on front lining approximately 1 inch from the finished side seam and approximately 4 inches from armhole and seam on all sides 1/8 inch from each edge.	301	LSbj-1	10-14	A	A
	b. The size label shall be centered on the inside left back 1-1/2 to 2 inches below the neck and seamed 1/8 inch from all edges.	301	LSbj-1	10-14	A	A
5	<u>Make pocket welt.</u> Finished appearance. The welt shall be uniformly made and stitched, and shall finish smooth and flat without twists, puckers or pleats. a. The welt shall be made of one ply of basic material and one ply of interlining. b. Position welt interlining to the inside of each welt and fuse (see 3.6.3). c. Fold the welt at the notches, and close the ends of the welt with a 1/4 inch seam. Trim the corners of the welt for proper turning.	301	SSe-2	10-14	A (Silk)	A
	d. Turn the welt right side out, completely working out the seamed edges and corners. Edgestitch the welt uniformly 1/16 inch from the seamed and folded edges.	301	SSe-2 (b) (seame edges) OSf-1 (folded)	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
6	<p><u>Make adjustment straps.</u></p> <p>Finished appearance. The strap shall be two-piece, uniform in appearance and shall finish smooth and flat without twists, pleats, puckers or other distortions. The seam shall be centered on the underside of the strap. The strap shall finish 1-1/4 to 1-1/2 inches wide at the wide end and 5/8 to 3/4 inch wide at the narrow end.</p> <p>a. Each strap shall be made of a single ply of rayon material.</p> <p>b. Fold the material for each strap in half lengthwise forming two plies. Seam the two plies together along the length, 1/4 inch from the raw edge.</p> <p>c. Spread open the seams and press smooth and flat with a heated pressing iron.</p> <p>d. Position the seam at the center of the strap and close the narrow end with a seam 1/4 inch from the raw edge.</p> <p>e. Trim the corners at the narrow end, turn strap through the open end, completely working out the corners and seam.</p> <p>f. Press the strap smooth and flat with a heated pressing iron or pressing machine with the seam line positioned in the center.</p>	301	SSa-1	10-14	A	A
		301	SSa-1	10-14	A	A
7	<p><u>Make fronts.</u></p> <p>a. Position the left and right front interlining on the underside of their respective vest fronts and fuse (see 3.6.3).</p>					

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
7	<u>Make fronts. (cont'd)</u> b. Position facing rayon lining on the inside of right front with front and bottom edges even. Stitch the two plies together 1/8 inch from bottom and front edge. c. Position a 1 inch wide by 6 inch long strip of fusible material on the upper and back edge of lining covering the raw edges and fuse (see 3.6.3).	301	SSa-1	10-14	A	A
8	<u>Seam darts at fronts.</u> Finished appearance. The darts shall be properly positioned and finished without pleats, puckers or gathers. a. Fold lower front and interlining, matching the cut edges of the waist darts. Seam lengthwise along the entire length of the darts starting 3/8 inch from the cut edges at the lower end and tapering to a point at the upper end. b. Spread open the cut edges of the darts. Press darts smooth and flat with a heated pressing iron.	301	SSa-1	10-14	A	A
9	<u>Set welt and hanging pocket.</u> Finished appearance. The welt and hanging pocket shall be set to the fronts smooth and flat and without twists, gathers, puckers, raw edges or distortion. a. Mark the fronts for the position of the pockets in accordance with the marks on the pattern. Mark the welt 1 + 1/4 inch from the folded edge for proper sewing to front.					

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TABLE I. MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
9	<p><u>Set welt and hanging pocket.</u> (cont'd)</p> <p>b. Position welt on the outside of fronts with the mark on the welt and front matching and with the raw edge towards the upper edge of front.</p> <p>c. Seam the welt to the fronts at the mark through the interlining.</p> <p>d. Position one ply of pocket lining on outside of front with one edge under the raw edge of the welt and abutting the welt seam. Stitch the pocket lining to the front through the interlining 3/8 inch from the raw edge of the lining.</p> <p>e. Cut the pocket opening midway between the seams and tongue notch each end of the opening. The opening shall not extend beyond the ends of the welt.</p> <p>f. Turn the pocket lining and the raw edge of welt through the pocket opening, with the folded edge of the welt towards the top of the front.</p> <p>g. Position the other ply of pocket lining on the inside of front even with the raw edge of welt. Seam together 3/8 inch from the raw edge.</p> <p>h. Close the pocket along the sides and bottom, tacking the ends of the pocket opening, and catching the tongue notches in the stitching. The row of stitches at the sides shall be in line with the ends of the pocket opening. The row of stitches at the bottom of the pocket shall be 3/8 to 1/2 inch from the raw edge.</p>					
		301	SSa-1	10-14	A	A
		301	SSa-1	10-14	A	A
		301	SSa-1	10-14	A	A
		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
9	<u>Set welt and hanging pocket.</u> (cont'd)					
	i. Tack the ends of the welt to the front through the interlining. The stitching shall be adjacent to the edgestitching for the welt.	301	SSa-1	10-14	A	A
10	<u>Dress left front and left facing.</u>					
	a. Dress left front and facing from top edge to lower end for eyelet stand as indicated by marks on pattern.					
1	<u>Stitch bridle tape to lapel.</u>					
	Finished appearance. The bridle tape shall be stitched along the breakline with the proper tensions to allow the lapel to roll properly in the finished vest.					
	a. Position the 1/4 inch wide bridle tape on the interlining side of the fronts along the breakline of lapel and with the front edge of the tape in line with the breakline. The tape shall extend from the gorge to approximately 1 inch above the lower edge of lapel.					
	b. Stitch the tape through the front of the vest evenly, smoothly and with normal tension, holding the tape taut and working in 1/2 to 5/8 inch fullness along the breakline. The tape shall be stitched 1/16 inch from each edge.	301	SSau-2	10-14	A	A

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TABLE I. MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
12	<p><u>Make eyelets in right front.</u></p> <p>Finished appearance. The eyelets shall be worked with the purling on the outside of the front, and shall finish with 1/8 inch diameter opening. All stitches shall be securely caught in the fabric. The center of the eyelets shall be uniformly 1/2 inch minimum and 5/8 inch maximum from the finished front edge of the vest and shall be evenly spaced.</p> <p>a. Mark the right front for the location of four eyelets for removable insignia buttons in accordance with marks on patterns.</p> <p>b. Make an eyelet at each mark on the right front, through the front and interlining.</p>	Eyelet		21 Per eyelet	A (Silk)	A
13	<p><u>Make eyelet opening.</u></p> <p>a. Position lining for eyelet opening on outside of right front facing with edge of facing and lining even, and with notches matching. Stitch lining to facing from upper to lower notches with a 3/8 inch seam.</p> <p>b. Extend the depth of the notches up to the lining facing seam. Turn lining to the underside of the facing and edgestitch 1/16 to 1/8 inch from the seamed edge.</p> <p>c. Stitch the front raw edge of lining and facing together 1/8 to 3/16 inch from the raw edge. Trim excess lining if necessary.</p>	301	SSe-2 (a)	10-14	A (Silk)	A
		301	SSe-2 (b)	10-14	A	A
		301	SSa-1	10-14	A (Silk)	A

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TABLE I MANUFACTURING REQUIREMENTS

N.	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
14	<p><u>Seam facing to front lining.</u></p> <p>Finished appearance. The lining shall be properly and carefully aligned and seamed to the facing so that in the finished vest, the lining shall be smooth and flat along the facing without creases, bulges, overlapping of excess material, or other defect or distortion. The eyelet opening shall not gap or be distorted.</p> <p>a. Position right and left front linings on the respective facing with the notches at back edge of facing and front edge of lining matching.</p> <p>b. Join front edge of the right right front lining to the back edge of the respective facing with a 3/8 inch seam from the notch at the upper edge of facing to top notch for the eyelet opening and from the bottom notch for the eyelet opening to the lower edge of facing, leaving an opening between notches.</p> <p>c. Form a 3/16 to 1/4 inch hem in the lining, from top to bottom eyelet opening notches, turning under the raw edge and catching the turned under edge in the stitching 1/16 inch from the inner folded edge of the hem.</p> <p>d. Tack both ends of the eyelet opening.</p> <p>e. Join lining to left facing from the notch at the upper edge to the lower edge of the facing.</p>			=		
		301	SSa-1	10-14	A	A
		301	EFb-1	10-14	A	A
		301	SSa-1	10-14	A	A
		301	SSa-1	10-14	A	A

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
15	<p><u>Make pleat in front lining.</u></p> <p>Finished appearance. The pleat shall finish smooth and flat without puckers or other distortion, and the folded edge on the outside of the lining shall be towards the back.</p> <p>a. Fold the front lining in accordance with the notches in the pattern and stitch across the width of the pleat 1/8 to 3/16 inch from each end.</p> <p>b. Press the pleat smooth and flat with a heated pressing iron.</p>	301	SSa-1	10-14	A	A
16	<p><u>Join back and seam darts.</u></p> <p>Finished appearance. The back seams shall start and finish evenly and shall be smooth and flat without gathers, puckers or pleats.</p> <p>a. The inside and outside back, shall each be made from two plies of rayon lining.</p> <p>b. Properly position the respective backs with edges even and seam together along the center back from the neck to the bottom edge with a 3/8 inch seam.</p> <p>c. Fold the darts, matching the cut edges. Stitch along the entire length of the darts, beginning 3/8 inch from the raw edge at the bottom end and tapering to a point at the top end.</p> <p>d. Press the center seams and darts flat with a heated pressing iron or pressing machine.</p>	301	SSa-1	10-14	A	A
		301	SSa-1	10-14	A	A

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
17	<p><u>Stitch adjustment straps to back.</u></p> <p>Finished appearance. The straps shall be in proper alignment and shall be stitched to the back without puckers, wrinkles or other distortion. The seamed side of the straps shall face the outside of the back lining. In the finished vest the bottom edge of the straps shall be 3 to 3-1/4 inches above the finished bottom edge of the back lining. The rounded end of the straps shall overlap no less than 1-3/4 inches for attaching buckle and fastening.</p> <p>a. Position the adjustment straps on the face side of the back (i.e., one strap at each side edge) with the underside (seamed side) of the straps facing down and the raw wide end of the strap even with the raw side edge of the back.</p> <p>b. Stitch straps to back 1/8 to 1/4 inch from raw side edges.</p> <p>c. Stitch straps to back with a single row of stitches across the width of the straps through the seam allowance of each back dart.</p> <p>d. Position the back components face to face, with edges even and center seams matching, and join together along the bottom edge with a 3/8 inch seam.</p> <p>e. Turn the backs face side out and press the seam smooth and flat with a heated pressing iron or pressing machine. The bottom seam shall not be visible on the outside of the adjustment strap side of the back.</p>	301	SSa-1	10-14	A	A
		301	SSv-1	10-14	A	A
		301	SSa-1	10-14	A	A

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NO	OPERATION	STCH TYPE	/SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
18	<p><u>Join facing-lining assemblies to front with tapes.</u></p> <p>Finished appearance. The facing-lining assemblies shall be joined to the fronts in such a way as to produce smooth and flat seams without pleats, puckers or gathers in the finished vest.</p> <p>a. Position facing-lining assembly on the outside of the respective fronts, with the upper edge of neck extension and front edges even.</p> <p>b. Join facing-lining assemblies to the front with a 1/4 inch seam and with the stay tape positioned on the inside of the front 1/8 inch from the edge and caught in the stitching. The line of stitching shall extend from within 1 inch of the ends of the neck extension, along the front and bottom edge to the side edge, catching the lower edge of the lining pleat in the stitching. The stay tape is not required along the right front where the eyelets are located.</p> <p>c. Join the lining to the fronts along the armhole with a 3/8 inch seam. Clip or notch the seam allowance along the armhole for better turning.</p>	301	SSab-1	10-14	A	A
	<p>c. Join the lining to the fronts along the armhole with a 3/8 inch seam. Clip or notch the seam allowance along the armhole for better turning.</p>	301	SSa-1	10-14	A	A
19	<p><u>Join neck.</u></p> <p>a. Properly position the right and left ends of neck extension for the facing and fronts at center back and join respectively with a 1/4 inch seam.</p> <p>b. Spread each seam open and press smooth and flat with a heated pressing iron.</p>	301	SSa-1	10-14	A	A

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NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
19	<u>Join neck.</u> (cont'd)					
	c. Complete the closing of the neck extensions of the fronts and facing with 1/4 inch seams, catching the ends of the neck seams in the stitching.	301	SSa-1	10-14	A	A
	d. Turn each front right side out, through their respective shoulder, forcing out the seams.					
	e. Baste along the front, bottom and armhole edges.	Hand or 101		4-6	Commercial White	
20	<u>Finish front.</u>					
	Finished appearance. Fronts shall finish smooth and flat without distortion. The edgestitching shall be of uniform width without twisting, pleating or puckering and shall finish smooth and flat.					
	a. Edgestitch the vest along the front, bottom and armhole 1/16 inch from the seamed edges.	301	SSe-2 (b)	12-16	A (Silk)	A
	b. Remove all basting and press the edges of lapel, front and bottom edges of the vest smooth and flat with a heated pressing iron or pressing machine, removing the fullness. Turn lapel back over the front and crease along the breakline smooth and flat.					
	c. Tack the upper and lower rounded corners of the lapel to the fronts, through all plies, in line with the edgestitching for a distance of approximately 1 inch.	301	SSa-1	12-16	A (Silk)	A

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TABLE I. MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
21	<p><u>Join back lining to fronts.</u></p> <p>Finished appearance. The seams shall be carefully joined without twists, puckers or pleats. The seams shall start and finish evenly. The back lining shall be over the fronts. The lower joining seam for the back lining shall not be visible on the outside of the vest.</p> <p>a. Position right and left fronts between the plies of the respective back lining with edges even, notches matching and lower edge of front abutting the lower joining seam of back lining.</p> <p>b. Join the back to the fronts along the sides, through all plies, with a row of stitches in line with the upper and lower notches forming an outlet at the side seams. Continue to stitch the back lining along the armhole up to the shoulder seam using a 3/8 inch seam.</p> <p>c. Notch the seam allowance around armholes for better turning.</p> <p>d. Join the back lining to the front at the shoulder with a 3/8 inch seam. The seam shall extend from the armhole seam to approximately 3/8 to 1/2 inch from the upper neck edge of the back lining.</p> <p>e. Pull fronts through the neck opening. Turn under the raw top edges of the back lining approximately 3/8 inch and fell the folded edges to the respective neck extension of front and front facing.</p>	301	SSa-1	10-14	40/3	40/3
		301	SSa-1	10-14	A	A
		Hand		8-10	C (Silk)	

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
22	<u>Attach buckle.</u> Finished appearance. Buckle shall be securely attached and properly assembled to the left strap. a. Assemble buckle to the left strap by turning under the left end of the strap through the buckle 3/4 to 7/8 inch. Secure buckle to strap by stitching and backstitching the end of the strap to the body of the strap 3/8 inch from the end. Stitch across the full width of the strap.	301	SSb-2	10-14	A	A
23	<u>Make buttonholes.</u> Finished appearance. The buttonholes shall be clean-cut, well made and correctly positioned. The stitching shall be securely caught in the fabric. a. Mark the left front for the location of four buttonholes to align with the eyelets in the right front. b. Make a horizontal, eyelet-end, square-bar type buttonhole, cut 5/8 inch, at each of the marks on the left front. The inside edge of the buttonhole eyelet shall finish 3/8 to 1/2 inch from the front edge. c. The buttonholes shall be well worked over gimp to fit the 22-line button. The gimp shall be pulled through to the underside. The purling shall be on the outside. d. Securely bartack the end of each buttonhole and trim the ends of the gimp.	Button hole Bartack		60 Per button hole (minimum) 21 Per bartack (minimum)	A 40/3	A 40/3

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TABLE I MANUFACTURING REQUIREMENTS

NO	OPERATION	STCH TYPE	SEAM/ STCH TYPE	STCH/ IN	NDL	BOB/ LPR
24	<p><u>Clean vest.</u></p> <p>a. Trim all ends of stitchings and remove all loose threads from the vest.</p> <p>b. Remove all spots, shade tickets, markers and stains from the vest without injury to the material.</p>			=		
25	<p><u>Press vest.</u></p> <p>Finished appearance. Pressing shall be done with a heated pressing iron or pressing machine of a type suitable to obtain the desired shape and appearance in accordance with good manufacturing practice.</p> <p>a. Press the entire vest, removing all wrinkles.</p> <p>b. Finish press the lining.</p>					
26	<p><u>Attach buttons.</u></p> <p>Finished appearance. The buttons shall be properly attached to the vest. The buttons shall be properly aligned with the buttonholes to secure a smooth and complete closure without bulging or misalignment.</p> <p>a. Attach four 22-line insignia buttons to the right front with shank of buttons inserted through eyelets and secured by ring fasteners.</p>					

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3.7 Finished measurements. The finished vest shall conform to the measurements specified in Table II.

Table II Finished Measurements 1/

Size	Breast <u>2/</u> (inches)	Back length <u>3/</u> (inches)
<u>SHORT</u>		
36	37	18-1/2
38	39	18-3/4
40	41	19
42	43	19-1/4
44	45	19-1/2
<u>REGULAR</u>		
36	37	19-1/2
38	39	19-3/4
40	41	20
42	43	20-1/4
44	45	20-1/2
46	47	20-3/4
<u>LONG</u>		
36	37	20-1/2
38	39	20-3/4
40	41	21
42	43	21-1/4
44	45	21-1/2
46	47	21-3/4
<u>EXTRA LONG</u>		
36	37	22
38	39	22-1/4
40	41	22-1/2
42	43	22-3/4
44	45	23

1/ Tolerance - $\pm 1/2$ inch

2/ Breast measurement taken with vest buttoned or in buttoned position, from folded edge to folded edge in line with pit of armhole. Multiply by 2.

3/ Back length measurement taken along center back seam from top edge of neckline to bottom edge of vest.

3.8 Workmanship. This vest shall conform to the quality and grade of product established by this specification. The number of defects shall not exceed the applicable acceptable quality levels (AQL's).

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4. QUALITY ASSURANCE PROVISIONS

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

4.2 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. Inspection shall be in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated herein.

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

4.5 Quality conformance inspection.

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. The method of testing shall be as specified in FED-STD-191, wherever applicable.

4.5.2 In-process inspection. Inspection will be made at any point or during any phase of the manufacturing process to determine whether operations or assemblies are performed as specified herein. The Government reserves the right to exclude from consideration for acceptance any material or service for which in-process inspection has indicated nonconformance.

4.5.3 Examination of end item. The end item shall be examined for defects listed in 4.5.3.1, 4.5.3.2 and 4.5.3.3.

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4.5.3.1 General defects. General defects shall be classified as follows:

Examine	Defect	Classification	
		Major	Minor
Buttonholes and eyelets (construction)	a. One or more omitted or added.	101	
	b. Wrong type buttonhole or eyelet.		201
	c. Buttonhole or eyelet not securely caught on fabric causing stitching to pull away from fabric.	102	
	d. Not corresponding to size of button (front): - too small, not permitting button to enter buttonhole. - too large, 3/8 inch or more longer than the diameter of button (measured at inside of purling).	103	202
	e. Bartack omitted or loose on 1 or more buttonholes: - Front buttonholes.	104	
	f. Bartack misplaced: - on 1 buttonhole. - on 2 or more buttonholes.		203 204
	g. One or more broken stitches in: - 1 buttonhole. - 2 or more buttonholes. - 1 eyelet. - 2 or more eyelets.	105 106	205 206
	h. More than 2 skipped stitches in one or more buttonholes or eyelets: - 1 front buttonholes. - 1 eyelet. - 2 or more eyelets.		207 208 209
	i. Gimp omitted in 1 or more buttonholes.		210
	j. Ragged edges, affecting appearance.		211
	k. Poorly made affecting appearance (unless otherwise classified).		212
	l. Ends of gimp not pulled through on the underside on 1 or more buttonholes.		213

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Examine	Defect	Classification	
		Major	Minor
Buttonholes and eyelets (construction)	m. Stitches per buttonhole on front (excluding bartack) less than minimum specified: - 1 or 2 stitches. - 3 stitches. - 4 or more stitches.	107	214 215
	n. Any uncut buttonholes.		216
	o. Buttonhole finished with purling on inside.	108	
Buttons or ring toggle	a. Missing, loose or defective: - 1 button or ring toggle. - 2 or more buttons or ring toggles.	109	217
	b. Not specified type or size.		218
<u>NOTE:</u> Buttons shall be considered defective if they have sharp, rough or cracked edges; scratches, blemishes or imbedded foreign matter on face side of button, loose shanks; or badly shaded.			
Cleanness	a. One or more removable spots or stains clearly noticeable: - on outside. - on inside.	110	219
	b. One or more spots or stains of an obvious permanent nature.	111	
	c. Thread ends not trimmed, loose thread ends, 2 or more shade markings, or basting not removed throughout garment (to be scored when the condition exists on major portion on vest).		220
Components and assembly	a. Any defective component or defect of assembly (not herein classified).		221
	b. Any component part or required operation omitted (not herein classified).		222

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Examine	Defect	Classification	
		Major	Minor
Cutting	a. Any component part of basic material not cut in accordance with directional lines on patterns, or in accordance with specification requirements.	112	
Material defects and damages	a. Any weakening defect such as smash, multiple float, loose slub, etc., that may develop into a hole.		223
	b. Any hole.		224
	c. Shade bars, unsightly slubs, etc.		225
	d. Needle chews which may develop into a hole.		226
	e. Scissors or knife cut, tear, mend or burn.		227
	<p><u>NOTE:</u> Material defects and workmanship damages are to be classified as indicated above only when the condition is one which definitely weakens the fabric or when it is so conspicuously located as to be clearly noticeable. Weakening or nonweakening conditions which are inconspicuous and have negligible effect on serviceability are to be classified as follows:</p> <p>Material defect - No defect Workmanship damages - Minor defect</p>		
Pressing	a. Burned or scorched.		228
	b. Pressing omitted (entire garment).		229
	c. Poorly pressed (unless otherwise classified).		230
	d. Basting or pressing impressions not removed on major portion of vest.		231

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Examine	Defect	Classification	
		Major	Minor
Seams and stitching	a. Accuracy of seaming.	- -	
	1. Seams twisted, puckered, or pleated affecting appearance (unless otherwise classified).		232
	2. Part of garment caught in any unrelated operation or stitching.		233
	3. Thread breaks or ends of all stitching (when not caught in other seams or stitching) not securely backstitched.		234
	4. Wrong shade or 2 shades of thread used on outside of same vest.		235
	b. Gage of stitching (edge of top stitching).		
	1. Irregular, i.e., unevenly gaged or various stitching not uniform, affecting appearance.		236
	2. Beyond range of width specified or varies more than 1/16 inch when no range is specified.		237
	c. Open seams.		
	1. On outside:		
	- up to 1/4 inch inclusive.		238
	- more than 1/4 inch but not more than 1/2 inch.		239
	- more than 1/2 inch.	113	
	2. On inside:		
	- up to 1/4 inch or more but not more than 1/2 inch.		240
	- more than 1/2 inch.		241

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Examine	Defect	Classification	
		Major	Minor
Seams and stitching	d. Raw edges.		
	1. On outside:		
	- up to 1/8 inch inclusive.		242
	- more than 1/8 inch but not more than 1/4 inch.		243
	2. On inside:		
	- more than 1/4 inch but not more than 1/2 inch.		244
	- More than 1/2 inch.		245
	NOTE: Raw edges shall be classified as such when they occur at places where an edge is required to be turned under or over and stitched.		
	e. Run offs (see classification of seams).		
	f. Seam and stitch type.		
	1. Wrong seam type.		246
	2. Wrong stitch type.		247
	g. Stitch tension.		
	1. Loose tension, resulting in loose seams.		248
	2. Loose tension on edge or raised stitching resulting in loosely exposed bobbin thread or top thread.	114	
	3. Tight tension (stitches break when normal strain is applied to seam or stitching).	115	
	NOTE: Puckering is evidence of tight tension. When puckering is evident, the inspector shall test seam by exerting normal pull in the lengthwise direction of seam or stitching.		

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Examine	Defect	Classification	
		Major	Minor
Seams and stitching	h. Stitches per inch (including labels) less than minimum specified:		
	- one or two stitches.		249
	- three stitches.		250
	- four or more stitches.	116	
	- one or more on labels.		251
	<u>NOTE:</u> To be scored only when condition exists on major portion of seam.		
	i. Stitches skipped or broken (on edge or top stitching when seam is seamed, turned and stitched).		
	1. More than 1/4 inch but not more than 3/4 inch.		252
	2. More than 3/4 inch.	117	
Shaded parts	Any outside part shaded.		253

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4.5.3.2 Detailed defects applicable to specific parts. Detailed defects will be classified as follows:

Examine	Defect	Classification	
		Major	Minor
Alignment and position of buttonholes and eyelets Length of front lapels	Outside of vest:		
	a. Buttonhole on left front not in same horizontal position as eyelet on right front by more than 1/4 inch.		254
	b. Position of front buttonhole from front edge:		
	- less than 1/4 inch or more than 3/4 inch.		255
	Unbuttoned fronts unequal in length by more than 1/2 inch.		256
	a. Lapel facings.		
	1. Twisted, short or tight, causing lapels to curl out, affecting appearance.		257
	2. Fullness or puckers, affecting appearance.		258
	b. Lapel edges.		
	1. Bulky, irregular, or not properly forced out, causing crooked edges, affecting appearance.		259
	c. Bridle tape.		
	1. Misplace, not serving intended purpose.		260
	2. Tape partly on creased edge or on lapel side.		261
	d. Lapel shape.		
	1. Not uniform i.e., right and left top edge of lapels vary in length by 1/4 inch or more.		262

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Examine	Defect	Classification	
		Major	Minor
Lapels	2. Lapels poorly shaped or not of uniform size or shape.	-	263
Shoulder (construction)	Improperly joined or set, causing shoulders or back to twist.	118	
Armhole	Armhole seam crooked, affecting appearance.	119	
Body (outside)	a. Front dart.		
	1. One or both darts not properly tapered at top end causing puckers or pleats, affecting appearance.		264
	2. Upper end of darts not backtacked.		265
	3. Raw edges of darts not pressed open.		266
Front and bottom edges	a. Front edges stretched, affecting appearance.		267
	b. Bottom edge stretched, puckered or uneven, affecting appearance.		268
	c. Fronts rolling outward below button.		269
	d. Front edge irregular or not properly forced out, causing crooked or curved edges, affecting appearance.		270
	e. Facing exposed on left front edge, affecting appearance (score only when clearly noticeable and the condition exists along major portion of seam).		271
	f. Bottom corner of one or both fronts poorly shaped, affecting appearance.		272
Front facings	a. Short, tight or twisted, causing excessive fullness or twists on fronts.		273

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Examine	Defect	Classification	
		Major	Minor
Front facings	b. Facing long, causing bottom corner to curl up.	--	274
Size label	Inside of vest.		
	a. Missing, incorrect, illegible or not securely caught in stitching.		275
Identification instruction label	a. Omitted.	120	
	b. Incorrect or illegible.		276
	c. Not stitched on four sides.		277
Body seams	a. Seams not pressed open with heated pressing iron.		278
Welt Pockets	a. Construction and setting.		
	1. Top edge of welt short, causing puckering in front or too loose causing welt to gap, affecting appearance.		279
	2. Tape along creased edge omitted.		280
	3. Tape stitching exposed and visible on outside surface.		281
	4. Poorly shaped or not uniform in shape or in size, affecting appearance.		282
	5. Irregular in width by more than 1/8 inch.		283
	6. Topstitching of welt omitted.		284
	b. Pocket alignment and dimensions.		
	1. Welt pockets out of horizontal alignment:		
	- by more than 3/8 inch but not more than 5/8 inch.		285
	- by more than 5/8 inch.	121	

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Examine	Defect	Classification	
		Major	Minor
Welt Pockets	b. Pocket alignment and dimensions.	-	
	2. Finished width of welt less than 7/8 inch or more than 1-1/8 inch.		286
Straps	a. Construction and setting.		
	1. Less than 1/4 or more than 1-1/2 inches wide at wide end.		287
	2. Less than 5/8 or more than 3/4 inches wide at narrow end.		288
	3. Straps out of horizontal alignment by:		
	- more than 3/8 inch but not more than 5/8 inch.		289
	4. Lower edge of strap less than 3-1/2 inches or more than 3-1/2 inches from bottom finished edge of back, measured from wide end of strap.		290

4.5.3.3 Size measurement. Any measurement deviating from nominal dimension and tolerance specified in Table II shall be classified as a size measurement defect. Measurements will be made at points described in footnotes below Table II.

4.5.3.4 Inspection levels and AQL's. Inspection levels and AQL's shall be as noted in the contract or purchase order.

4.5.4 Bond strength of fusible interlining. The strength of the bond of the fusible interlining to the outer fabric shall be tested once each 4 hours as follows at each fusing press to determine that adequate fusing is being obtained. Prepare a test sample by fusing the fusible specified in 3.3.1 under the same fusing conditions to be used in the manufacture of the vest. Determine the bond strength of the test sample with a commercial spring scale (see 6.7). If the bond strength on any test sample is less than 22 ounces per inch of width, the fusing conditions shall be corrected and the bond strength shall be repeated. Those units represented by this test shall be fused again and retested. If they fail, they shall be rejected.

5. PACKAGING

5.1 Preservation. Preservation shall be commercial.

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5.1.1 Commercial. The vests shall be preserved in accordance with ASTM D 3951.

5.2 Packing. Packing shall be commercial level.

5.2.1 Commercial. Vests preserved as specified in 5.1.1 shall be packed in accordance with ASTM D 3951.

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

6. NOTES

(Information in this section is of a general or explanatory nature which may be helpful, but is not mandatory).

6.1 Intended use. The vest covered by this specification is intended for wear, by U. S. Marine Corps male general officers, with the evening dress uniform.

6.2 Ordering data. Procurement documents should specify the following:

6.2.1 Procurement requirements.

- (a) Title, number, and date of this specification.
- (b) Size required (see 1.2).
- (c) When first article is not required (see 3.2, 4.4 and 6.4).

6.3 Guide sample. The guide sample and color sample may be obtained from the procuring activity or as directed by the contracting officer.

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

6.5 Figures. Figures 1 through 3 show general design of the vest and are furnished for information only. In the event of conflict between these figures and the text of this specification, the text of this specification shall govern.

6.6 Fusing conditions. Specific machine setting should be obtained from the supplier of the particular fusible material for optimum results. The following fusing conditions include the recommendations of several suppliers of fusible material and are furnished for guidance only:

- (a) Temperature between pressing surfaces of 300°F minimum and 320°F maximum, at the fuseline (not the temperature at the clock).
- (b) Pressure between pressing surfaces of 6 pounds force per square inch (lb./in²) minimum and 7 lb./in² maximum.
- (c) Pressing time of 12 seconds minimum and 14 seconds maximum.
- (d) Heat-dry.

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6.7 Peel strength test. The procedure for the peel strength testing with a spring scale should be obtained from the supplier of the fusible material, and shall be accomplished 2 hours after fusing (see 4.5.4).

6.8 Subject term (key word) listing.

Evening dress
Officer's
Waist-coat

Preparing Activity
Navy - MC
Project No. 8405-N233

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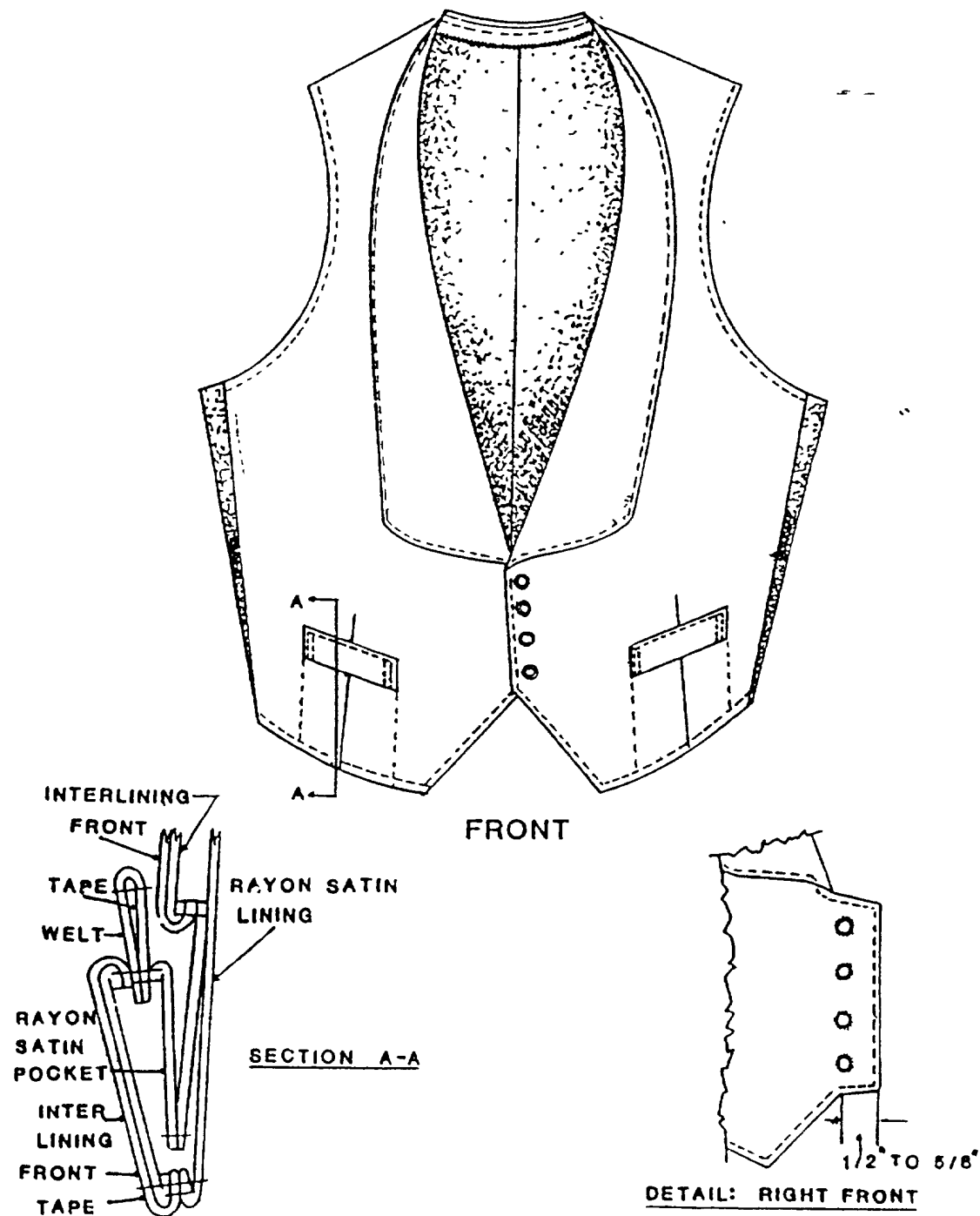


FIGURE 1. VEST, MAN'S: SCARLET DRESS (GENERAL OFFICER'S)

M11-V 29389A(PK)

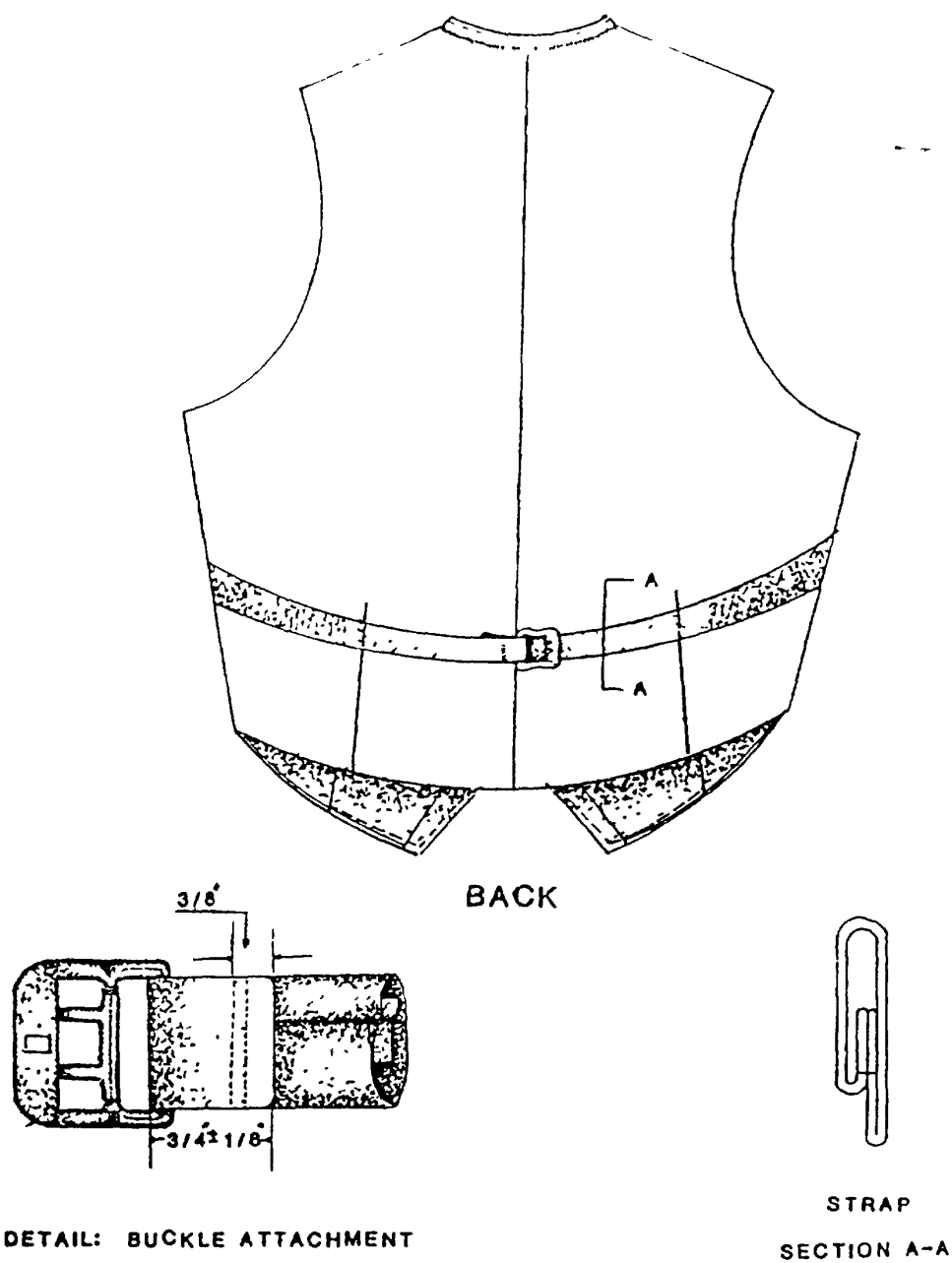


FIGURE 2: VEST, MAN'S: SCARLET DRESS (GENERAL OFFICER'S)

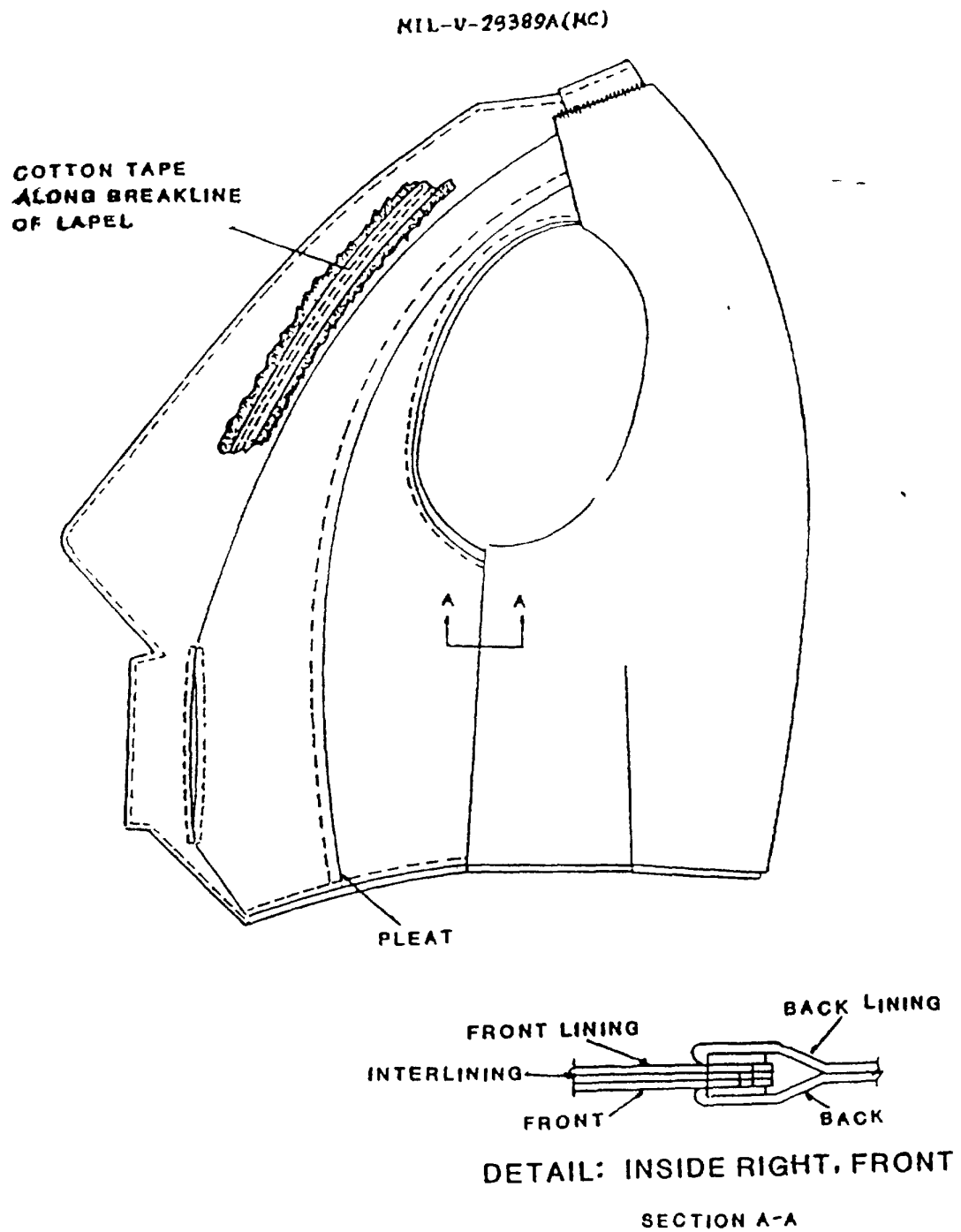


FIGURE 3. VEST, MAN'S: SCARLET DRESS (GENERAL OFFICER'S)

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-C-29389A(MC)

2 DOCUMENT DATE (YYMMDD)
14 April 1994

3. DOCUMENT TITLE

VEST, MAN'S: SCARLET, DRESS (GENERAL 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

7. DATE SUBMITTED
(YYMMDD)

(2) AUTOVON
(if applicable)

PREPARING ACTIVITY

NAME

b. TELEPHONE (Include Area Code)
(1) Commercial

(2) AUTOVON

COMMANDER

(912) 439-6560

567-6560

c. ADDRESS (Include Zip Code)

MARINE CORPS LOGISTICS BASE, CODE, R55
814 FAIRFORD BOULEVARD
ALBANY, GA 31701-1100

IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS CONTACT
Defense Quality and Standardization Office
205 Leesburg Pike, Suite 1403, Falls Church, VA 22043-4400
Telephone (703) 754-2550 AUTOVON (703) 754-2550