

INCH-FOUND

MIL-STD-1391D

2 June 1992

~~SUPERSEDING~~

MIL-STD-1391C

5 October 1984

MILITARY STANDARD
PROVISIONS FOR EVALUATING QUALITY
OF
OVERCOATS, MEN'S



FSC 8405

ANSC N/A

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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 of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, P.O. Box 59, Natick, MA 01760-0001 by using the self-addressed 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>Title</u>
MIL-O-2414(NU)	- Overcoat, Man's, Enlisted
MIL-O-43537(GL)	- Overcoat, Man's, Wool, Army Green 44, With Removeable Liner
MIL-O-82250(NU)	- Overcoat, Man's, (Officer's Type)

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1. SCOPE

1.1 Scope. The scope of this standard is to provide standardized provisions for evaluating the quality of men's overcoats.

1.2 Application. This standard will be made applicable to contracts by references in the appropriate overcoat specifications. These documents require:

(a) As a final step in the contractor's production control plan before formation of a lot, each overcoat shall be buttoned on a model form and examined for selected defects.

and

(b) An overcoat containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in Table II as asterisk (*) defects. The selected asterisk defects are listed individually in Table III. The examination for selected defects will also include the measurement of those selected defects identified in Table IV.

1.2.1 Model form. The model forms (for the selected defects examination specified in 1.2, and for examination of defects XI through XXVII in Table II, Classification of defects) shall be men's forms conforming to the measurements specified below. The overcoat sizes listed shall be examined on the appropriate model form size as specified below.

Coat size	Model form size	Model form measurements		
		Chest <u>1/</u>	Waist <u>1/</u>	Hip <u>1/</u>
30, 31	30	32	26	32
32, 33	32	34	28	34
34, 35	34	36	30	36
36, 37	36	38	32	38
38, 39	38	40	34	40
40, 41	40	42	36	42
42, 43	42	44	38	44
44, 45	44	46	40	46
46, 47	46	48	42	48
48, 50	48	50	44	50
52	50	52	46	52

1/ Tolerance \pm 1/2 inch

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2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks forms a part of this document to the extent specified herein. Unless otherwise specified, the issue 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).

STANDARD

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 Definition

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

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

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 the 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 standard shall take precedence. Nothing in this standard, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

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3. DEFINITIONS

3.1 Fabric defects. The fabric defect definitions applicable to the standard are described in FED-STD-4. Fabric defects shall be clearly visible when examined at a distance of 3 feet.

3.2 Knots and slubs. Only knots and slubs that exceed the limits specified in the basic cloth specification and are clearly visible when examined at a distance of 3 feet shall be scored as defects in evaluating quality of overcoats.

3.3 Quality assurance terms and procedures. Quality assurance terms and procedures, when applicable, shall be in accordance with MIL-STD-105 and MIL-STD-109.

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

3.5 Defective button. A button shall be considered defective when it has a sharp, rough, cracked or split edge; scratches, dents, blemishes, imbedded foreign matter, loose shank, loose shell; badly shaded or poorly plated.

3.6 Outside-inside. The terms "outside" and "inside" as used in this standard for defects I, II, and IV (see Table II) are defined as follows:

Outside - Any part of overcoat that is visible when the completely buttoned overcoat is observed on the model form (including undersleeve).

Inside - Any part of overcoat that is not visible when the completely buttoned coat is observed on the model form.

The terms "outside" and "inside" as used in this standard for any defects other than I, II, and IV are defined as follows:

Outside - Any part, seam or stitching that appears on the outer overcoat. This includes under the collar (including undercollar), under the shoulder loops, under the pocket flaps and in the back vent.

Inside - Any part, seam, or stitching that does not appear on the outer overcoat.

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

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* 3.8 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 (see 2.2), Method 88B for seams. Puckering on a major portion of the suspected seam that equals or is worse than rating 3 for single needle seams or double needle seams shall be scored as a puckered seam.

*4. GENERAL REQUIREMENTS

This section is not applicable to this standard.

5. DETAILED REQUIREMENTS

5.1 Purpose. This standard contains the provisions for end item examination, dimensional examination, and packaging inspection for overcoats. If there are any inconsistencies between the requirements of the appropriate specification and the provisions of the standard, the specification shall control. This standard assigns to listed defects, point values of 1, 2, or 3 depending on a degree of severity. The higher point values are assigned to those defects having more detrimental effect on the appearance or serviceability of the item. The defects indicated by an asterisk (*) in Table II are those defects having the most detrimental effect on appearance or serviceability of the item.

5.2 Inspection procedures. Inspection procedures shall be 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 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 change.

5.5 Switching procedures.

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:

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- (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 sixty 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 ~~seventy-five~~ seventy-five 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 administrating 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 NOTE to Table I); or
- (c) Production becomes irregular or delayed; or
- (d) Other conditions warrant that normal inspection be instituted.

5.6 End item examination. The overcoats shall be buttoned on a model form or laid out flat on a table as required in Table II for inspection. The overcoats shall be examined and all defects shall be penalized as indicated in Table II of this standard. The sample size shall be as specified in Table I. the sample unit shall be one finished overcoat. 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.

OR

- c. The number of selected defects (asterisk * defect) exceeds the maximum allowed for the sample size (see Table I).

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* 5.6.1 Examination for measurable defects (Table IV). As a part of the end item examination, the applicable number of overcoats specified below shall be measured to determine the presence of defects listed in Table IV. At least one overcoat from each size in the lot shall be included in the sample. When the number of sizes in the lot exceeds the sample size, the sizes to be included in the sample shall be randomly selected from among all the sizes. The sample shall be examined for all end item characteristics as well as being measured for the defects in Table IV. Additional dimensional measurements may be taken at any time in the remainder of the end item examination. The number of selected defects found and the points scored during this examination shall be included with the selected defects and point count scored for the entire specified sample size of the end item examination. The contractor shall clearly identify the units subjected to this measurement examination by stamping the identification/instruction label with a 1/2 inch stamp depicting a -D- using indelible ink.

<u>Lot size</u>	<u>Sample size</u>
Up thru 500	8
501 thru 3200	13
3201 thru 35,000	20
35,000 and up	32

5.7 Dimensional examination. The appropriate number of overcoats, determined from the Table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate overcoat specification. When a measurement deviates from a dimension and tolerance specified, the overcoat shall be penalized one point. Each sample unit shall be penalized one point when the sleeves are uneven in length by 3/8 inch or more. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point values. Each size of overcoat present in the lot shall be represented in the sample selected for this examination.

<u>Lot size</u>	<u>Sample size</u>	<u>Maximum acceptable point values</u>
Up thru 500	8	0
501 thru 3,200	13	1
3,201 thru 35,000	20	2
35,001 and up	32	3

5.8 Examination of packaging requirements. An examination shall be made to determine that packaging, packing, and marking comply with Section 5 requirements of the appropriate overcoat specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully prepared for delivery. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be on the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per hundred units.

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<u>Examine</u> Marking (exterior and interior)	<u>Defect</u> Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.
Materials	Any component missing, damaged, or not as specified.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling, bulged or distorted container.
Content	Number of items per shipping container is more or less than required. Size shown on one or more items not as specified on shipping container. <u>1/</u>

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

6. NOTES:

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

* 6.1 Intended use. The overcoat standard is used to inspect garments which are intended for use by male military personnel of the Department of Defense. The overcoats are to be worn as part of the Dress uniform.

* 6.2 Subject term (key word) listing.

Coats, uniform dress
Quality assurance
Tables, inspection
Uniforms, quality

* 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 last previous issue.

Custodians:
Navy - NU
Army - GL

Preparing activity:
Navy - NU

Project No. 8405-0128

Review activity:
DLA-CT

User activity:
Navy - MC

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TABLE I - SAMPLING PROVISIONS

	Lot Size	Sample Size	Maximum Acceptance Number for Selected Defects (*defect)	Maximum Acceptable Point Values	
				3 & 2 point defects	3, 2, & 1 point defects
Normal	Up thru 90	20	0	5 points	10 points
Inspection	91 thru 150	32	0	6 points	16 points
	151 thru 280	50	0	10 points	20 points
	281 thru 500	80	0	13 points	28 points
	501 thru 1200	125	1	21 points	40 points
	1201 thru 3200	200	1	27 points	54 points
	3201 thru 10,000	315	2	38 points	82 points
	10,001 thru 35,000	500	3	54 points	122 points
	35,001 and over	800	5	82 points	183 points
Tightened	Up thru 90	20	0	4 points	7 points
Inspection	91 thru 150	32	0	5 points	11 points
	151 thru 280	50	0	7 points	16 points
	281 thru 500	80	0	10 points	21 points
	501 thru 1200	125	1	16 points	32 points
	1201 thru 3200	200	1	20 points	47 points
	3201 thru 10,000	315	2	33 points	70 points
	10,001 thru 35,000	500	3	49 points	104 points
	35,001 and over	800	5	73 points	156 points
Reduced	Up thru 280	20	0	3-6 points	10 points
Inspection	281 thru 500	32	0	5-11 points	18 points
	501 thru 1200	50	0	9-15 points	22 points
	1201 thru 3200	80	0	11-19 points	36 points
	3201 thru 10,000	125	1	19-27 points	47 points
	10,001 thru 35,000	200	1	25-34 points	70 points
	35,001 and over	315	2	34-44 points	104 points

NOTE: For the point values of the reduced inspection on 3 & 2 point defects. 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 II - CLASSIFICATION OF DEFECTS

Defect	Point Value
A. GENERAL DEFECTS	
I. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES	
a. Hole, cut, tear, smash, visible mend, burn, scorched area or open place:	
1. On outside	3
2. On inside (longest dimension in any direction):	
(a) - up to 1/4 inch inclusive	1
(b) - more than 1/4 inch	2
b. Loose yarn, snagged thread, misweave, area of no dye penetration, dye streak, missing yarn, broken yarn, thin place, shade bar or woven in waste; more than 1/4 inch (largest dimension in any direction):	
1. On outside	2
2. On lining	1
3. On liner	1
c. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching):	
1. On outside	2
2. On lining	1
3. On liner	1
d. Needle chew on outside:	
1. Up to 1/4 inch inclusive	2
2. More than 1/4 inch	3
e. Knot or slub (see 3.2 on outside)	2
II. SHADED PART	
a. On outside:	
1. Variation in shade between two or more parts (except parts which may be cut from ends)	3
2. Variation in shade within a part (except part which may be cut from ends)	3
3. Part cut from ends badly shaded	1
4. Undercollar parts not matching each other	1

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
b. On inside: Lining and liner	
1. Any part badly shaded	1
2. Sleeve lining pair not matching each other	1
III. PRESSING (Overcoat, with or without liner)	
a. Pressing omitted or poorly pressed (any specified operation)	2
b. Excess gloss	1
c. Edge bulky, i.e., not pressed solid	1
d. Lapel not roll pressed as specified	1
e. Sleeve not pressed as required	2
f. Armhole seam not pressed open across top (when applicable)	2
g. Armhole stretched	3
h. Armhole or shoulder not blocked	2
i. Inside of armhole not creased as required	1
j. Lining (except sleeve linings) not finish pressed	1
k. Collar breakline not creased as specified	1
l. Wrinkles, creases or pressing impressions not removed	1
m. Any required seam not pressed open or not pressed smooth or flat for more than 1/2 inch or not turned in accordance with requirements	1
n. Finished pressed width of lapel not uniform (i.e. one side finishing 1/4 inch or more than other when measured across upper portion on horizontal, from forced out edge to lapel creaseline)	2
o. Body, liner or lining, front darts, yoke, or pleats, back pleats, and bellows pleat not pressed smooth and flat	1
p. Pressing impressions under lapels, collar, pocket welts or flaps, half belt sections and vent not removed	1
q. Belt not pressed	1
IV. CLEANNESS	
a. Any spot or stain on outside (largest dimension in any direction):	
1. Up to 3/8 inch inclusive	1
2. More than 3/8 inch up to 3/4 inch inclusive	2
3. More than 3/4 inch	3
b. Any marking exposed or visible on outside	3
c. Thread ends not trimmed:	
1. Three or more on outside longer than 1/4 inch	2
2. Five or more inside longer than 1/2 inch	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
d. Two or more shade or size tickets on overcoat	1
e. Basting thread (including monofilament thread or fragments of monofilament thread) not completely removed from outside	1
V. COMPONENT AND ASSEMBLY	
a. Any component part or operation omitted (unless otherwise classified herein)	3
b. Any component not as specified (type, size, color, etc)	3
c. Any component part tight, twisted, distorted, pleated or full (unless otherwise classified herein)	2
d. Any operation not as specified (unless otherwise classified herein)	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
f. Any wool parts assembled with the face side on the underside (unless otherwise specified)	3
g. Any inside part assembled with the face side (as specified) on the underside	1
VI. CUTTING	
a. Any component part not cut in accordance with specified pattern, directional line or pattern or in accordance with specifications requirement	3
b. Twill line of any outside part not running in specified direction	3
c. Any outside component part not cut in the same direction of the nap	3
VII. SEAM AND STITCHING	
a. Accuracy of seaming:	
1. Seam puckered (unless otherwise classified herein)	1
2. Seam irregular, pleated or wavy (unless otherwise classified herein)	2
3. Part of overcoat, lining or liner caught in any unrelated operation or stitching	2
4. Blindstitching, tacking, or hand felling of armhole exposed on outside	1
5. Machine felling or hand felling (other than around armhole) exposed on outside for a distance of 3/8 inch or more	1

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
6. End of stitching when not caught in another seam or stitching not finished as specified	1
7. Stitching overlapping end of thread break less than 1/2 inch	1
8. End of a continuous line of stitching overlapped less than 1/2 inch or ends of label stitching overlapped less than 3 stitches	1
9. Not specified color thread used on outside	2
10. Needle perforations visible on outside	2
b. Gage of stitching and seam allowance:	
1. Stitching irregular, not within range specified, or varies more than 1/16 inch when no range is specified (score only when condition exists on more than 1/2 the length of seam)	1
2. Edge, top, or raised stitching sewn too close to edge resulting in damage to cloth	3
3. Width of seam allowance varies more than 1/16 inch from allowance specified (score only when condition exists on more than 1/2 the length of seam)	1
c. Open seam (see 3.4 and 3.6):	
1. On outside (excluding lower edge of undercollar):	
(a) - More than 3/4 inch	3
(b) - More than 1/2 inch up to 3/4 inch inclusive	2
(c) - Up to 1/2 inch inclusive	1
2. On inside and liner: Machine felling and hand felling (other than hand felling around armhole):	
(a) - More than 3/8 inch up to 2 inches (inclusive)	1
(b) - More than 2 inches	2
3. On inside and liner: Stitch type 301 and hand felling around armholes:	
(a) - Up to 2 inches inclusive	1
(b) - More than 2 inches	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
d. Raw edge: (see 3.7)	
1. On outside: (except per, permitted)	
(a) - Up to 1/2 inch inclusive	1
(b) - More than 1/2 inch up to 3/4 inch inclusive	2
(c) - More than 3/4 inch	3
2. On inside and liner: (excluding an edge that is not required to be turned under, pinked or overedged):	
(a) - 3/8 inch up to 2 inches inclusive	1
(b) - More than 2 inches	2
e. Seam and stitch type:	
1. Not specified seam or stitch type	3
2. Any line of stitching omitted or insecure	2
3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein)	1
4. Looper thread or 401 stitch type on outside	3
f. Stitch tension:	
1. Loose tension resulting in a loose seam	3
2. Loosely exposed loops of lower or top thread on edge, top, or raised stitching	2
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)	3
g. Stitches per inch (score only when condition exists on more than 1/2 the length of seam):	
1. More than the maximum specified	1
2. Less than the minimum specified:	
(a) - By one or two stitches	1
(b) - By three or more stitches	2
h. Runoff, skipped, or broken stitch:	
1. Joining seam - use open seam classification	-
2. Edge, top or raised stitching (more than 1/4 inch)	1
i. Bartack, backtack, tack, or tacking (except buttonhole bartack):	
1. Missing, insecure, misplaced, not serving intended purpose, or not specified length or type	2
2. Loose stitch tension	1
3. Length not as specified by 1/16 inch or more	1
4. Other than direction specified	1

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
VIII. BUTTONHOLE	
a. Misplaced or not positioned as specified	3
b. Omitted, added, not specified type or not finished as specified	3
c. Gimp omitted or ends of gimp not pulled thru to underside of cut first square bar buttonhole	2
d. Ragged edge, incomplete stitching, stitching not securely caught in fabric, bulky appearance, stitches not uniformly spaced or uncut stitches	2
e. Broken stitch or two or more skipped stitches	2
f. Buttonhole stitching extending beyond bartack	2
g. Bartack missing, loose or misplaced (not serving intended purpose)	2
h. Stitches per buttonhole or bartack less than minimum number specified by:	
1. One to three stitches	1
2. Four or more stitches	2
i. Finished length or diameter not as specified	2
j. Buttonhole stitching not covering gimp for a distance of more than 1/8 inch	1
k. Ends of buttonhole in bartack area are uneven in length by more than 1/8 inch	2
IX. BUTTONS (see para. 3.5)	
a. Omitted, broken or defective	2
b. Out of horizontal or vertical alignment by:	
1. 3/16 to 3/8 inch inclusive	1
2. More than 3/8 inch	2
c. Misplaced, loose, not attached as specified or insecurely sewn	1
d. Shank wrapping (when required) omitted, loosely or insecurely wrapped, or not specified length	2
e. Part of garment pleated or puckered by button sewing	1
f. Stitch not locked at end of cycle (tug at the loose end of the thread when accessible to determine if it will ravel)	2
g. Tacking stitches omitted or insecure (hand sewn)	2
h. Button sewn with eagle or anchor in other than specified direction	1
X. BUTTON LOOP	
a. Omitted or insecure	1
b. Misplaced or not attached as specified	2
c. Length or width not as specified	1

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
B. OVERCOAT BUTTONED ON FORM	
XI. POSITION AND ALIGNMENT OF FRONT, BACK, BUTTONS, BUTTON LOOPS, AND BUTTONHOLES	
a. Top or lower button or buttonhole misplaced or not positioned as specified by:	
1. 3/8 to 1/2 inch inclusive	3
2. More than 1/2 inch	*
b. Button and buttonhole not aligned, causing a bulge or twist;	
1. On front	3
2. On half belt or tab for sleeves, collar, vent or lapel	1
c. Spacing between front buttonholes varying more than 1/4 inch	1
d. Buttonholes unequally spaced from edge by 1/8 inch or more	1
e. Left front below bottom button swings to the right or left, when measured as a straight line extension of the front edge by more than 1/2 inch	2
f. Back shorter or longer than front by more than 1/2 inch	3
g. MIL-O-2414 Only:	
1. Top button stitching through inside breast pocket causing an obstruction in pocket	2
2. Hidden button stitching not caught in inner ply of slash (Beason) pocket	1
XII. FRONTS	
a. Length:	
1. With overcoat buttoned:	
(a) - left front shorter than right front at bottom by:	
(1) - 1/8 to 1/4 inch inclusive	2
(2) - More than 1/4 inch	*
(b) - Left front longer than right front at bottom corner by:	
(1) - 1/8 to 1/4 inch inclusive	2
(2) - More than 1/4 inch	*
(c) - Right front at bottom corner exposed beyond bottom edge of left front by more than 1/8 inch	2
(d) - Fronts uneven at neck when buttoned by more than 1/4 inch	2
2. Unbuttoned fronts uneven in length by 3/8 inch or more	3

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
b. Facing, front and bottom edges:	
1. Front rolling outward below bottom button	3
2. Facing tight, short, or twisted causing fullness or twist on fronts	3
3. Front or bottom edge stretched, bulky or irregular	1
4. Bottom corner or right front misshapen or distorted	1
5. Facing full; lapel will not lie smooth and flat	3
6. Facing exposed beyond front or bottom edge by more than 1/16 inch for a distance of more than 1 inch	1
7. Tacking at back edge of facing to interlining omitted or insecure	1
XIII. POCKET, WELT, OR FLAP	
a. Misshapen or distorted - any point varying;	
1. More than 1/4 inch with corresponding point on finished shaper	*
2. 1/8 inch up to 1/4 inch (inclusive) with corresponding point on finished shaper	3
b. Not uniform in size or shape; any point varying more than 1/4 inch with corresponding point on matching part	3
c. Out of alignment in any direction or misplaced at any point by: <u>1/</u>	
1. More than 3/8 inch	*
2. More than 1/4 up to 3/8 inch inclusive	3
3. More than 1/8 up to 1/4 inch inclusive	2
d. Side not parallel with front edge of coat by more than 1/4 inch	1
e. Twisted, puckered, or too full; pocket, welt or flap will not lie smooth or flat	2
f. Finished length, width, or depth not within tolerance specified	1
g. Lining or underside exposed beyond edge of patch pocket or flap more than 1/16 inch	2
h. Double welt pocket gapping by more than 1/4 inch or overlapping each other by more than 1/16 inch at any point	1

1/ Following local points shall be measured in the examination for this condition:

1. Flap: Top corner of flap nearest front edge of coat and front edge of flap just before the curved corner.
2. Patch pocket: Bottom of straight edge nearest edge of coat.
3. Welt pocket: Top corner of pocket nearest front edge of coat.

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
i. Notch or raw edge at corner exposed at end of welt or tongue notch not securely caught in the row of stitching or bartack of welt	3
j. Pocket opening too tight, i.e., fullness or puckering in side front or fuller than side front	3
k. Corners insecurely backtacked	2
l. Top edge of raise stitching on welt through the underply of pocket	3
m. Corner tacks, decorative stitching (when applicable) misplaced, omitted or not serving intended purpose	2
n. Topstitching along welt crooked, not parallel to pocket or misplaced	1
o. Notch or binding not caught in stitching on underside at end of welt	2
p. Tape, reinforcement piece or interlining omitted	2
q. Tape stitching exposed and visible on outside	2
r. One or both ends of welt pleated	1
s. Material twill lines of welt not running in same direction or angled by more than 1/8 inch as twill lines on front	2
t. Lining tight or twisted causing flap to curl or twist	2
u. Fullness on outside of flap	2
v. Top edge of welt at corner opening 3/16 inch or more below seam joining flap to front	2
w. Edge of flap not properly forced out or lining exposed	1
x. Front at corner of pocket opening pleated or distorted	1
XIV. TABS (sleeves, collar, lapel and vent)	
a. End poorly shaped or ends not of uniform shape or size	1
b. Tight, loose or distorted when buttoned	1
c. Bottom edge of sleeve tabs not uniformly positioned from bottom edge of sleeve by more than 3/8 inch	1
d. Irregular in width by 3/16 inch or more	1
e. Finished length or width not as specified	1
f. Misplaced	1
g. Edge not fully forced out	1
h. Construction other than specified	1
i. Omitted or insecurely attached	3
j. Felling stitches on serged edge of lapel tab not caught through interlining	2
XV. SWORD SLIT OPENING	
a. Omitted or misplaced	3
b. Assembly reversed, i.e., facing stitched to front edge of underarm seam of left forepart and flap stitched to back underarm seam of left forepart	3

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
c. Flap too large causing puckers or pleats on foreparts	1
d. Width and length of flap varies more than 1/8 inch from finished shaper	3
e. One or both ends insecurely tacked	2
f. Flap lining tight or twisted, causing fullness or twist on outside of flap	2
XVI. HAND OPENING	
a. One or both ends not completely caught in stitching at ends of welt	2
b. Finished piping less than 1/4 inch or more than 3/8 inch wide	1
c. Length of opening not as specified	1
d. Hand felling on lining around pocket opening not performed as specified	1
XVII. COLLAR OR LAPEL	
a. Misshapen or distorted - any point varying:	
1. More than 1/4 inch with corresponding point on finished shaper	*
2. 1/8 inch up to 1/4 inch (inclusive) with corresponding point on finished shaper	3
b. Not uniform in size or shape - any point varying:	
1. More than 5/16 inch with corresponding point on matching part	*
2. More than 1/4 inch but not more than 5/16 inch with corresponding point on matching part	3
3. More than 1/8 inch but not more than 1/4 inch with corresponding point on matching part	2
c. Twisted, short, tight or long, i.e., causing curled edges, puckering, fullness, or pleat on one or more collar or lapel parts or in seamline joining parts	*
d. Collar setting	
1. Short, i.e., causing puckers on back or front along edge of collar or pulling lapel breakline causing front to roll out	3
2. Long, i.e., setting away from neck collar not fitting neck, or lapel rolling higher than 2 inches above top front button or buttonhole when measured along front edge	3

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
3. Collar not properly set, causing a curve or bulge on creaseline at joining to gorge seam	3
4. Tight at joining to gorge seam of front or facing or undercollar across back causing fullness on lapel or fullness or pleat across outside of back	2
e. Collar (top, under, or stand):	
1. Collar off center at front by 1/4 inch or more with shoulder seamlines matching	2
2. Collar edge short across shoulders, causing collar to rise above creaseline by:	
(a) - More than 1/4 inch up to 1/2 inch inclusive	2
(b) - More than 1/2 inch	3
3. Collar edge or piping crooked, irregular or wavy	2
4. Gorge seam not spread open (any portion), not straight, tacking insecure or tacking omitted	2
5. Gorge seam length not uniform by 1/4 inch or more	1
6. Undercollar exposed beyond collar edge by more than 1/16 inch or for a distance of more than 1 inch	2
7. Center seam of undercollar not aligned with center back seam of coat by more than 1/4 inch	2
8. Undercollar joining seamline exposed below edge of collar across back	3
9. Width not within tolerance specified or 1/4 inch from required width when no tolerance is specified	2
10. Length of collar ends not within tolerance specified or (+) 1/4 inch from required length when no tolerance is specified	2
11. Back end of gorge seam machine stitched less than 1 inch back of lapel breakline	1
12. Breakline on undercollar not stitched, when required	1
13. Collar interlining tight or twisted, causing puckers on undercollar	1
14. Undercollar lower raw edge stitching not uniform for more than 3/4 inch	1
15. Undercollar lower raw edge stitching not repaired neatly	2
16. Blindstitching at corner of collar or lapel exposed on outside of overcoat	1

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
17. Tacking on corner of undercollar to lapel omitted or insecured	1
18. Undercollar distorted or pleated at joining seam to coat	2
19. Piping omitted	3
20. Collar rolling up above breakline by:	
(a) - 1/8 inch up to 3/16 inch inclusive	3
(b) - More than 3/16 inch	*
f. Lapel	
1. Gap between top edge of lapel and end of collar or overlap of collar end on lapel step on one side of coat not uniform with other side of coat by:	
(a) - 1/8 inch up to 1/4 inch inclusive	2
(b) - More than 1/4 up to 5/16 inch inclusive	3
(c) - More than 5/16 inch	*
2. Lapel facing twisted, short or tight causing lapel to curl out or twist	3
3. Front part of coat exposed by more than 1/16 inch or for a distance of more than 1/2 inch on step or front edge of lapel	2
4. Length of lapel step not within tolerance specified or (+) 1/4 inch from required length when no tolerance is specified	2
5. Fullness (not smooth and flat)	2
6. Lapel facing pleated or puckered	3
7. Lapel edge irregular, wavy or not properly forced out	2
8. Collar end lapped over top edge of lapel on one or both sides	3
9. Notch length not within specified tolerance or not uniform within 1/4 inch from one side to another	3

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
g. Bridle tape	
1. Bridle tape not held taut causing breakline not to finish flat or to be misplaced (i.e. tape extending beyond breakline on lapel side)	3
2. Bridle tape misplaced:	
(a) - At gorge:	
(1) - more than 3/8 inch behind lapel breakline	3
(2) - Bridle tape basted onto or extending beyond breakline on lapel side	*
(3) - More than 5/8 inch behind lapel breakline	*
(b) - At 1-1/2 inches from lapel bottom:	
(1) - more than 5/8 inch behind lapel breakline	3
(2) - bridle tape basted onto or extending beyond breakline on lapel	*
(3) - bridle tape more than 7/8 inch behind lapel breakline	*
(c) - Bridle tape end not within 1 to 1-1/2 inches from bottom of lapel	2
XVIII. SHOULDERS	
a. Improperly joined or set, causing shoulder or back to twist	3
b. Shoulder seamline curved towards back from normal position at armhole end by:	
1. More than 3/8 inch	2
2. 1/4 inch up to 3/8 inch inclusive	1
c. Vertical seamlines on front and back of coat staggered 1/4 inch or more at shoulder seamline	2
XIX. SHOULDER PAD	
a. Not properly set, causing shoulder to twist, pucker, or bulge	3
b. Misplaced, not serving intended purpose, i.e., too far back or too far forward, not completely or securely caught in armhole tacking	3

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
XX. SHOULDER STRAP (LOOP)	
a. Not uniform in size or shape, any point varying:	
1. More than 3/8 inch with corresponding point on matching part	3
2. 1/4 inch up to 3/8 inch inclusive with corresponding point on matching part	2
b. Length or width not within tolerance specified or 1/4 inch when no tolerance is specified	2
c. Misplaced so that shoulder seamline is exposed	3
d. Set upside down exposing underside seamline	3
e. Strap will not lie flat, twists, or bulges when buttoned, fastened, or tacked	2
f. Piped edge is puckered, wavy, or irregular in width	1
g. Poorly shaped	1
h. One strap further forward or backward of the shoulder seamline from position of other strap by more than 1/4 inch	2
i. End of strap not positioned within tolerance specified or 1/8 inch when no tolerance is specified from finished edge of collar or undercollar neck joining seamline	2
j. Ends of both shoulder straps unequally placed from finished edge of collar or undercollar neck joining seamline by more than 1/4 inch	2
k. Button partially or fully covered by collar when specified not to be covered	1
1. Button or buttonhole exposed beyond collar edge (MIL-O-43537)	2
m. Buttonhole location not as specified	2
XXI. ARMHOLE	
a. Stretched causing excessive fullness on back between shoulder and underarm	3
b. Crooked or puckered seamline	2
c. Tape or armhole tacking stitches visible on outside	2
d. Armhole not tacked as specified	2
e. Armhole tacking stites exposed and visible on outside	2
XXII. SLEEVE HEAD WADDING	
Not tacked to armhole as specified, omitted when specified, tacking incomplete, insecure, misplaced, or not serving intended purpose	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
XXIII. SLEEVE	
a. Set improperly, sleeve hangs with break or twist	*
b. Sleeve reversed, i.e., right sleeve set in left armhole	3
c. Fullness misplaced or concentrated in one area	3
d. Tight at armholes, i.e., roll effect not present on front or back of sleeve	3
* e. Front edge of sleeve either too far front or too far back when measured from its normal hanging position by:	
1. More than 2 inches	3
2. More than 1 inch up to 2 inches inclusive	2
NOTE: The normal hanging position for the sleeve is:	
1. MIL-O-43537(GL) and MIL-O-82250(SA) Overcoats:	
a. Front of pocket - from center of welt joining seam	
b. Back of pocket - from lower back corner of welt	
2. MIL-O-2414(NU) Overcoat:	
a. From lower end of pocket opening	
f. Lining too long, extends below bottom edge of sleeve or sags below felling to sleeve hem by 1/2 inch or more	1
g. Wigan twisted, tight or pleated causing puckering on outside of sleeve	2
h. Underarm sleeve seamline not aligned with side seamline by 1/4 inch or more, or not aligned uniformly with side seams by 1/4 inch or more	2
i. Backarm seamlines unequal distance from shoulder seamlines or forearm (inseam) seamlines unequally spaced from side seamlines by more than 3/8 inch	1
j. Bottom edge of sleeve uneven by:	
1. 1/4 inch to 3/8 inch inclusive	1
2. More than 3/8 inch	2
k. Tacking of sleeve lining seam to sleeve seam omitted, insecure or incomplete	1
l. Bottom edge of braid from bottom of sleeve not within tolerance specified or (+) 1/4 inch from required distance when no tolerance is specified	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
m. Edges of braid at backarm seam staggered:	
1. 1/8 inch to 1/4 inch inclusive	1
2. More than 1/4 inch	2
n. Sleeve lining twisted, tight, or short causing fullness or twist on outside of sleeve	3
o. Braid stitched too tightly to sleeves causing puckers; or stitched too loosely causing puckers or pleat on braid	2
p. One or both sleeve seams not pressed open	2
XXIV. SLEEVE CUFF (Regular and Ornamental)	
a. Full, tight, puckered, or twisted	2
b. Point of cuff not uniformly shaped or not forced out to a sharp point	2
c. Uneven in width or cuffs not uniform in width by 1/4 inch or more	1
d. Sleeve seamline in cuff not aligned with sleeve seamline above cuff by 1/4 inch or more	1
e. Top edge of cuffs at backarm or underarm seamline staggered more than 1/8 inch	2
f. Finished height of cuff at point, backarm seamline or forearm seamline not as specified	2
g. Ornamental piece poorly shaped, set on crooked or misplaced	2
h. Edge of cuff irregular by 1/8 inch or more	2
i. Flat part (stitch portion) of tubular braid exposed on edge of cuff for a length of 1/4 inch or more	1
j. Piping omitted	3
XXV. FRONT AND BOTTOM EDGES	
a. Front edge stretched	2
b. Tape set too tight causing puckering on front or bottom edge	2
c. Front edge irregular, bulky, or not fully forced out	2
d. Bottom corner of left front poorly shaped	1
e. Bottom edge stretched or uneven	1
f. Stitching along bottom edge exposed on outside	1
XXVI. FITTING	
a. Body lining:	
1. Tight, short, or twisted causing fullness or twist on outside of coat	3
2. Lining too long, exposed beyond bottom edge of coat	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
b. Interlining:	
1. Tight, short, or twisted causing fullness or twist on outside of coat	3
2. Too full, causing front to have a wavy appearance or not lie smoothly	3
XXVII. VENT	
a. Not lapped in direction specified	2
b. Outer vent edge stretched or not properly constructed causing vent to open	3
c. Lining, interlining or tape tight, short or twisted causing puckers or fullness on outside of vent edge	2
d. Outer vent edge irregular	2
e. Stitching of stay or tape on outer vent exposed and visible on outside	1
f. Bottom turn-up exposed on outside of outer vent edge	1
g. Outer vent shorter or longer than inner vent by:	
1. 1/4 inch to 1/2 inch inclusive	1
2. More than 1/2 inch	2
h. Stay piece or tape on inside of left vent omitted	2
i. Diagonal row(s) of stitching across top of vent opening omitted, insecure, or not as specified	2
j. Top of right vent lining not folded diagonally or not extending above top of right vent as specified	1
k. Stitching on back seam extends more than 1/2 inch below diagonal row of stitching on back	1
l. Distance of left vent lining from edge of left vent and folded edge of left vent lining from left vent not as specified	1
m. Top edge of silesia stay not caught in stitching across vent extension	1
n. Turn-back of left vent irregular in width by 1/4 inch or more	1
o. Folded edge of right vent lining exposed beyond raw edge of right vent (score only when condition exists on more than 1/2 the length of seam)	1
p. Blindstitch tacking on back edge of left vent omitted	2
q. Vent overlap 1/4 inch or more or less than specified	1
r. Vent not top stitched as specified	1
s. Felling on bottom corners of lining and vent omitted or not secure	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
C. DETAILED DEFECTS (OVERCOAT SPREAD OUT ON TABLE)	
XXVIII. DART, PLEATS, OR BELLOWS	
a. Omitted	
1. On outside	3
2. On inside and liner	2
b. Dart not tapered to a point causing bulge on outside	2
c. Corresponding darts, pleat or bellow unequal in length by more than 1/2 inch	2
d. Fold not facing direction specified	1
e. Darts or pleats not uniformly positioned	2
f. Not pressed flat	1
g. Length, depth, location, or construction other than specified	2
h. Bellow strip short causing front to pucker or twist	2
i. Bellow pleat twisted	1
j. Bellow pleat not abutted along top edge of hem	2
XXIX. BINDING, CORD, BRAID, OR PIPED EDGE	
a. Omitted	3
b. Tight, twisted or loose causing puckered, curled or wavy edge	3
c. Width not as specified	1
d. Edge not properly forced out	1
e. Not securely caught to fabric causing fabric to pull away	2
f. Ends not caught as specified	1
g. Not starting or finishing as specified	1
h. Not spliced or caught as specified	1
XXX. HEMS	
a. Twisted, puckered, or pleated	2
b. Irregular in width by more than 1/8 inch	1
c. Finished width not within tolerance specified or 1/8 inch from width required when no tolerance is specified	1
d. Seam lines in hem turnup not aligned with coat seam lines by more than 1/4 inch	1
e. Tape on bottom turn-up not specified type, width or color	1
f. Not bound, taped or turned under as specified	2
g. Tacking on turn-up of front to front omitted or insecure	1
h. Felling or blindstitching of hem not securely caught to overcoat	2
i. Step at front hem edge not squared when specified	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
XXXI. BELT ASSEMBLY	
a. Belt (general)	
1. Free end or point poorly shaped	2
2. Irregular by more than 1/8 inch or not of uniform width	1
3. Lining, interlining or underply tight or twisted	2
4. Length or width of finished belt not as specified	2
5. Fullness, twist or pleats on upperside	2
6. Edge stretched or full	2
7. Joining seam off center by 1/4 inch or more	1
8. Attached with underseam exposed on opposite side to that specified	2
9. Point off center by 1/4 inch or more	1
10. Joining seam not pressed open	1
b. Half-belt	
1. Out of horizontal alignment by more than:	
a. 1/2 inch to 3/4 inch inclusive	1
b. More than 3/4 inch	2
2. Position other than specified	2
c. Full belt	
1. Belt in reversed position, i.e., buckle end of belt on wrong side	1
2. Length of turnback less than specified	1
3. Raw edge not turned under at turnback	1
4. Buckle omitted, defective or not specified type, size, color or finish	3
5. Belt keeper:	
a. Omitted or insecure	2
b. Too short, not permitting belt to lie smoothly or to function freely, opening wider by 1/4 inch than belt	2
c. Finished width not as specified	1
d. Position not as specified	1
6. Belt loop:	
a. Any omitted	3
b. Misplaced, not attached as specified, poorly shaped or set on an angle (more than 3/16 inch off the perpendicular)	2
c. Length or width not as specified	2
d. Raw ends extending more than 1/4 inch from stitching	1
e. Irregular in width by more than 1/8 inch	1
f. Reversed; set with covering stitch or seam on outside	2
g. Out of horizontal alignment by more than 1/2 inch	2
h. Insecure	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

<u>Defect</u>	<u>Point Value</u>
XXXII. FRONT, BACK (YOKE), VENT AND SLEEVE LINING	
a. Twisted, short or tight causing puckering or twist on outside	2
b. Backstitching at armpit of armhole from forearm seam to side seam omitted or insecure	2
c. Bottom turn-up of sleeve lining not specified distance from lower end of sleeve	1
d. Shoulder seam not lapped as specified	2
e. Welt pocket slash lining opening not as specified	1
f. Sleeve seam out of alignment with sleeve seam at armhole or at bottom of sleeve by more than 3/4 inch	1
g. Lining too long, extends below bottom edge of sleeve by more than 1/2 inch	1
h. Tacking of sleeve lining seam to sleeve seam omitted or insecure	2
i. Bottom of front and back yokes staggered 1/2 inch or more at side seam	1
j. Lower edge of front yoke not completely covering top edge of bellow strip	2
k. Tacking no bottom edge of yoke to side seam omitted or insecure	1
l. Felling on bottom corners of lining and vent omitted or insecure	1
XXXIII. INSIDE POCKET	
a. Positioned other than specified	3
b. Width of pocket opening or depth of pocket not as specified	2
c. Opening gapped by more than 1/4 inch in the center of opening	1
d. Finished width of piping less than 3/16 inch or more than 1/4 inch	1
e. Stay or facing omitted	1
f. Tacking along front edge of pocket through facing and interlining omitted or insecure	2
g. Tacking on upper or back edges of inside pockets to interlining omitted or insecure	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
XXXIV. HANGING POCKET	
a. Stitching on one or both ends of welt not completely caught through specified plies of material, i.e., facing, stay piece or pocketing	3
b. Reversed; finished with face side not on inside of pocket	2
c. Twisted, tight or short; pocket does not lie smoothly	2
d. Depth not as specified	1
e. Seam allowance or twill or corduroy pocket not tacked to interlining as specified	2
f. Back ply not lined on outside with rayon lining	3
g. Tacking along front edges on interlining omitted or insecure	2
h. Row of stitching around edges of pocket adjacent to binding omitted	2
XXXV. SHIELDS	
a. Tacking of lower edge omitted, insecure or not located as specified	1
b. Finished length or width not within tolerance specified or 1/4 inch from required measurement when no tolerance is specified	1
c. Not positioned as specified by more than 1/2 inch	2
d. One or both, omitted	2
e. Top edge not securely caught in armhole tacking or stitching	1
f. Puckered, pleated or twisted	1
g. Top or bottom raw edge of binding on shield (when applicable) not turned under and caught in stitching	1
h. Binding (when applicable) omitted on one or both armhole shields	2
i. Binding (when applicable) not securely stitched to fabric	1
XXXVI. LINER	
a. Size shown on liner not same as overcoat	1
b. Fronts uneven in length by more than 3/4 inch	2
c. Slash opening:	
1. One or both omitted	3
2. Out of alignment by more than 1 inch	2

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TABLE II - CLASSIFICATION OF DEFECTS (cont'd)

Defect	Point Value
d. Vent uneven in length by more than 3/8 inch	1
e. Lining tight or short causing puckering on wool part	2
f. Stitching around edges through wool part and lining omitted before binding operation	1
g. Shoulder seam not pressed open (wool part)	1
h. Ends of binding at top of vent opening not caught in bartack or stitching	2
i. Ends of binding on slash opening not caught in bartack	2
 XXXVII. SLIDE FASTENER	
a. Not type, size or finish specified	3
b. Any part of assembly defective	3
c. Overcoat or liner twisted or distorted when slide fastener is engaged	3
d. Stitching too close to metal chain, not permitting slider to pass freely	3
e. Slide fastener tape stitched on too loosely or tightly causing waviness or puckering	1
f. Ends of tape not turned under when specified	2
g. Tape not attached or positioned as specified	2
h. Tape stitched to liner or facing with one row of stitching	2
i. Front button stitching caught through slide fastener track at back edge of facing prohibiting function of the slide fastener	3
 XXXVIII. HANGER LOOP	
a. Omitted or insecure	2
b. Misplaced 1/2 inch or more off center with center back	1
c. Finished length not as specified by more than 1/2 inch	1
d. Not specified type or construction	1
e. Spread of hanger loop not as specified by more than 1/2 inch	1
 XXXIX. LABEL	
a. Missing, incorrect, or illegible:	
1. Size, instruction, or combination label	3
2. Identification label	1
b. Not attached as specified or location incorrect	1
c. Stitching through printing	1
d. Misplaced by more than 1/2 inch from location specified	1
 XL. INSTRUCTION TAG	
a. Missing, incorrect, or illegible	1
b. Not attached as specified	1

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TABLE III - SELECTED DEFECTS

ALIGNMENT OF FRONT, BUTTON OR BUTTONHOLE

Top or lower button or buttonhole misplaced or not positioned as specified by more than 1/2 inch.

FRONTS

Length of front with overcoat buttoned, left front shorter or longer than right front by more than 1/4 inch.

POCKET, WELT, OR FLAP

Out of alignment or misplaced at any point by more than 3/8 inch.

Misshapen or distorted - any point varying more than 1/4 inch with corresponding point on finished shaper.

LAPEL OR COLLAR

Misshapen or distorted - any point varying more than 1/4 inch with corresponding point of finished shaper.

Not uniform in size or shape - any point varying more than 5/16 inch with corresponding point on matching part.

Twisted, short, tight or long, i.e., causing curled edges, puckering, fullness, or pleat on one or more collar or lapel parts or in seamline joining parts.

Collar rolling up above collar breakline by more than 3/16 inch.

Gap between top edge of lapel and end of collar or overlap of collar end on lapel step on one side of coat not uniform with other side of coat by more than 5/16 inch.

Bridle tape basted onto or extending beyond breakline on lapel side at gorge.

Bridle tape more than 5/8 inch behind lapel breakline at gorge.

Bridle tape basted onto or extending beyond breakline on lapel side at lapel bottom.

Bridle tape more than 7/8 inch behind lapel breakline at lapel bottom.

SLEEVE

Set improperly, sleeve hangs with break or twist.

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* TABLE IV. MEASUREABLE DEFECTS 1/

ALIGNMENT OF FRONT BUTTON OR BUTTONHOLE

Top or bottom button or buttonhole of coat out of alignment by more than 1/2 inch.

FRONTS

Length of front with overcoat buttoned, left front shorter or longer than right front by more than 1/4 inch.

POCKET OR FLAP

Out of alignment or misplaced by more than 3/8 inch.

LAPEL OR COLLAR

Gap between top edge of lapel and end of collar or overlap of collar on one side of coat not uniform with other side of coat by more than 5/16 inch.

SLEEVE

Set improperly; sleeve set too far forward or back, sleeves hang with break or twist; not hanging in position specified.

1/ All defects in Table IV are listed in the most critical classification. Refer to Table II to determine if another classification (3,2 or 1 point) may be applicable, prior to scoring.

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1 DOCUMENT NUMBER
MIL-STD-1391D

2 DOCUMENT DATE (YYMMDD)
92 06 02

3 DOCUMENT TITLE

MILITARY STANDARD PROVISIONS FOR EVALUATING QUALITY OF OVERCOATS, MEN'S

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

REVISION

5 REASON FOR RECOMMENDATION

6 SUBMITTER

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(if applicable)

7. DATE SUBMITTED (YYMMDD)
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8 PREPARING ACTIVITY

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b TELEPHONE (include Area Code)
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