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MILITARY STANDARD  
PROVISIONS FOR EVALUATING QUALITY  
OF  
COATED FABRIC RAINCOATS



FSC 8405

MIL-STD-1393B

DEPARTMENT OF DEFENSE

WASHINGTON, D.C. 20301

Provisions for Evaluating Quality of Coated Fabric Raincoats

1. This standard has been approved by the Department of Defense and is mandatory for use by the Departments of the Navy, Marine Corps, Army and Air Force.
2. Beneficial comments (recommendations, additions, and 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, 21 Stra Road, Natick, MA 01760 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

## MIL-STD-1392C

## FOREWORD

This standard provides a standardized procedure for evaluating quality of overcoats procured for the Department of Defense. It is intended to list in a single document, defects irrespective of fabrics, (i.e., wool or polyester/wool) or end use.

The objectives of this standard are to provide:

- a. Standardized defect descriptions.
- b. Standardized examination requirements.

As of the date of approval of this document, the following specifications will reference this standard.

<u>Specifications</u>	<u>Title</u>
MIL-O-16736(NU)	- Overcoat, Woman's, with Removable Liner, Enlisted
MIL-O-21086(MC)	- Overcoat, Woman's, Wool, Serge, Green

## MIL-STD-1392C

## CONTENTS

<u>Paragraph</u>		<u>Page</u>
1.	SCOPE	1
1.1	Purpose	1
1.2	Application	1
1.2.1	Model form	1
2.	REFERENCED DOCUMENTS	1
2.1	Government documents	1
2.1.1	Specifications, standards, and handbooks	1
3.	DEFINITIONS	2
3.1	Fabric defects	2
3.2	Knots and slubs	2
3.3	Quality assurance terms and procedures	2
3.4	Open seam	2
3.6	Defective button	2
3.6	Outside-inside	2
3.7	Raw edge	2
3.8	Puckering	3
4.	GENERAL	3
5.	SAMPLE AND INSPECTION PROVISIONS	3
5.1	End item examination	3
5.2	Dimensional examination	3
5.3	Packaging inspection	4
6.	INSPECTION	5
6.1	Initiation of inspection	5
6.2	Continuation of inspection	5
6.3	Switching procedures	5
6.3.1	Normal to tightened	6
6.3.2	Tightened to normal	6
6.3.3	Normal to reduced	6
6.3.4	Reduced to normal	6
7.	NOTES	6
7.1		6

## TABLES

<u>Number</u>		<u>Page</u>
I	Sampling provisions	4
II	Classification of defects	6
III	Selected defects	25

## MIL-STD-1392C

## 1. SCOPE

1.1 Purpose. The purpose of this standard is to provide standardization provisions for evaluating the quality of women'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 asterisk defects are listed individually in Table III.

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

Coat size	Model form size	Model form measurements		
		Bust <u>1/</u>	Waist <u>2/</u>	Hip <u>2/</u>
3, 4, 5	4	33	24	34
6, 7, 8, 9, 10	6	34	25	35
11, 12, 13, 14, 15,	12	37	28	38
16, 17, 18, 19	16	40	31	41
20, 22	20	43-1/2	34-1/2	45

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

## 2. REFERENCED DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. Unless otherwise specified, the following specifications, standards, and handbooks of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this specification to the extent specified.

## 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 Definitions

## MIL-STD-1392C

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

### 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 coat.

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.

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 are defined as follows:

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

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

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

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

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

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.

## MIL-STD-1392C

\* 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 7.1) for seams. Puckering or 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

4.1 This standard contains the provisions for end item examination, dimensional examination and packaging inspection for coats. If there are any inconsistencies between the requirement of the appropriate specification and the provisions of the standard, the specification shall control. The standard assigns to 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 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. SAMPLE AND INSPECTION PROVISIONS

5.1 End item examination. The coats 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 coat. 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 exceed 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).

5.2 Dimensional examination. The appropriate number of coats, determined from the table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate coat specification. When a measurement deviated from a dimension and tolerance specified, the coat 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 coat present in the lot should be represented in the sample selected for this examination.

## MIL-STD-1392C

<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

5.3 Packaging inspection. An examination shall be made to determine that the packaging, packing and marking requirements are in compliance with section 5 of the appropriate specification. Defects listed below shall be scored one point. The sample size for this examination shall be five shipping containers fully prepared for delivery with the exception that they need not be closed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot shall be unacceptable if one or more points are scored for this examination.

<u>Examine</u>	<u>Defects</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 closure of container flaps, loose strapping, improper taping, inadequate stapling.
Content	Bulged or distorted container. Number of intermediate packages per shipping container is more or less than required. Number of coats per intermediate package is more or less than required. <u>1/</u> Size shown on one or more coats not as specified on shipping container. <u>1/</u>

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



## MIL-STD-1392C

Table I - Sampling provisions

	Lot Size	Sample Size	Maximum Acceptance Number for Select Defects (*defect)	Maximum Acceptable Point Values	
				3 & 2 point defects	3,2,&1 point defects
Normal Inspection	Up thru 90	20	0	5	10
	91 thru 150	32	0	5	10
	151 thru 280	50	0	10	20
	281 thru 500	80	0	13	28
	501 thru 120	125	1	21	40
	1201 thru 3200	200	1	27	54
	3201 thru 10,000	315	2	38	82
	10,000 thru 35,000	500	3	54	122
	35,001 and over	800	5	82	183
Tightened Inspection	Up thru 90	20	0	4	7
	91 thru 150	32	0	5	11
	151 thru 280	50	0	7	16
	281 thru 500	80	0	10	21
	501 thru 1200	125	1	16	32
	1201 thru 3200	200	1	20	47
	3201 thru 10,000	315	2	33	70
	10,001 thru 35,000	500	3	49	104
	35,001 and over	800	5	73	156
Reduced Inspection	Up thru 280	20	0	3-6	10
	281 thru 500	32	0	5-11	18
	501 thru 1200	50	0	9-15	22
	1201 thru 3200	80	0	11-19	36
	3201 thru 10,000	125	1	19-27	47
	10,001 thru 35,000	200	1	25-34	70
	35,001 and over	315	2	34-44	104

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 6.3.4b).  
 The second value is the maximum acceptable point value.

6. INSPECTION. Inspection shall be as specified in MIL-STD-105, except where otherwise indicated in this document.

6.1 Initiation of inspection. Normal inspection will be used at the start of inspection unless otherwise directed by the procurement quality assurance element administrating the contract.

6.2 Continuation of inspection. Normal, tightened or reduced inspection shall continue unchanged on successive lots except where switching procedures in 6.3 require change.

6.3 Switching procedures.

## MIL-STD-1392C

6.3.1 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).

6.3.2 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.

6.3.3 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.

(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.

(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 percent of the total maximum acceptable point values for 3, 2 and 1 point defects from the preceding 10 lots.

(d) Production is at a steady rate.

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

6.3.4 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.

(b) A lot is considered acceptable but exceeds the applicable first value (see NOTE to table I).

(c) Production becomes irregular or delayed.

(d) Other conditions warrant that normal inspection be instituted.

## 7. NOTES

7.1 The AATCC Photographic Comparative Rating of Single and Double Needle Seams (Method 88B, two photos) is available from:

The American Association of Textile Chemists and Colorists  
P.O. Box 12215  
Research Triangle Park, NC 22709

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
<u>A. GENERAL DEFECTS</u>	
I. MATERIAL DEFECT AND WORKMANSHIP DAMAGE	
a. Hole, cut, tear, smash, mend, burn, scorched area, or open place:	
1. On outside	3
2. On inside of liner (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 liner	1
c. Permanent fold, pleat, or crease in cloth (when caught in seaming or stitching):	
1. On outside	3
2. 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. Any part shaded (except parts which may be cut ends)	3
2. Variation in shade within a part (except parts which may be cut from ends)	3
3. Part cut from ends badly shaded	1

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
b. On inside or liner:	
1. Any part badly shaded (except sleeve linings)	1
2. Sleeve lining part badly shaded, pairs not matching each other	1
III PRESSING (Overcoat, with or without liner)	
a. Omitted or poorly pressed (unless otherwise classified)	2
b. Excess gloss on edges of seamlines	1
c. Lapel, front or collar edge bulky, or not pressed solid	1
d. Lapels not roll pressed	1
e. Armhole seam not pressed open across top	2
f. Wrinkle, crease or basting thread or ticket impression not removed	1
g. Sleeve not roll pressed or creased	2
h. Armhole stretched	3
i. Collar breakline not creased as specified	1
j. Armhole not blocked or poorly blocked	1
k. Body, liner or lining, front darts or pleats, back pleats, and bellow pleat not pressed smooth and flat	1
l. Inside of armhole not creased or not creased solid	1
m. Pressing impressions under lapels, collar, pocket welts and vent not removed	1
n. One or more seams not pressed open or not turned to the side specified	1
o. Belt not pressed	1
IV CLEANNES	
a. Any spot or stain on outside (visible at 2 feet) (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 size or shade marking exposed or visible on outside	3
c. More than 3 thread ends not trimmed to 1/4 inch or less on outside	2
d. More than 5 thread ends not trimmed to 1/4 inch or less on inside	1
e. Two or more shade, size, or marking tickets not removed	1
f. Basting thread (including monofilament thread or fragments of monofilament thread) not completely removed from outside	1
g. Loose thread ends not removed	1

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
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)	3
d. Any operation not as specified (unless otherwise classified herein)	3
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
VI CUTTING	
a. Any component part not cut in accordance with specified pattern, directional lines on pattern or not in accordance with specification requirements	3
b. Twill line of any outside part not running in specified direction	3
VII SEAM AND STITCHING	
a. Accuracy of seaming:	
1. Seam puckered, pleated or twisted on outside (unless otherwise classified herein)	3
2. Seam irregular or wavy (unless otherwise classified herein)	3
3. Part of overcoat or liner caught in any unrelated operation or stitching	3
4. Excessive fullness between rows of stitching	2
5. Machine felling, hand felling, inside stitching or blindstitching exposed on outside	1
6. End of stitching when not caught in another seam or stitching not finished as specified	2
7. Stitching overlapping end of thread break less than 1/2 inch	2
8. End of a continuous line of stitching overlapped less than 1/2 inch (except labels)	2
9. Not specified color thread used on outside	2
10. Needle perforations visible on outside	2

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
b. Gage of stitching and seam allowance:	
1. Edge, top or raised stitching sewn too close to edge resulting in damage to cloth	3
2. Width of seam allowance not as specified by 1/16 inch or more (score only when condition exists on more than 1/2 the length of the seam)	2
3. Stitching irregular or 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 the seam)	1
c. Open seam (see 3.4):	
1. On outside (excluding lower edge of undercollar):	
(a) -more than 1/2 inch	3
(b) -more than 1/4 inch up to 1/2 inch inclusive	2
(c) -up to 1/4 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 1 inch inclusive	1
(b) -more than 1 inch	2
3. On inside and liner; stitch type 301 and hand felling around armhole:	
(a) -up to 2 inches inclusive	1
(b) -more than 2 inches	2
d. Raw edge (see 3.5):	
1. On outside (excluding permitted raw edges):	
(a) -up to 1/8 inch inclusive	1
(b) -more than 1/8 inch up to 1/2 inch inclusive	2
(c) -more than 1/2 inch	3
2. On inside and liner (excluding raw dge of binding not required to be turned under):	
(a) -3/8 inch up to 1 inch inclusive	1
(b) -more than 1 inch	2

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
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 of 401 stitch type on outside	3
5. Direction of seam not as specified	2
f. Stitch tension:	
1. Loose tension resulting in a loose seam:	
(a) -up to 1/2 inch (12.70 mm) inclusive	1
(b) -more than 1/2 inch up to 3/4 inch inclusive	2
(c) -more than 3/4 inch	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 riase 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 size or type	1
2. Loose stitch tension	1

## MIL-STD-1392C

Table II - Classification of defects

	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; uncut, finished length not as specified or end of gimp not pulled through to underside of cut first square bar buttonhole	2
d. Ragged edge (i.e, yarn or thread ends on inside of buttonhole not trimmed to less than 1/4 inch), incomplete stitching, stitching not securely caught in fabric, bulky appearance or stitches not uniformly spaced	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 specified minimum number by:	
1. One to three stitches	1
2. Four or more stitches	2
i. Purling not finishing on the side specified	1
IX BUTTONS (see 3.5)	
a. Omitted, broken or defective	2
b. Part of garment pleated or puckered by button sewing	1
c. Misplaced, loose, not attached as specified or insecurely sewn	1
d. Tacking stitches omitted or insecure (hand sewn)	1
e. Button sewn with insignia in other than specified direction	1
f. Shank wrapping (when required) omitted, loosely or insecurely wrapped or not specified shank length	2
g. Stitching on button not locked at end of cycle (tug at loose end of the thread when accessible to determine whether it will ravel)	1
X BUTTON LOOP OR TAB	
a. Omitted or insecure:	
1. On vent, lapel or facing	1
2. On liner	2
b. Misplaced or not attached as specified	2
c. Length or width not as specified	1



## MIL-STD-1392C

Table II - Classification of defects

	Point Value
<u>B. DETAILED DEFECTS (OVERCOAT BUTTONED ON FORM)</u>	
XI ALIGNMENT OF BUTTONS (INCLUDING ANCHOR BUTTON), BUTTONHOLES AND BUTTON LOOPS OR BUTTON TABS	
a. Not aligned, causing a bulge or twist when buttoned:	
1. On front or liner	2
2. On tab for sleeve, collar, vent or lapel	1
b. Spacing between front buttonholes varying more than 1/4 inch	1
c. Button on right front not in horizontal alignment with corresponding button on left front by:	
1. More than 1/2 inch but not more than 1 inch inclusive	2
2. More than 1 inch	3
XII COLLAR (construction and setting)	
a. Collar setting:	
1. Short, i.e., causing puckers on back or front along edge of collar 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
3. Collar not properly set, causing a decided 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
5. Collar off center by more than 1/4 inch with shoulder seams matching	2
b. Collar edge:	
1. Collar edge short across shoulders, causing collar to rise above creaseline by:	
(a) -more than 1/4 inch to 1/2 inch inclusive	2
(b) -more than 1/2 inch	3
2. Irregular or wavy	1

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
3. Outer edge of undercollar exposed beyond outer edge of topcollar (score only when the condition exists on more than 1/2 the length of seam)	2
4. Undercollar edge more than 1/8 inch from topcollar edge (score only when the condition exists on more than 1/2 the length of seam)	1
c. Topcollar:	
1. Tight, i.e., causing edges to curl or bulge on undercollar	2
2. Twisted, i.e., having a diagonal twist	3
3. Full, i.e., having puckers or pleats	3
4. Full, i.e., topcollar folds 1/8 inch or more above creased edge or breakline of undercollar	2
5. Seam joining topcollar and topcollar stand exposed beyond edge of breakline	3
6. Puckers or pleats on topcollar at joining to topcollar stand	2
7. Finished collar width at center back not as specified (measure from fold to outer edge of topcollar)	2
d. Topcollar stand:	
1. Stitching of collarstand and topcollar not extending beyond side sections of undercollar	1
2. Tight, puckered or pleated at joining to topcollar	2
e. Undercollar:	
1. Interlining pleated, affecting smoothness of topcollar	3
2. Interlining tight or twisted, causing puckers on undercollar	2
3. Tight at joining to fronts or back causing puckers or pleats at neck	3
4. Center seam from center back seam:	
(a) -1/4 inch or more but not more than 3/8 inch	1
(b) -more than 3/8 inch	2
5. Tacking on corners of undercollar to fronts omitted or insecure	1

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
f. Undercollar stand:	
1. Width not as specified (measure from breakline to bottom edge of undercollar at center)	1
2. Collarstand row of stitching through undercollar and collar interlining omitted	2
3. Tight, puckered or pleated at joining to undercollar	2
4. Tacking of neck outlet and lining to undercollar interlining omitted or insecure	1
g. Gorge seam:	
1. Not straight	2
2. Any portion of seam not spread open	2
3. Back end of seam not back of or is less than 1 inch back of lapel breakline	2
4. Length of seam outside not uniform with other side by 3/8 inch or more (measured from collar breakline to end of gorge seam at notch)	1
5. Tacking or gorge seam omitted or insecure	1
XIII LAPEL AND COLLAR	
a. Lapel facings	
1. Twisted, short or tight, causing lapel to curl out or twist	3
2. Fullness, pleat or puckers	3
3. Fullness (not smooth and flat)	2
b. Lapel edges:	
1. Irregular, wavy, or not properly forced out	2
2. Front part of overcoat exposed on lapel edge	2
3. Tape set on too tight causing puckering at edges	2
c. Bridle tape:	
1. Misplaced, not serving intended purpose	2
2. Loose, causing breakline not to lie flat	2
3. Tight, causing puckers or pleats along breakline	3
d. Lapel and collar shapes (ends, points, and steps):	
1. Twisted, short or tight causing collar or lapel to curl out	*
2. Misshapen or distorted - any point varying from finished shaper by:	

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
(a) -1/4 inch or more but less than 1/2 inch	3
(b) -1/2 inch or more	*
3. Not uniform in size or shape, varying from matching part by:	
(a) -1/4 inch or more but less than 1/2 inch	2
(b) -1/2 inch or more	*
4. Matching parts uniform but varying from finished pattern shaper by:	
(a) -1/4 inch or more but not more than 3/8 inch	1
(b) -more than 3/8 inch	2
5. Gap between top edge of lapels and ends of collar not uniform with other side by 1/4 inch or more	3

## XIV LENGTH OF BUTTONED FRONTS

- |   |   |
|---|---|
| a. Right front shorter than left front at bottom corner by:                         |   |
| 1. More than 1/4 inch to 1/2 inch inclusive   | 1 |
| 2. More than 1/2 inch   | 2 |
| b. Right front bottom corner longer than left front at bottom by more than 1/2 inch | 1 |
| c. Bottom corner of left front exposed below bottom edge of right front by:         |   |
| 1. More than 1/2 inch to 1/2 inch inclusive   | 1 |
| 2. More than 1/2 inch   | 2 |
| d. Fronts uneven at neck when buttoned by more than 1/4 inch                        | 2 |

## XV CONSTRUCTION OF FRONTS

- |  |   |
|--|---|
| a. Fronts not properly shaped or constructed causing right front to swing to the right or left by more than 2 inches when buttoned from an imaginary perpendicular line drawn from forward edge of top bottom to bottom of overcoat. (Measure horizontally at bottom of overcoat from imaginary line to front edge of left front.) | 2 |
| b. Right front rolling outward below bottom front button, when buttoned  | 2 |
| c. Fronts puckered, twisted or not smooth, having a wavy appearance  | 3 |

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
<b>XVI FRONT AND BACK NECK FACINGS</b>	
a. Short, tight, or twisted, causing puckers or twist on fronts or back	3
b. Front facing long causing bottom corner of front to curl up	3
c. Front facing exposed along edge of right front	1
d. Shoulder seam of back neck facing not aligned with overcoat or lining shoulder seam by 3/8 inch or more	1
e. Fullness on facing between buttons and buttonholes or between buttonholes or buttons and front edge	1
f. Felling at back edge of facing to bottom hem omitted or insecure	1
g. Felling on underside of neck facing to lining across back between top ends of stitching on front facings omitted or insecure	2
h. Tacking of seam joining front edge of front lining and lining strip to interlining omitted or insecure	2
<b>XVII TABS (sleeve, collar, lapel, and vent)</b>	
a. End poorly shaped or ends not of uniform shape or size	1
b. Tight, loose or distorted when buttoned	1
c. Sleeve tab not uniformly positioned from bottom edge by more than 3/8 inch	1
d. Irregular in width by 3/16 inch or more	1
e. Sleeve tab joined to underarm seam of sleeve at an angle	2
f. Sleeve tab buttons out of horizontal alignment by more than 1/4 inch	2
g. Finished length or width not as specified	1
h. Misplaced	1
i. Edge not fully forced out	1
j. Construction other than specified	1
k. Omitted or insecurely attached	3
<b>XVIII POCKETS AND WELTS</b>	
a. Poorly shaped or not uniform in shape or size by more than 1/4 inch with corresponding point on matching part	2
b. Irregular in width by 3/16 inch or more	2
c. Notch exposed at end of welt or raw edge at corner	3
d. Out of horizontal alignment by:	
1. More than 1/2 inch to 3/4 inch inclusive	2
2. More than 3/4 inch to 1 inch inclusive	3
3. More than 1 inch	*
e. Finished length or width not as specified	2
f. Front at corner of pocket opening pleated or distorted	2

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
g. Top back edge of welt not equidistant from side seam by more than 3/4 inch	2
h. Welt misplaced, i.e., right welt on left front and left welt on right front	3
i. Back edge of welt short, causing puckers on front or too loose causing welt to gap	2
j. Tape, reinforcement piece or interlining omitted	2
k. Tape stitching exposed and visible on outside	1
l. Front under width of welt at one or both ends puckered or pleated	1
m. Reinforcing or diagonal row of stitching on corners of welt, omitted or insecure	2
n. Pocket seam allowance not stitched or tacked to interlining as specified; tacking omitted or insecure	2
XIX SHOULDER	
a. Construction:	
1. Improperly joined or set causing front or back of shoulder to twist	3
2. Shoulder seam curved towards back at armhole seam in lieu of toward the front:	
(a) -3/16 inch to 3/8 inch inclusive	1
(b) -more than 3/8 inch	2
b. Shoulder pad:	
1. Not properly set causing shoulder or shoulder lining to twist, pucker or bulge	3
2. Misplaced, not serving intended purpose, i.e., too far back or too far forward, not completely or securely caught in armhole tacking	2
3. Neck end of shoulder pad not tacked to shoulder seam allowance as specified	1
c. Shoulder strap or loop (construction and setting):	
1. Poorly shaped or not of uniform shape or size	2
2. Strap will not lie flat, twists or bulges when buttoned or tacked	2
3. Pointed or rounded end not specified distance from undercollar joining seam	2
4. Misplaced so that shoulder seam is exposed	3
5. Set with seam on the underside	3
6. Length or width not as specified	2

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
7. Not uniformly placed, one strap is further forward or back from position of other strap by 1/4 inch or more	2
8. Back edge of strap at neck edge more than specified distance beyond shoulder seam	1
9. Back edge of strap not specified distance from shoulder seam at armhole	1
XX ARMHOLE	
a. Armhole not completely tacked or not tacked as specified	2
b. Stretched causing excessive fullness on back between shoulder and underarm	2
c. Tape around armhole omitted	3
d. Crooked or puckered seam	2
e. Tape stitching exposed and visible on outside (score only when condition exists on more than 1/2 the length of seam)	2
f. End of shoulder loop caught in raise stitching or armhole	2
XXI SLEEVE HEAD WADDING	
a. Not completely or insecurely tacked	2
b. Misplaced, not serving intended purpose	2
XXII SLEEVE	
a. Set improperly, causing sleeve to break or twist	*
b. Fullness misplaced	2
c. Tight at armholes, i.e., roll effect not present on front or back of sleeves or causing fold of undersleeve or on armhole at base of sleeve	3
d. Lower part of top sleeve tight causing front of sleeve not to roll	3
e. Front edge of sleeve either too far front or too far back when measured from a set point on pocket by more than 1-1/2 inches:	
1. MIL-O-16736(NU):	
(a) -front of pocket - from center of welt joining seam	3
(b) -back of pocket - from lower back corner of welt	3
2. MIL-O-21086(MC):	
(a) -front of pocket - from top back corner of welt	3

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
f. Setting of sleeves within above tolerances but hanging in opposite directions, one sleeve too far forward and one sleeve too far back from above set points of measurement of pockets. A tolerance of not more than 1-1/4 inches is allowed for position of each sleeve	2
g. Sleeve backarm seam not equidistant from shoulder seam by 1/2 inch or more	2
h. Underarm seam staggered more than 1/2 inch with side seam at armhole	1
i. Wigan twisted, tight or pleated causing puckering on outside of sleeve, clearly noticeable	2
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. Bottom edge of wigan not extending to bottom edge of sleeve by more than 1/8 inch or blindstitch tacking on bottom turn-up to wigan omitted or insecure	2
XXIII SLEEVE CUFF	
a. Cuff full or twisted	2
b. Point of cuff not uniformly shaped or not forced out to a sharp point	2
c. Pointed end of cuff not seamed and stitched as specified	2
d. Height of cuff points on paired sleeves varying by more than 1/4 inch	2
e. Sleeve or cuff puckered or twisted at joining seam	2
f. Height of cuff at point, at backarm seam or forearm seam within tolerance specified	2
g. Point not centered between the rolled front and back folds of sleeve by 3/8 inch or more	2
h. Top edge of cuff at backarm seam staggered more than 1/8 inch	2
i. Edge of cuff crooked, irregular or not uniform on either side of point	2
j. Cuff turn-up, not specified width	1
k. Tacking at bottom turn-up cuff to sleeve omitted or insecure	2
XXIV 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 or right front poorly shaped	1
e. Bottom edge stretched or uneven	1



## MIL-STD-1392C

Table II - Classification of defects

	Point Value
f. Stitching along bottom edge exposed on outside	1
XXV FITTING	
a. Fitting of body lining, front interlining, and liner tight, short or twisted causing puckers or twist on outside	3
b. Canvas front too full, causing front to have a wavy appearance or not lie smoothly	3
XXVI VENT	
a. Not lapped in direction or within tolerance specified	2
b. Outer vent edge stretched or not properly constructed causing vents to open	2
c. Lining, interlining or tape tight, short or twisted causing puckers on 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 than inner vent by:	
1. 1/4 inch to 1/2 inch inclusive	1
2. More than 1/2 inch	2
h. Outer vent longer than inner vent by more than 1/2 inch	1
XXVII DARTS, PLEATS, AND BELLOWS STRIP OR PLEAT	
a. Omitted	
1. On outside	3
2. On inside or liner	2
b. Uneven in length by more than 1/2 inch	1
c. Not properly tapered causing unsightly bulge	1
d. Bellows pleat twisted	1
e. Bellows pleat not abutted along top edge of hem	2
f. Length, depth, location or construction other than specified	2
g. Bellows strip short causing front to pucker or twist	2
h. Inside fold of dart or outer fold of pleat not facing direction specified	1

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
XXVIII BACKS	
a. Edge of back pleat not continuous with or in a straight line with the seam above the pleat	2
b. Back pleat seam not at edge of inside fold of pleat	1
c. Bottom of inside fold of pleat exposed below bottom of overcoat by more than 1/4 inch	2
d. Bottom of outside fold of pleat longer than lower edge of other back by 1/4 inch or more	1
e. Bottom of outside fold of pleat shorter than lower edge of other back by 1/4 inch or more	2
f. Outside fold of pleat not facing the right side (as worn)	2
XXIX HEMS (sleeve, yoke and bottom)	
a. Irregular in width by more than 1/8 inch	1
b. Twisted, puckered or pleated	2
c. Width not as specified	1
d. Tape on bottom turn-up not specified type, width or color	1
e. Not bound, taped or turned under as specified	2
f. Felling of ends of bottom turn-up omitted or insecure or end of binding not turned under or not caught in felling stitches on one or both vent edges	2
XXX BELT ASSEMBLY	
a. Belt:	
1. Free end or point poorly shaped	2
2. Irregular by more than 1/8 inch or not of uniform width	1
3. Length or width of finished belt not as specified	2
4. Fullness, twist or pleats on upperside	2
5. Edge stretched or full	2
6. Joining seam off center by 1/4 inch or more	1
7. Attached with underseam exposed on opposite side to that specified	2
8. Belt in reversed position, i.e., buckle end of belt on wrong side	1
9. Length of turnback less than specified	1
10. Raw edge not turned under at turnback	1
11. Point off center by 1/4 inch or more	1
12. Joining seam not pressed open	1
13. Other than one piece construction	2
b. Buckle:	
-Buckle omitted, defective or not specified type, size, color or finish	3

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
c. Belt keeper:	
1. Omitted or insecure	2
2. Too short, not permitting belt to lie flat or to function freely or more than 1/4 inch wider than belt	2
3. Finished width not as specified	1
4. Position not as specified	1
d. Belt loops:	
1. Any omitted	3
2. Misplaced, not attached as specified, poorly shaped or set at an angle (more than 3/16 inch off the perpendicular)	2
3. Length or width not as specified	2
4. Raw ends extending more than 1/4 inch from stitching	1
5. Irregular in width by more than 1/8 inch	1
6. Reversed: set with covering stitch or seam on outside	2
7. Out of horizontal alignment by more than 1/2 inch	1
8. Insecure	2
XXXI VENT	
a. Stay piece or tape on inside of left vent omitted	2
b. Finished length or width of vent or vent lining not as specified	1
c. Diagonal row of stitching across top of vent opening omitted, insecure or not as specified	2
d. Top or right vent lining not folded diagonally or not extending above top of right vent as specified	1
e. Stitching on back seam extends more than 1/2 inch below diagonal row of stitching on back	1
f. Distance of folded edge of left vent lining from folded edge of left vent not as specified	1
g. Top edge of silesia stay not caught in stitching across vent extension	1
h. Turn-back of left vent irregular in width by 1/4 inch or more	1
i. Vent overlap 1/4 inch or more or less than specified	1
j. Bottom turn-up exposed on outside of vent	2
XXXII BINDING	
a. Omitted	3
b. Twisted	1
c. Not securely caught, causing binding to pull away from fabric	3
d. Binding short or tight, causing gedge of seam to curl and not lie flat	2

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
e. Stretched causing edge to be wavy in appearance	2
f. End not overlapped as specified	1
g. Not starting or finishing as specified or incomplete	1
h. Not spliced or caught as specified	1
i. Not specified width	1
XXXIII FRONT, BACK, 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. Shoulder seam not lapped as specified	2
d. Sleeve seam out of alignment with sleeve seam at armhole or at bottom of sleeve by more than 3/4 inch	1
e. Diagonal fold on left back lining not extending above top or right vent as specified	1
f. Bottom of front and back yokes staggered 1/2 inch or more at side seam	1
g. Lining too long, extends below bottom edge of sleeve more than 1/2 inch	1
h. Lower edge of front yoke not completely covering top edge of bellows	2
i. Tacking on centerback pleat or shoulder pleat dart omitted or insecure	2
j. Tacking on bottom edge of back yoke to back side seam omitted or insecure	1
k. Lining not stitched to shoulder pad along the straight edge of pad	2
l. Bottom turn-up of sleeve lining not specified distance from lower end of sleeve	1
m. Tackling of sleeve lining seam to sleeve seam omitted or insecure	2
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
XXXV LINER	
a. Fronts uneven in length by more than 3/4 inch	2
b. Size shown on liner not same as overcoat	1
c. Vents uneven in length by more than 3/8 inch	1
d. Lining tight or short causing puckering on wool part	2

## MIL-STD-1392C

Table II - Classification of defects

	Point Value
XXXVI SLIDE FASTENER	
a. Not type, size of finish specified	3
b. Any part of assembly defective	3
c. Overcoat or liner twisted or distorted when slide fastener is engaged	3
d. Stitched too close to metal chain, not permitting slider to pass	3
e. Slide fastener tape stitched on too loosely or tightly causing waviness or puckering	1
f. End of tape not turned under when stitched	2
g. Tape not attached or positioned as specified	2
h. Tapes reversed, slider part of facing when liner is removed from overcoat	2
i. Ends of slide fastener unequal distance from bottom edge of liner by more than 1 inch	2
j. Tape stitched to liner of facings with one row of stitching	2
XXXVII HOOK AND PILE FASTENER	
a. Not type, size or color specified	1
b. Misplaced or reversed in assembly	1
c. Pile tape on overcoat lining and hook tape on liner not aligned, causing bulge or twist when engaged	2
XXXVIII HANGER LOOP	
a. Omitted	1
b. Misplaced, 1/2 inch or more off center with center back	1
c. Finished length, width or spread not as specified	1
d. Not specified type or construction	1
e. Bartack at end of hanger loop not through undercollar	2
f. Insecure	1
XXXIX LABEL	
a. Missing, incorrect or illegible:	
1. Size or combination	3
2. Identification label	1
b. Not attached as specified	1
c. Misplaced or stitching through printing	1

## MIL-STD-1392C

Table III - Selected defects

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LAPEL AND COLLAR SHAPES (ends, points, and steps)

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Twisted, short or tight, causing collar or lapel to curl out.

Misshapen or distorted, any point varying from finished shaper by 1/2 inch or more.

Not uniform in size or shape, varying from matching part by 1/2 inch or more.

POCKET AND WELTS

Out of alignment by more than 1 inch.

SLEEVE

Set properly, causing sleeve to break or twist.

---

Custodians:

Navy - NU  
Army - GL  
Air Force - 11

Preparing activity:

Navy - NU

Project No. 8410-0550

Review activities:

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

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3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
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b. ADDRESS (Street, City, State, ZIP Code)			
5. PROBLEM AREAS			
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7a. NAME OF SUBMITTER (Last, First, MI) - Optional		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
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