

INCH-POUND

MIL-STD-656C

18 July 1990

SUPERSEDING

MIL-STD-656B

14 June 1988

MILITARY STANDARD
PROVISIONS FOR EVALUATING QUALITY
OF
SLACKS, WOMEN'S



AMSC N/A

FSC 8410

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FOREWORD

1. This military standard is approved for use by all Departments and Agencies of the Department of Defense.

2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be used in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

3. This document supplements the military specifications listed below. It provides a standard description for defects and standardizes examination requirements.

| | <u>SPECIFICATION</u> | <u>CLASSIFICATION</u> | <u>TITLE</u> |
|---|----------------------|-----------------------|----------------------------------------------------|
| * | MIL-S-24948 (NU) | D | Slacks, Women's (with Side Pockets) |
| | MIL-S-29364 (MC) | D | Slacks, Women's |
| * | MIL-S-29377 (MC) | D | Slacks, Women's, Maternity |
| * | MIL-S-29432 (MC) | D | Slacks, Women's |
| | MIL-S-41825 (NU) | D | Slacks, Women's |
| * | MIL-S-43526 | U | Slacks, Utility, Women's, Wool, Field |
| * | MIL-S-44092 (GL) | D | Slacks, Women's: Classic Design, Polyester/Wool |
| | MIL-S-83482 (USAF) | D | Slacks, Women's |
| | MIL-S-87054 (NU) | D | Slacks, Women's, Belted |
| | MIL-S-87063 (NU) | U | Slacks, Utility, Women's, Denim |

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1. SCOPE

1.1 Scope. This document provides a standardized procedure for evaluating quality of women's slacks procured for the Department of Defense. It is intended to list, in a single document, defects irrespective of fabrics (i.e. cotton, wool or synthetic) or end use.

1.2 Application. This document will be made applicable to contracts by reference in the appropriate slacks specification.

1.3 Classification. The slacks shall be of the following types:

- D - Dress
- SD - Semi-dress
- U - Utility

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 document to the extent specified herein. Unless otherwise specified, the issues of these documents are 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).

STANDARDS

FEDERAL

FED-STD-4 - Glossary of Fabric Imperfections

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes

MIL-STD-109 - Quality Assurance Terms and Definitions

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

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- * 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 are 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 ASSOCIATION OF TEXTILE CHEMISTS AND COLORISTS (AATCC)

AATCC Photographic Comparative Rating of Single and Double Needle Seams
(Method 88B, two photos)

(Application for copies should be addressed to the American Association of Textile Chemists and Colorists, P.O. Box 12215, Research Triangle Park, NC 27709-2215.)

(Non-Government standards and other publications are normally available from organizations that prepare or distribute the documents. These documents also may 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 shall take precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. DEFINITIONS

3.1 Fabric defects. The fabric defect definitions applicable to this document are described in FED-STD-4. Fabric defects shall be clearly visible when examined with slacks lying flat on an inspection table at a distance of 3 feet.

3.2 Knots and slubs. Only knots and slubs on the outside that exceed the specified limits in the basic cloth specification shall be scored as defects in evaluating quality of the slacks.

3.3 Open seam. A seam shall be classified as open when one or more stitches joining a seam are broken or runoff, or when two or more continuous skipped stitches occur. Double stitched seams and safety stitches are considered open when one or both rows of the stitching are open.

3.4 Raw edge. A raw edge is defined as any edge not finished as specified including any protruding edge on the outside of the slack.

3.5 Defective button. A button shall be considered defective when it has sharp, rough, cracked or split edge; has scratch, dent, blemish or imbedded air bubble(s) or foreign matter; or is badly shaded.

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3.6 Outside - inside. The terms outside and inside as used in this standard are defined as follows:

Outside: Any part of slack that is visible when the completely buttoned and closed slack is examined lying flat on an inspection table.

Inside: Any part of slack that is not visible when the completely buttoned and closed slack is examined lying flat on an inspection table.

3.7 Puckering. In the course of the sampling examination, seams suspected of being puckered shall be examined at a distance of 3 feet in comparison with the AATCC photographic comparative rating for seams. Puckering on a major portion of the suspect seam that has a rating of less than 4 shall be scored as a puckered seam.

3.8 Quality assurance terms and procedures. Definitions of quality assurance terms and procedures, where applicable, shall be in accordance with MIL-STD-105 and MIL-STD-109.

4. GENERAL REQUIREMENTS

This section is not applicable to this standard.

5. DETAILED REQUIREMENTS

5.1 Purpose. This document contains inspection provisions for end item examination, dimensional examination, and packaging examination for dress, semi-dress, and utility slacks. If there are any inconsistencies between the requirements of the appropriate slack specification and the provisions of this standard, the slack specification shall control. This standard assigns to the listed defects, point values of 1, 2, or 3 depending on degree of severity. The higher point values are assigned to those defects having more detrimental affect on the appearance or serviceability of the item.

5.2 Inspection procedures. Inspection procedures shall be as specified in MIL-STD-105 except where otherwise indicated in this document.

5.3 Initiation of inspection. Normal inspection shall be used at the start of inspection unless otherwise directed by the responsible procurement quality assurance element administering the contract.

5.4 Continuation of inspection. Normal, tightened or reduced inspection shall continue unchanged on successive lots except where switching procedures in 5.5 require a change.

5.5 Switching procedures.

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5.5.1 Normal to tightened. When normal inspection is in effect, tightened inspection shall be instituted when two out of five consecutive lots have been rejected on original inspection (i.e., ignoring resubmitted lots for this procedure).

5.5.2 Tightened to normal. When tightened inspection is in effect, normal inspection shall be instituted when five consecutive lots have been considered acceptable on original inspection.

5.5.3 Normal to reduced. When normal inspection is in effect, reduced inspection shall be instituted providing that all of the following conditions are satisfied:

a. The preceding 10 lots have been on normal inspection and none have been rejected on original inspection; and

b. The total number of points for 3 and 2 point defects in the samples from the preceding 10 lots is equal to or less than 60 percent of the total maximum acceptable point values for 3 and 2 point defects from the preceding 10 lots; and

c. The total number of points for 3, 2 and 1 point defects in the sample from the preceding 10 lots is equal to or less than 75 percent of the total maximum acceptable point values for 3, 2 and 1 point defects from the preceding 10 lots; and

d. Production is at a steady rate; and

e. Reduced inspection is considered desirable by the procurement quality assurance element administering the contract.

5.5.4 Reduced to normal. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:

a. A lot is rejected; or

b. A lot is considered acceptable but exceeds the applicable first value (see 1/ to tables I, II and III); or

c. Production becomes irregular or delayed; or

d. Other conditions warrant that normal inspection be instituted.

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5.6 End item visual examination. The slacks shall be examined as indicated in section 3 for all defects except puckering. The puckering examination shall be as described in 3.7. All defects shall be assigned point values as indicated in table IV. The sample size shall be based on lot size, and the acceptance values for 3 and 2 point defects and total (3, 2 and 1 point) defects shall be as specified in tables I Dress Slacks (D), II Semi-dress Slacks (SD) or III Utility Slacks (U), as applicable. The sample unit shall be one pair of finished slacks. The lot shall be unacceptable if:

a. The point value for 3 and 2 point defects exceeds the applicable maximum acceptable point value; or

b. The point value for total (3, 2 and 1 point) defects exceeds the applicable maximum acceptable point value.

TABLE I. Sampling provisions for end item visual examination of dress (D) slacks

| | Lot size | Sample size | Maximum acceptable point values | |
|-------------------|-----------------|-------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects | 3, 2 & 1 point defects |
| Normal inspection | Up through 90 | 20 | 5 points | 9 points |
| | 91 - 150 | 32 | 7 points | 13 points |
| | 151 - 280 | 50 | 11 points | 19 points |
| | 281 - 500 | 80 | 14 points | 26 points |
| | 501 - 1200 | 125 | 21 points | 37 points |
| | 1201 - 3200 | 200 | 27 points | 49 points |
| | 3201 - 10,000 | 315 | 36 points | 72 points |
| | 10,001 - 35,000 | 500 | 53 points | 108 points |
| | 35,001 and over | 800 | 83 points | 165 points |

| | Lot size | Sample size | Maximum acceptable point values | |
|----------------------|-----------------|-----------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects | 3, 2 & 1 point defects |
| Tightened inspection | Up through 150 | 32 | 3 points | 7 points |
| | 151 - 280 | 50 | 5 points | 11 points |
| | 281 - 500 | 80 | 8 points | 17 points |
| | 501 - 1200 | 125 | 13 points | 26 points |
| | 1201 - 3200 | 200 | 20 points | 39 points |
| | 3201 - 10,000 | 315 | 30 points | 59 points |
| | 10,001 - 35,000 | 500 | 45 points | 89 points |
| | | 35,001 and over | 800 | 67 points |

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TABLE I. Sampling provisions for end item visual examination of dress (D) slacks
(cont'd)

| | Lot size | Sample size | Maximum acceptable point values | |
|--------------------|-----------------|-------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects <u>1/</u> | 3, 2 & 1 point defects |
| Reduced inspection | Up through 280 | 20 | 3-9 points | 16 points |
| | 281 - 500 | 32 | 5-13 points | 22 points |
| | 501 - 1200 | 50 | 8-15 points | 27 points |
| | 1201 - 3200 | 80 | 12-20 points | 36 points |
| | 3201 - 10,000 | 125 | 18-25 points | 42 points |
| | 10,001 - 35,000 | 200 | 25-32 points | 50 points |
| | 35,001 and over | 315 | 35-43 points | 71 points |

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.5.4b). The second value is the maximum acceptable point value.

TABLE II. Sampling provisions for end item visual examination of semi-dress (SD) slacks

| | Lot size | Sample size | Maximum acceptable point values | |
|-------------------|-----------------|-------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects | 3, 2 & 1 point defects |
| Normal inspection | Up through 500 | 50 | 11 points | 21 points |
| | 501 - 1200 | 80 | 13 points | 30 points |
| | 1201 - 3200 | 125 | 21 points | 39 points |
| | 3201 - 10,000 | 200 | 29 points | 57 points |
| | 10,001 - 35,000 | 315 | 40 points | 85 points |
| | 35,001 and over | 500 | 61 points | 127 points |

| | Lot size | Sample size | Maximum acceptable point values | |
|----------------------|-----------------|-------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects | 3, 2 & 1 point defects |
| Tightened inspection | Up through 500 | 50 | 5 points | 15 points |
| | 501 - 1200 | 80 | 7 points | 22 points |
| | 1201 - 3200 | 125 | 12 points | 34 points |
| | 3201 - 10,000 | 200 | 18 points | 51 points |
| | 10,001 - 35,000 | 315 | 28 points | 78 points |
| | 35,001 and over | 500 | 41 points | 117 points |

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TABLE II. Sampling provisions for end item visual examination of semi-dress (SD) slacks
(cont'd)

| | Lot size | Sample size | Maximum acceptable point values | |
|--------------------|-----------------|-------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects <u>1/</u> | 3, 2 & 1 point defects |
| Reduced inspection | Up through 1200 | 32 | 5-12 points | 22 points |
| | 1201 - 3200 | 50 | 7-14 points | 27 points |
| | 3201 - 10,000 | 80 | 12-18 points | 36 points |
| | 10,001 - 35,000 | 125 | 16-23 points | 46 points |
| | 35,001 and over | 200 | 23-30 points | 65 points |

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.5.4b). The second value is the maximum acceptable point value.

TABLE III. Sampling provisions for end item visual examination of utility (U) slacks

| | Lot size | Sample size | Maximum acceptable point values | |
|----------------------|-----------------|-------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects | 3, 2 & 1 point defects |
| Normal inspection | Up through 500 | 50 | 13 points | 25 points |
| | 501 - 1200 | 80 | 19 points | 31 points |
| | 1201 - 3200 | 125 | 27 points | 43 points |
| | 3201 - 10,000 | 200 | 38 points | 63 points |
| | 10,001 and over | 315 | 58 points | 93 points |
| Tightened inspection | Up through 500 | 50 | 7 points | 16 points |
| | 501 - 1200 | 80 | 12 points | 25 points |
| | 1201 - 3200 | 125 | 18 points | 37 points |
| | 3201 - 10,000 | 200 | 28 points | 57 points |
| | 10,001 and over | 315 | 41 points | 85 points |

| | Lot size | Sample size | Maximum acceptable point values | |
|--------------------|-----------------|-------------|---------------------------------|------------------------|
| | | | 3 & 2 point defects <u>1/</u> | 3, 2 & 1 point defects |
| Reduced inspection | Up through 1200 | 32 | 7-14 points | 24 points |
| | 1201 - 3200 | 50 | 12-18 points | 30 points |
| | 3201 - 10,000 | 80 | 16-21 points | 38 points |
| | 10,001 and over | 125 | 23-28 points | 43 points |

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.5.4b). The second value is the maximum acceptable point value.

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TABLE IV. End item visual defect point values

| Defect | Point value | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| I. <u>MATERIAL DEFECT AND DAMAGE</u> | | | |
| a. Any hole, cut, tear, smash, burn, drill hole, run, scorched area or open place: | | | |
| 1. On outside (see 3.6) (longest dimension in any direction): | | | |
| (a) - up to 1/4 inch inclusive | 3 | 2 | 2 |
| (b) - more than 1/4 inch | 3 | 3 | 3 |
| 2. On inside (see 3.6) (longest dimension in any direction): | | | |
| (a) - up to 1/4 inch inclusive | 1 | 1 | 1 |
| (b) - more than 1/4 inch | 2 | 2 | 2 |
| b. Knot or slub (see 3.2) on outside | 2 | 1 | 1 |
| c. Misweave, area of no dye penetration, dye streak, missing yarn, broken yarn, visible mend, thin place, shade bar, barre and uneven knitting; more than 1/2 inch (largest dimension in any direction) on outside | 2 | 1 | 1 |
| d. Loose yarn, snag or coarse yarn; more than 1 inch (largest dimension in any direction) on outside | 2 | 1 | 1 |
| e. Woven in waste on outside visible at 3 feet, largest dimension in any direction: | | | |
| 1. 1/4 inch up to 1 inch inclusive | 2 | 1 | 1 |
| 2. More than 1 inch | 3 | 2 | 1 |
| f. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching) on outside | 2 | 2 | 2 |
| g. Needle chew on outside, largest dimension in any direction: | | | |
| 1. Up to 1/2 inch inclusive | 2 | 2 | 2 |
| 2. More than 1/2 inch | 3 | 3 | 3 |
| II. <u>SHADED PART</u> | | | |
| a. On outside: | | | |
| 1. Variation in shade within a part or between parts (except part which may be cut from ends) | 3 | 2 | 2 |
| 2. Parts cut from ends badly shaded or unevenly shaded | 1 | 1 | - |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|-------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| III. <u>PRESSING</u> | | | |
| a. Omitted or poorly pressed | 2 | 1 | 1 |
| b. Legs not pressed seam on seam at bottom or knee by more than 3/4 inch | 1 | 1 | 1 |
| c. Seam not pressed open (to be scored only when condition exists on major portion of seam) | 1 | 1 | - |
| IV. <u>CLEANNESS</u> | | | |
| a. Any spot or stain on outside visible at 3 feet, largest dimension in any direction: | | | |
| 1. Up to 3/8 inch inclusive | 1 | 1 | - |
| 2. More than 3/8 inch up to 3/4 inch inclusive | 2 | 1 | 1 |
| 3. More than 3/4 inch | 3 | 2 | 1 |
| b. Thread ends: | | | |
| * 1. Three or more thread ends on outside not trimmed less than 1/4 inch | 2 | 2 | 2 |
| 2. Five or more thread ends on inside not trimmed to less than 1/2 inch | 1 | 1 | 1 |
| c. Thread end caught for a distance of more than 1/4 inch in line of stitching on outside | 1 | 1 | 1 |
| d. Two or more shade or size tickets not removed | 1 | 1 | 1 |
| e. Any size or shade marking or residue on outside, score as spot or stain (see IVa) | | | |
| f. One or more basting or holding stitches visible on finished slacks | 1 | 1 | 1 |
| g. Loose thread ends not removed from slacks (to be scored only when condition exists on a major portion of slacks) | 1 | 1 | 1 |
| V. <u>COMPONENT AND ASSEMBLY</u> | | | |
| a. Any component part or operation omitted (unless otherwise classified herein) | 3 | 3 | 3 |
| b. Any component not as specified | 3 | 3 | 3 |
| c. Any component part tight, twisted, distorted, pleated, or full (unless otherwise classified herein) | 2 | 2 | 2 |
| d. Any operation not as specified (unless otherwise classified herein) | 2 | 1 | 1 |
| e. The edge of any component part required to be forced out having folds of more than 1/8 inch (unless otherwise classified herein) | 2 | 2 | 1 |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| <u>VI. CUTTING</u> | | | |
| a. Any component part not cut in accordance with specified pattern or directional lines on patterns, or not in accordance with specification requirements | 3 | 3 | 3 |
| b. Twill line of any outside part not running in specified direction | 3 | 3 | 3 |
| <u>VII. SEAMS AND STITCHING</u> | | | |
| a. Accuracy of seaming: | | | |
| 1. Seam puckered (score only when on major portion of seam) (see 3.7) | 1 | 1 | 1 |
| 2. Seam irregular, pleated or wavy (unless otherwise classified herein) | 2 | 1 | 1 |
| 3. Any part of slacks caught in an unrelated operation or stitching (unless otherwise specified herein) | 2 | 2 | 2 |
| 4. End of stitching when not caught in other seams or stitching not backstitched as specified (except stitching for attaching labels) | 1 | 1 | 1 |
| 5. Thread breaks secured by stitching back of the break less than 1/2 inch | 1 | 1 | 1 |
| 6. Ends of a continuous line of stitching overlapped less than 1/2 inch | 1 | 1 | 1 |
| 7. Not specified color thread used on outside | 3 | 2 | 1 |
| 8. Stitching for attaching labels not finished as specified | 1 | 1 | 1 |
| 9. Needle perforations visible on outside | 2 | 2 | 1 |
| b. Gage of stitching and seam allowance: | | | |
| 1. Gage irregular or not within range specified (score only when condition exists on more than 1/2 the length of the seams) | 1 | 1 | 1 |
| 2. Edge or raised stitching sewn too close to edge, resulting in damage to cloth | 3 | 3 | 2 |
| 3. Seam allowance not as specified or varies more than 1/8 inch | 2 | 2 | 2 |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|----------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| VII. <u>SEAMS AND STITCHING</u> (cont'd) | | | |
| c. Open seam: (see 3.3) | | | |
| 1. On all seams except label stitching: | | | |
| (a) - up to 1/2 inch inclusive | 1 | 1 | 1 |
| (b) - more than 1/2 inch up to 3/4 inch inclusive | 2 | 2 | 2 |
| (c) - more than 3/4 inch | 3 | 3 | 3 |
| 2. On label stitching | 1 | 1 | 1 |
| d. Runoff: | | | |
| 1. On joining seam, score as open seam | | | |
| 2. Edge or raise stitching | 1 | 1 | 1 |
| e. Raw edge (except where pinking is required) <u>1</u> / ₁ : (see 3.4) | | | |
| 1. On outside: | | | |
| (a) - up to 1/2 inch inclusive | 1 | 1 | 1 |
| (b) - more than 1/2 inch up to 3/4 inch inclusive | 2 | 2 | 1 |
| (c) - more than 3/4 inch | 3 | 3 | 2 |
| 2. On inside 1/2 inch or more | 1 | 1 | 1 |
| f. Seam and stitch type: | | | |
| 1. Not specified seam or stitch type | 2 | 2 | 2 |
| 2. Loper thread of 401 stitch type on outside | 3 | 3 | 3 |
| 3. Any line of stitching omitted | 3 | 3 | 3 |
| 4. Any line of stitching not beginning or ending where specified (unless otherwise classified herein) | 1 | 1 | 1 |
| g. Broken, missing or skipped stitches on edge or raised stitching (when seam is seamed, turned and stitched): | | | |
| 1. 1/4 inch up to 1/2 inch inclusive | 1 | 1 | 1 |
| 2. More than 1/2 inch | 2 | 1 | 1 |

1/ Raw edge resulting from missing, incomplete or loose overedging on slack bottom or any part of slack where overedging is required shall be scored as a raw edge on inside.

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|---------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| VII. SEAMS AND STITCHING (cont'd) | | | |
| h. Stitch tension: | | | |
| 1. Loose tension resulting in a loose seam: | | | |
| (a) - up to 1/2 inch inclusive | 1 | 1 | 1 |
| (b) - more than 1/2 inch up to 3/4 inch inclusive | 2 | 2 | 2 |
| (c) - more than 3/4 inch | 3 | 3 | 3 |
| 2. Loose tension on raised or edge stitching resulting in exposed loose thread | 1 | 1 | 1 |
| 3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching): | | | |
| (a) - seat seam | 3 | 3 | 3 |
| (b) - all other seams | 3 | 3 | 3 |
| i. Stitches per inch (to be scored only when the condition exists on a major portion of seam or stitching): | | | |
| 1. Less than the minimum specified (except on overedge stitching and labels) | 2 | 2 | 2 |
| 2. Less than the minimum specified on overedge stitching and labels | 1 | 1 | 1 |
| 3. More than the maximum specified | 1 | 1 | 1 |
| VIII. BUTTONHOLE | | | |
| a. Omitted, added, not specified type or not finished as specified | 3 | 3 | 2 |
| b. Misplaced or not positioned as specified: out of alignment with other buttonhole or button resulting in bulge or twist when buttoned | 3 | 3 | 3 |
| c. Gimp omitted, uncut buttonhole, end of gimp not pulled through to underside, incomplete stitching, or stitching not securely caught in fabric: | | | |
| 1. On outside | 3 | 2 | 2 |
| 2. On inside | 2 | 1 | 1 |
| d. Ragged edge, broken stitch or two or more skipped stitches: | | | |
| 1. On outside | 2 | 2 | 1 |
| 2. On inside | 1 | 1 | 1 |
| e. Buttonhole stitching extending beyond bartack or stitches per buttonhole not as specified: | | | |
| 1. On outside | 2 | 2 | 1 |
| 2. On inside | 1 | 1 | 1 |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|--------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| VIII. <u>BUTTONHOLE</u> (cont'd) | | | |
| f. Cut length of buttonhole not as specified | 1 | 1 | 1 |
| g. Purling not on side specified | 1 | 1 | 1 |
| h. Ends not securely tacked in: | | | |
| 1. One buttonhole | 1 | 1 | 1 |
| 2. Two or more buttonholes | 2 | 2 | 2 |
| IX. <u>BUTTON</u> | | | |
| a. Missing, broken, defective (see 3.5), misplaced, not sewn as specified, or insecurely sewn | 1 | 1 | 1 |
| b. Not finished as specified | 1 | 1 | 1 |
| X. <u>SNAP FASTENER</u> | | | |
| a. Socket and stud out of alignment when fastener is closed causing noticeable bulge or twist | - | 2 | 2 |
| b. Socket or stud missing, loose, defective or mismatched | - | 2 | 2 |
| c. Snap fastener not as specified | - | 2 | 2 |
| d. Center of socket or stud off center of waistband by more than 1/4 inch | - | 1 | 1 |
| e. Stitching of fastener stud exposed on outside of waistband | - | 1 | 1 |
| f. Socket less than 1/4 inch or more than 1/2 inch from square end of tab | - | 1 | 1 |
| g. Hand sewn snap fastener (stud or socket) tacked off with less than two stitches | - | 1 | 1 |
| h. Snap fastener broken, bent, cracked or improperly clinched failing to effect a secure closure or to open freely | - | 3 | 3 |
| XI. <u>BARTACK OR TACK</u> | | | |
| a. Missing, insecure, misplaced, not serving intended purpose or not specified size or type: | | | |
| 1. Bartack for attachment | 2 | 2 | 2 |
| 2. Bartack for reinforcement | 1 | 1 | 2 |
| b. Loose stitch tension | 1 | 1 | 1 |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|---------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| XII. <u>WAISTBAND</u> (outside of slacks) | | | |
| a. Construction: | | | |
| 1. Fullness, pleats, gathers or twist on outside of waistband | 3 | 2 | 2 |
| 2. Top of slacks puckered or pleated at joining to waistband | 3 | 2 | 2 |
| 3. Waistband end(s) poorly shaped or not same shape (when applicable) | 1 | 1 | 1 |
| 4. Width of waistband not as specified | 1 | 1 | 1 |
| 5. Bottom edges of waistband extensions not in line with waistband joining seam by more than 1/4 inch, when slacks are buttoned | 1 | 1 | 1 |
| 6. Waistband extension not specified distance from fold or welt to point of tab | 1 | 1 | 1 |
| 7. Underside of waistband at extension piece exposed by 1/8 inch up to 1/4 inch | 2 | 2 | - |
| * 8. Top or bottom edge of waistband does not match at center back by 1/8 inch or more | 2 | 0 | 0 |
| * 9. Left waistband edge not finishing even with left fly edge | 1 | 0 | 0 |
| b. Waistband buttonholes: | | | |
| 1. Off center of waistband by more than 1/4 inch | 2 | 2 | 2 |
| 2. Inside edge of eyelet not specified distance from front edge or pointed end of waistband | 1 | 1 | 1 |
| c. Waistband buttons (measurements taken from center of button): | | | |
| 1. Any button positioned out of the required tolerance from finished end | 1 | 1 | 1 |
| 2. Off center on waistband by more than 1/4 inch | 1 | 1 | 1 |
| * d. Waistband lining: | | | |
| 1. Width of finished waistband linings not as specified | 2 | 1 | 1 |
| 2. Linings exposed on outside: | | | |
| (a) - up to 1 inch inclusive | 1 | 1 | 1 |
| (b) - more than 1 inch | 2 | 2 | 2 |
| 3. Waistband lining not turned in diagonally at centerback as specified | 2 | - | - |
| 4. Waistband lining not as specified | 2 | - | - |
| 5. More than one piecing of buckram | 1 | - | - |
| 6. More than one piecing of lining | 1 | - | - |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| XII. WAISTBAND (outside of slacks) (cont'd) | | | |
| e. Waistband non-slip tape: | | | |
| 1. Not type specified | 2 | - | - |
| 2. Not positioned on outside of inner waistband as specified | 1 | - | - |
| f. Waistband hook and eye: | | | |
| 1. Not aligned causing distortion when engaged | 3 | 3 | 3 |
| 2. Missing or not properly clinched | 3 | 3 | 3 |
| g. Waistband interlining: | | | |
| 1. Not type specified | 1 | - | - |
| 2. Not positioned on inside of waistband as specified | 1 | - | - |
| 3. Evidence of bubbling, delamination, change of color, or strike through on waistband due to fusible interlining | 3 | - | - |
| XIII. <u>SIDE OR CENTER BACK PLACKET OPENING</u> | | | |
| a. Placket not caught in waistband stitching; or on utility slacks, waistband extending beyond front folded edge of placket | 2 | 2 | 2 |
| b. Overedge of stitching omitted on top, bottom, or side edges of gusset | 2 | 2 | 2 |
| c. Lining omitted from placket or facing on side opening edge of pocket | - | 2 | - |
| d. Binding omitted from inside back edge of placket or side edge of pocket | - | 2 | - |
| e. Placket or gusset twisted or distorted | 1 | 1 | 1 |
| f. Placket exposed when front waistband buttonhole is fastened to the center button on back waistband, and the placket buttons are fastened to the front side opening buttonholes | - | 1 | 1 |
| g. Front edge of side opening stretched, gapped or distorted | 2 | 2 | 1 |
| h. Line of stitching across bottom edge not specified distance from edge | - | - | 1 |
| i. Metal chain of slide fastener, slider or slider pull exposed beyond edge of welt when opening is closed | 2 | 2 | - |
| j. Stitching on front of slacks less than 1/8 inch or more than 1/4 inch from slide fastener chain | 1 | 1 | - |
| k. Length from inside edge of buttonhole eyelet to front side opening edge, less than specified | - | 1 | 1 |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | | |
|---------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|---|---|
| | D | SD | U | |
| XIV. <u>SLIDE FASTENER</u> | | | | |
| Operate slider on chain twice, opening and closing the complete length of chain and locking slider each time. | | | | |
| a. | Slide pull becomes detached or slider disengages from either row of scoops | 3 | 3 | 3 |
| b. | Chain becomes unmeshed or does not mesh properly | 3 | 3 | 3 |
| c. | Any required component missing or not properly assembled | 3 | 3 | 3 |
| d. | Slider lock does not retain slider when pull is in down position on non-automatic lock or when pull is released on automatic lock, when the open chain above the slider is lightly pulled apart | 2 | 2 | 2 |
| e. | Slider binds, catches or sticks at any point or does not function properly | 2 | 2 | 2 |
| * f. | Fastener is not type, size, style, or finished length specified | 2 | 2 | 2 |
| g. | Chain (scoops) installed upside down | 1 | 1 | 1 |
| h. | Cut, tear or hole in slide fastener tape | 3 | 3 | 3 |
| * i. | Stitching too close to chain not permitting slider to pass freely | 3 | 3 | 3 |
| j. | Tape set too loose or too tight causing bulge, twist or fullness in closed fly on top end of tape; not caught as specified or staple not securely clinched at bottom of chain; slide fastener chain misplaced (set too high or low); or tape not attached as specified | 2 | 2 | 2 |
| k. | Edge of chain not positioned within specified range at top or bottom from finished edge of fly or end of metal scoops uneven at top by more than 3/16 inch | 1 | 1 | 1 |
| * l. | End of coil not positioned as specified | 2 | 2 | 2 |
| * m. | Bottom stop not positioned within 3/8 inch of front seam | 2 | - | 3 |
| * n. | Top stop missing or positioned more than 1/4 inch from waistband joining seam when coil does not extend into waistband | 3 | 3 | 3 |
| * o. | Bottom stop not securely stapled | 2 | 2 | 2 |
| * p. | Bartacks missing or not taking the strain off the bottom stop in a fly application when fronts are pulled in opposing directions | 3 | 3 | 3 |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| <u>XV. POCKET OR FLAP</u> | | | |
| a. Any one pocket or flap out of alignment by (at any point when measured from lowest row of waistband stitching) more than 1/2 inch | 3 | 2 | 2 |
| b. Pocket or flap set on higher or lower than companion pocket or flap by more than 1/2 inch | 3 | - | 2 |
| c. Flap buttonhole off center by more than 1/4 inch | - | - | 1 |
| d. Inside edge of eyelet less than 1/2 inch or more than 5/8 inch from bottom edge of flap | - | - | 1 |
| e. Facing less than 1-3/8 inches or more than 1-5/8 inches except at the bellows side of pocket | - | - | 1 |
| f. Pocket flap poorly shaped or constructed, set on crookedly, or not completed covering pocket opening | - | - | 1 |
| g. Center of button out of alignment with eyelet of buttonhole in flap causing a noticeable bulge, twist or distortion of flap or pocket, when buttoned | - | - | 2 |
| * h. Top of waistband pocket, welt pockets, or hanging pockets twisted or short causing fullness or distortion on the outside of fronts | 2 | 2 | - |
| i. Pocket openings uneven in length by: | | | |
| 1. More than 1/4 inch but less than 1/2 inch | 1 | 1 | 1 |
| 2. More than 1/2 inch | 2 | 2 | 2 |
| j. Edge of opening stretched, gapped or irregular; facing exposed on edge more than 1/8 inch; or joining seam of top pocket less than 1/8 inch or more than 3/16 inch from edge of pocket opening | 2 | 2 | - |
| k. Edge not properly forced out, having a fold of 1/8 inch or more | - | 1 | - |
| l. Stitching of pocket opening edge of front to pocket (below waistband) extending less than 1-1/4 inches or more than 1-1/2 inches, or not superimposed on edge stitching of pocket opening edge of front | 1 | 1 | - |
| m. Fullness or twist on either bearer piece | 1 | 1 | 1 |
| n. Finished bearers not the same width at waistband seam by more than 3/8 inch | 1 | 2 | 1 |
| o. Lower edge of opening caught in outseam stitching more than 1/4 inch beyond bartack | 1 | 1 | 1 |
| p. Top edge of pocket not completely caught in waistband stitching | 2 | 2 | 1 |
| q. Finished edge of pocket less than 1/8 inch from back of slide fastener chain | - | 1 | - |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| XV. <u>POCKET OR FLAP</u> (cont'd) | | | |
| r. Width or depth of pocket opening not as specified | 1 | 1 | 1 |
| s. Hip pocket: | | | |
| 1. Cord (welt) not specified width or varies in width by more than 1/16 inch | - | 1 | 1 |
| 2. End of hip pocket cord (welt) or bearer not caught in the edge stitching of pocketing | - | 1 | 1 |
| t. Welt pocket: | | | |
| 1. Top edge of welts short, causing puckers on front or too loose causing welt to gap | 2 | - | - |
| 2. Poorly shaped or not uniform in shape or size | 2 | - | - |
| 3. Irregular in width by more than 3/16 inch | 2 | - | - |
| 4. Reinforcing row of stitching on corners of welt, omitted or insecure | 1 | - | - |
| * 5. Welts out of horizontal alignment with waistband when measured from bottom of waistband to top corners of welt by: | | | |
| - 1/8 up to 1/4 inch (inclusive) | 2 | - | - |
| - more than 1/4 inch | 3 | - | - |
| 6. Finished depth of welt less than 1 inch or more than 1-1/8 inches | 2 | - | - |
| 7. Finished width of welt less than 4-1/8 inches or more than 4-3/8 inches | 2 | - | - |
| * 8. Welts out of alignment with each other when measured from bottom of waistband straight down to top edge of outside end of welt by 1/4 inch or more | 2 | - | - |
| * 9. Welts out of alignment with each other when measured from bottom of waistband straight down to top of inside end of welt by 1/4 inch or more | 2 | - | - |
| * 10. The sum of the measurements taken in defects XV."t.7." and "t.8." for each pocket welt shall not deviate 1/2 inch or more when compared to the sum of the measurements for the opposite pocket welt | 3 | - | - |
| * 11. Bottom of pockets out of horizontal alignment when measured from bottom of waistband to center of pocket by 1/4 inch or more | 2 | - | - |
| * 12. Stitching of front ply of pocketing to welt performed simultaneously with stitching of welts to slacks | 1 | - | - |
| * 13. Raw edges or notches showing around outside of welt | 3 | - | - |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| <u>XV. POCKET OR FLAP</u> (cont'd) | | | |
| t. Welt pocket: (cont'd) | | | |
| * 14. Bottom ply of pocket not completely caught in waistband joining seam | 2 | - | - |
| * 15. Bulging, pulling, twisting, or disortion of facing or pocketing affecting appearance on the outside of the slacks | 2 | - | - |
| NOTE: Defects "XV.t.5." to "XV.t.7." relate to individual measurements of each welt on a pair of slacks. Defects "XV.t.8." to "XV.t.10." relate to measurements of one welt compared to the opposite welt on a pair of slacks. | | | |
| u. Side pocket or hanging type pocket: | | | |
| 1. Facing or bearer not caught in bartack at each end of opening; facing or bearer not extending below bottom bartack and above top bartack | 3 | 3 | 3 |
| 2. Facing exposed on outside | 2 | 1 | 1 |
| 3. Pocketing notched more than 1/4 inch beyond width of outseam allowance on the underside | 1 | 1 | 1 |
| 4. Bartack extends beyond outseam, less than 1/16 inch or more than 1/8 inch | - | 1 | 1 |
| 5. Pocket stay not extending above and below bartacks or bottom end of stay not turned under | 1 | - | - |
| 6. Top or bottom of pocket opening more than 1/8 inch from outside joining seam | 1 | 1 | - |
| <u>XVI. DARTS</u> | | | |
| a. Darts stitched with twists or puckers, or not properly tapered and stitched closed to the very end of the folded edge, resulting in noticeable indentation or fullness on the outside of slacks | 2 | 2 | 1 |
| b. Corresponding darts not uniform in length by 1/4 inch or more, or stitched less than specified below drill holes | 2 | 2 | 1 |
| c. Inside folded edge of back darts not turned toward the seat seam or front darts not turned toward front seam | 1 | 1 | 1 |
| d. Not securely caught in waistband forming seam | 1 | 1 | 1 |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|-------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| XVI. <u>DARTS</u> (cont'd) | | | |
| e. Thread ends at lower end of dart trimmed closer than 1/2 inch (when applicable) | 1 | 1 | 1 |
| f. When automatic dart machine is used thread ends of dart not backstitched | 1 | 1 | 1 |
| XVII. <u>INSEAMS AND OUTSEAMS</u> | | | |
| a. Inseam or outseam not lapped as specified | 3 | - | 1 |
| b. Ends of inseams staggered at crotch more than 1/2 inch (center to center) | 2 | 1 | 1 |
| c. Pleated or twisted at base of pocket or placket opening | 2 | 2 | - |
| XVIII. <u>SEAT AND FRONT SEAMS</u> | | | |
| a. Front and seat seams not joined in one continuous operation (when applicable) | 2 | 2 | 2 |
| b. Seat seam outlet omitted or less than specified by more than 1/2 inch on total width of both seams | 1 | 1 | 1 |
| * c. Seat seam not repaired as specified | 2 | - | - |
| XIX. <u>LEG BOTTOM</u> | | | |
| a. Not finished as specified | 1 | 1 | 1 |
| * b. Unhemmed bottoms uneven by more than 1/2 inch at inseams or outseams | 1 | - | - |
| XX. <u>LABEL</u> | | | |
| a. Not attached as specified, misplaced or stitching through the printing | 1 | 1 | 1 |
| b. Missing, incorrect or illegible: | | | |
| 1. Size label, instruction label or combination label | 3 | 3 | 3 |
| 2. Identification label | 1 | 1 | 1 |
| * c. Removable size ticket missing, incorrect, or illegible | 3 | - | - |

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* TABLE IV. End item visual defect point values (cont'd)

| Defect | Point value | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----|---|
| | D | SD | U |
| XXI. <u>HOOK AND EYE</u> | | | |
| a. Hook and eye damaged affecting function or not securely attached | 3 | 3 | 3 |
| b. Hook or eye not positioned as specified causing bulge, twist, distortion or puckers on outside | 3 | 3 | 3 |
| XXII. <u>BELT LOOP</u> | | | |
| a. Omitted or covering stitch on outside | 2 | 2 | 2 |
| b. Set at an angle (more than 3/16 inch off perpendicular), insecure, not attached as specified, length too short constricting waistband, width not as specified, or poorly shaped | 2 | 2 | 1 |
| c. Misplaced by more than 3/4 inch, length too long causing gap of material to extend more than 1/8 inch above waistband or finished length more than 1/4 inch longer than specified | 1 | 1 | 1 |
| d. Finished length shorter than specified | 1 | 1 | 1 |
| e. Tacking or bartacking visible on outside (when applicable) | - | 1 | 1 |
| f. Turn under of loop not trimmed as specified or not trimmed to 1/2 inch when no requirement is specified | 1 | 1 | 1 |
| g. Not dropped as specified | 1 | 1 | 1 |
| h. Center back loop not centered on seat seam by more than 1/4 inch | 2 | 2 | 1 |
| XXIII. <u>FRONT OPENING</u> | | | |
| a. Length of fly uneven at top: (examination to be performed with slide fastener closed and hook and eye or button unfastened): | | | |
| 1. By 1/8 inch up to 3/8 inch inclusive | 1 | 1 | 1 |
| 2. By more than 3/8 inch | 2 | 2 | 2 |
| b. Tight fly exposed beyond front edge, seam joining left fly to front exposed when fly is closed, or right fly more than 1/4 inch inward from front edge | 1 | 1 | 1 |
| c. Stitching on right fly, irregular or not positioned as specified or not terminated where specified | 1 | 1 | 1 |
| d. Raw edge of left fly extension not turned under, or the turned edge not stitched to edge of crotch seam allowance | 1 | - | 1 |

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5.7 End item dimensional examination. The sample size for end item dimensional examination shall be based on lot size as shown in table V. The slacks shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate slack specification. When a measurement deviates from a dimension and tolerance specified, the slack shall be penalized one point. Each slack shall also be penalized one point when the in-seams are uneven in length by 1/2 inch or more. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value for the lot. Each size of slack present in the lot should be represented in the sample selected for this examination.

TABLE V. Sampling provisions for end item dimensional examination

| Lot size | Sample size | Maximum acceptable point values |
|----------------------|-------------|---------------------------------|
| Up through 500 | 8 | 0 |
| 501 through 3,200 | 13 | 1 |
| 3,201 through 35,000 | 20 | 2 |
| 35,001 and up | 32 | 3 |

5.8 Packaging examination. The fully packaged slacks shall be examined for the defects listed below. The sample size shall be five shipping containers, fully packaged. The lot shall be unacceptable if one or more defects are found.

| <u>Examine</u> | <u>Defect</u> |
|---------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Marking (exterior and interior) | Omitted; incorrect; illegible; of improper size, location, sequence, or method of application. |
| Materials | Any component missing, damaged, or not as specified. |
| Workmanship | Inadequate application of components, such as: incomplete sealing or closure of container flap, improper taping, loose strapping, inadequate stapling, or improper adhesive application. Open and noncontinuous heat sealed seams in closure of polyethylene bag. <u>1/</u> Alternative closure of polyethylene bag not provided with tuck or reverse flap. <u>1/</u> Omission of vent hole in polyethylene bag. <u>1/</u> Incorrectly fabricated bag. <u>1/</u> Bulged or distorted container. |

1/ When applicable

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| <u>Examine</u> | <u>Defect</u> |
|--------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Content | Number of bundles or intermediate packages per shipping container is more or less than required. Number of slacks per intermediate package is more or less than required. <u>2/</u> Size shown on one or more slacks not as specified on shipping container. <u>2/</u> |
| Preservation (naphthalene flakes) | Improperly applied or missing. <u>1/</u> |

1/ When applicable

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

6. INFORMATION FOR GUIDANCE ONLY

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

* 6.1 Intended use. This document provides quality assurance provisions for the inspection of women's slacks and is intended for reference in section 4 of Department of Defense specifications for applicable items.

6.2 Subject term (key word) listing.

Examination
Inspection
Quality Assurance Provisions
Uniforms

6.3 Changes from previous issue. The margins of this document are marked with an asterisk (*) to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content, irrespective of the marginal notations and relationship to the previous issue.

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Custodians:

Army - GL
Navy - NU
Air Force - 11

Review activities:

Navy - MC,
Air Force - 99, 82
DLA - CT

Preparing activity:

Army - GL

(Project 8410-0737)

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2. DOCUMENT DATE (YYMMDD)
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3. DOCUMENT TITLE

PROVISIONS FOR EVALUATING QUALITY OF SLACKS, WOMEN'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

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