

INCH-POUND

MIL-STD-1488C

30 March 1990

SUPERSEDING

MIL-STD-1488F

31 July 1987

MILITARY STANDARD
PROVISIONS FOR EVALUATING QUALITY
OF
TROUSERS



AMSC N/A

FSC 8405

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FOREWARD

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: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5014 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

3. This standard provides a standardized procedure for evaluating quality of dress (D), semi-dress (SD) and utility (U) trousers procured for the Department of Defense.

The objectives of this standard are to.

- a. Provide standard descriptions for trouser defects.
- b. Standardize examination requirements

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

<u>DOCUMENT</u>	<u>CLASSIFICATION</u>	<u>TITLE</u>
MIL-T-1870	U	Trousers, Cold Weather; Field, Wool, M-1951
MIL-T-2423	D	Trousers, Men's (White)
MIL V-17658	D	Uniform, Man's (Dress white)
MIL-T-21704	U	Trousers, Cold Weather, Permeable
MIL-T-21705	U	Trousers, Extreme Cold Weather, Impermeable
MIL-T-28902	D	Trousers, Men's: Musicians
MIL-T-28919	D	Trousers, Men's: Service, Summer and Winter (Officer's)
MIL-T-28920	D	Trousers, Men's: Dress (Officer's)
MIL-T-29369	D	Trousers, Men's: Wool and Polyester/Wool
MIL-T-29452	D	Trousers, Man's. Polyester/Wool
MIL-T-41828	D	Trousers, Men's, Wool and Polyester/Wool
MIL-T-41834	SD	Trousers, Men's, Polyester and Cotton
MIL-T-43497	U	Trousers, Cold Weather, Field, Nylon and Cotton
MIL-T-43654	U	Trousers, Snow Camouflage, White, Arctic
MIL-T-43853	D	Trousers, Men's, Army Tan 445, Durable Press
MIL-T-43932	U	Trousers, Utility, (Durable Press)
MIL-T-43957	D	Trousers, Men's, Dress. Wool and Polyester/Wool
MIL-T-44047	U	Trousers, Camouflage Pattern; Combat
MIL-T-44094	U	Trousers, Night Camouflage, Desert
MIL-T-44372	U	Trousers, Aircrew, Camouflage Pattern; Combat

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<u>DOCUMENT</u>	<u>CLASSIFICATION</u>	<u>TITLE</u>
MIL-T-82161	D	Trousers, Men's: Evening Dress (Officer's)
MIL-T-82163	D-SD	Trousers, Men's: Dress, White; and Special Mess, Black
MIL-T-82199	D	Trousers, Men's: Mess, Black (Officer's)
MIL-T-87038	D	Trousers, Men's (Blue, Enlisted)
MIL-T-87039	L	Trousers, Men's (Undress)
MIL-T-87047	D	Trousers, Men's Polyester/Wool Serge (CG)
MIL-T-87062	U	Trousers, Utility, Men s. Denim
MIL-T-87067	D	Trousers, Men's (Enlisted, White)

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1 SCOPE

1.1 Purpose. The purpose of this standard is to provide standardized provisions for evaluating the quality of dress, semi-dress, and utility trousers.

1.2 Application. This standard will be made applicable to contracts by reference in the appropriate trouser documents. The dress trouser documents require: (a) as a final step in the contractor's production control plan before formulation of a lot, each of the dress trousers shall be examined after pressing and prior to folding for packaging and (b) any of the trousers containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in table IV which are identified by an asterisk (*) in the "Point value" column. The selected defects are listed individually in table V.

2. REFERENCE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 7.1).

STANDARDS

FEDERAL

FED-STD-4 - Glossary of Fabric Imperfections
 FED-STD-751 - Stitches, Seams, And Stitchings

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
 MIL-STD-109 - Quality Assurance Terms and Definitions
 MIL-STD-1491 - Glossary of Knitting Imperfections

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

2.2 Non-Government publications. The following document forms a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation. (see 7.1)

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AMERICAN ASSOCIATION OF TEXTILE CHEMISTS AND COLORISTS (AATCC)

AATCC 88B (Two Photos) - Photographic Comparative Rating of Single and Double Needle Seams

(Applications for copies of Method 88B should be addressed to the American Association of Textile Chemists and Colorists, P.O. Box 12215, Research Triangle Park, NC 22709-2215.)

(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 document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3 DEFINITIONS

3.1 Fabric defects. Definitions of fabric defects, where applicable, shall be in accordance with FED-STD-4 and MIL-STD-1491. 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 document and are clearly visible when examined at a distance of 3 feet shall be scored as defects in evaluating quality of the trousers.

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

3.4 Open seam. Definitions of stitches, seams, and stitchings shall be in accordance with FED-STD-751. A seam shall be classified as open when one or more stitches joining the seam are broken or runoff, or when two or more continuous skipped stitches occur. Double stitched seams are considered open when one or both rows of the stitching are open.

3.5 Raw edge. Raw edge is defined as any edge not finished as specified including any protruding raw edge on the outside of the trouser.

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

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

Outside: Any part of the trousers that is visible when the completely buttoned and closed trousers are examined.

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Inside: Any part of the trousers that is not visible when the completely buttoned and closed trousers are examined.

3.8 Puckering. In the course of the sampling examination, seams and stitchings suspected of being puckered shall be examined at a distance of 3 feet in comparison with the AATCC photographic comparative rating (see 2.2) for seams. Puckering on a major portion of the suspected seam that equals or is worse than rating 3 for single or multiple 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 dress, semi-dress, and utility trousers. If there are any inconsistencies between the requirement of the appropriate trouser document and the provisions of this standard, the trouser document shall control. This standard assigns to the listed defects, point values of 1, 2, or 3 depending on severity. The higher point values are assigned to those defects having the more detrimental effect on the appearance or serviceability of the item. The defects identified by an asterisk (*) in the "Point value" column of table IV are those defects having the most detrimental effect on the appearance or serviceability of the item.

5. SAMPLE AND INSPECTION PROVISIONS

5.1 End item examination. The inside and outside of the trousers shall be examined and all defects shall be penalized as indicated in table IV. "D" signifies dress trousers. "SD" signifies semi-dress trousers. "U" signifies utility trousers. The sample size shall be based on lot size, and the acceptable point values for selected defects, 3 and 2 point defects, and total (3, 2 and 1 point) defects shall be as specified in table I, II, or III as applicable. The sample unit shall be one of the finished trousers. 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 (see 1.2) exceeds the maximum allowed for the sample size (see table I).

5.2 Dimensional examination. The appropriate number of trousers, determined from the table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate trouser document. When a measurement deviates from a dimension and tolerance specified, the

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trousers shall be penalized one point. Each sample unit shall also be penalized one point when the inseams are uneven in length by 1/2 inch or more. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value. Each size of the trousers present in the lot should be represented in the sample selected for this examination.

Sampling provisions for dimensional 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

5.3 Packaging examination. An examination shall be made to determine that preservation, packing, and marking requirements are in compliance with section 5 of the appropriate trouser document. Defects listed below shall be scored one point. The sample size for this examination shall be five shipping containers fully packaged 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>Defect</u>
Marking (exterior and interior)	Omitted; incorrect, illegible; of improper size, location, sequence, or method of application.
Materials	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, improper adhesive application, or inadequate stapling. Open and non-continuous heat sealed seams and closure of polyethylene bag. <u>1/</u> Alternative closure of polyethylene bag not provided with tuck or reverse flap. <u>1/</u> Omission of vent hole in polyethylene bag. <u>1/</u> Incorrectly fabricated bag. <u>1/</u> Bulged or distorted container.
Content	Number of bundles or intermediate packages per container is more or less than required. Number of trousers per bundle or intermediate package is more or less than required. <u>2/</u> Packaged inside out. Size shown on one or more trousers not as specified on outside of shipping container. <u>2/</u>
Preservative application (naphthalene flakes)	Improperly applied or missing. <u>1/</u>

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- 1/ When applicable.
- 2/ For this defect, one bundle or intermediate package from each container in the sample shall be examined.

6. INSPECTION

6.1 Inspection procedures. Inspection procedures, except for sampling plans, shall be as specified in MIL-STD-105, except where otherwise indicated in this document.

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

6.3 Continuation of inspection. Normal, tightened, or reduced inspection shall continue unchanged on successive lots except where switching procedures in 6.4 require a change.

6.4 Switching procedures.

6.4.1 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).

6.4.2 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.

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

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

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

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

d. Production is at a steady rate; and

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

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

- a. A lot is rejected; or
- b. A lot is considered acceptable but exceeds the applicable first value (see 1/ to tables I, II and III); or
- c. Production becomes irregular or delayed; or
- d. Other conditions warrant that normal inspection be instituted.

7. NOTES

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

7.1 Issue of DODISS. When this standard is used in aquisition, the applicable issue of the DODISS must be cited in the solicitation (see 2.1.1 and 2.2).

7.2 Subject term (key word) listing.

Clothing inspection

Dress

PFEQ

Semi-dress

Uniform

Utility

7.3 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes

TABLE I. Sampling provisions for visual examination of dress (D) trousers

	Lot size	Sample size	Maximum acceptance number for selected defects (see 1.2)	Maximum acceptable point values	
				3 & 2 point defects	3, 2 & 1 point defects
Normal inspection	Up thru 90	20	0	5 points	9 points
	91 thru 150	32	0	7 points	13 points
	151 thru 280	50	0	11 points	19 points
	281 thru 500	80	0	14 points	26 points
	501 thru 1200	125	1	21 points	37 points
	1201 thru 3200	200	1	27 points	49 points
	3201 thru 10,000	315	2	36 points	72 points
	10,001 thru 35,000	500	3	53 points	108 points
35,001 and over	800	5	83 points	165 points	

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TABLE I Sampling provisions for visual examination of dress (D) trousers (cont'd)

	Lot size	Sample size	Maximum acceptance number for selected defects (see 1.2)	Maximum acceptable point values	
				3 & 2 point defects	3, 2 & 1 point defects
Tightened inspection	Up thru 150	32	0	3 points	7 points
	151 thru 280	50	0	5 points	11 points
	281 thru 500	80	0	8 points	17 points
	501 thru 1200	125	1	13 points	26 points
	1201 thru 3200	200	1	20 points	39 points
	3201 thru 10,000	315	2	30 points	59 points
	10,001 thru 35,000	500	3	45 points	89 points
	35,001 and over	800	5	67 points	133 points

	Lot size	Sample size	Maximum acceptance number for selected defects (see 1.2)	Maximum acceptable point values	
				3 & 2 point ^{1/} defects	3, 2 & 1 point defects
Reduced inspection	Up thru 280	20	0	3-9 points	16 points
	281 thru 500	32	0	5-13 points	22 points
	501 thru 1200	50	0	8-15 points	27 points
	1201 thru 3200	80	0	12-20 points	36 points
	3201 thru 10,000	125	1	18-25 points	42 points
	10,001 thru 35,000	200	1	25-32 points	50 points
	35,001 and over	315	2	35-43 points	71 points

^{1/} If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 6.4.4b). The second value is the maximum acceptable point value.

TABLE II. Sampling provisions for visual examination of semi-dress (SD) trousers

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

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

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

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

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 6.4.4b). The second value is the maximum acceptable point value.

TABLE III. Sampling provisions for visual examination of utility (U) trousers

	Lot size	Sample size	Maximum acceptable point values	
			3 & 2 point defects	3, 2 & 1 point defects
Normal inspection	Up thru 500	50	13 points	25 points
	501 thru 1200	80	19 points	31 points
	1201 thru 3200	125	27 points	43 points
	3201 thru 10,000	200	38 points	63 points
	10,000 and over	315	58 points	93 points

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TABLE III. Sampling provisions for visual examination of utility (U) trousers (cont'd)

	Lot size	Sample size	Maximum acceptable point values	
			3 & 2 point defects	3, 2 & 1 point defects
Tightened inspection	Up thru 500	50	7 points	16 points
	501 thru 1200	80	12 points	25 points
	1201 thru 3200	125	18 points	37 points
	3201 thru 10,000	200	28 points	57 points
	10,001 and over	315	41 points	85 points
	Lot size	Sample size	3 & 2 point <u>1/</u> defects	3, 2 & 1 point defects
Reduced inspection	Up thru 1200	32	7-14 points	24 points
	1201 thru 3200	50	12-18 points	30 points
	3201 thru 10,000	80	16-21 points	38 points
	10,001 and over	125	23-28 points	43 points

1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 6.4.4b). The second value is the maximum acceptable point value.

TABLE IV. Trousers visual defects

Defect	Point value		
	D	SD	U

I. MATERIAL DEFECT AND DAMAGE

- a. Any hole, cut, tear, smash, burn, drill hole 1/, scorched area, multiple float, or open place:
1. On outside (see 3.7) (longest dimension in any direction):
 - (a) - up to 1/4 inch inclusive 3 2 2
 - (b) - more than 1/4 inch 3 3 3
 2. On inside (see 3.7) (longest dimension in any direction):
 - (a) - up to 1/4 inch inclusive 1 1 1
 - (b) - more than 1/4 inch 2 2 2

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
I. MATERIAL DEFECT AND DAMAGE (cont'd)			
b. Knot or slub (see 3.2) on outside <u>2/</u> :			
1. In Zone I	2	1	1
2. In Zone II	1	1	1
3. In Zone III	1	-	-
c. No dye penetration, all zones (except MIL-T-44047 and MIL-T-43497)	3	3	3
d. No printed dye penetration (applicable to MIL-T-44047 and MIL-T-43497 only):			
1. Up to 1/4 inch inclusive	-	-	1
2. More than 1/4 inch to 1/2 inch inclusive	-	-	2
3. More than 1/2 inch	-	-	3
e. Misweave, area of poor dye penetration, dyestreak, broken and missing section of varn. visible mend, thin place or shade bar (longest dimension in any direction) <u>2/</u> :			
1. In Zone I:			
(a) - 1/4 to 1/2 inch inclusive	2	1	1
(b) - more than 1/2 inch	3	2	2
2. In Zone II <u>2/</u> :			
(a) - more than 1/4 inch up to 1 inch inclusive	2	1	1
(b) - more than 1 inch	3	2	1
3. In Zone III <u>2/</u> :			
(a) - more than 3/4 inch	1	1	1
f. Loose yarn or coarse yarn on outside <u>2/</u> :			
1. In Zone I:			
- more than 1 inch	2	1	1
2. In Zone II:			
- more than 2 inches	1	1	1
3. In Zone III:			
- more than 3 inches	1	1	1
g. Woven in waste on outside (largest dimension in any direction) <u>2/</u> :			
1. In Zone I:			
(a) - up to 1/2 inch inclusive	2	1	1
(b) - more than 1/2 inch	3	2	1
2. In Zone II:			
(a) - more than 1/4 inch up to 1 inch inclusive	2	1	1
(b) - more than 1 inch	3	2	1
h. Fleece lining (applicable to MIL-T-21704 and MIL-T-21705 only)			
1. Any bare (bald) spot	-	-	3
2. Slubby yarn, dropped stitch, or other knitting deviation causing a cut, tear, run, hole or other surface blemish	-	-	2
3. Loose or tight knit causing sleaziness, kinks, creases, washboards, or otherwise affecting stability of the material	-	-	3

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
I. <u>MATERIAL DEFECT AND DAMAGE</u> (cont'd)			
1. Needle chew on outside (largest dimension in any direction):			
1. In Zones I and II:			
(a) - up to 1/2 inch inclusive	2	2	2
(b) - more than 1/2 inch	3	3	3
2. In Zone III, more than 1/4 inch	1	1	1
II. <u>SHADED PART</u>			
a. On outside:			
1. Variation in shade within a part or between parts (except part which may be cut from ends)	3	2	2
2. Part cut from ends badly shaded	1	1	-
3. Belt loops that are required to be cut from same piece of material, shaded	2	2	-
NOTE: For MIL-T-44047 and MIL-T-43497 only, parts suspected of being shaded shall be examined at a distance of 3 feet against a background of the other parts and colors of the garment. When the shade difference is readily discernable under these examination conditions, it shall be scored as a shaded part.			
III. <u>PRESSING</u>			
a. Omitted or poorly pressed, or exhibiting a double crease line:			
1. On permanent crease or durable press	3	3	3
2. On other than permanent crease or durable press	2	1	1
b. Legs not pressed seam on seam at bottom at knee by more than 3/4 inch:			
1. On permanent creased or durable press	3	3	3
2. On other than permanent creased or durable press	1	1	1
c. Permanent crease line not ending within specified limits			
	2	2	2
d. Seam not pressed open, to be scored only when condition exists on:			
1. More than 5 inches, and up to 1/2 the total length of the seam	1	1	-
2. More than 1/2 the total length of the seam	2	2	-
e. Bulge or distortion on or near inseam or outseam for a distance of more than 2 inches on outside			
	1	1	-

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
III. <u>PRESSING</u> (cont'd)			
f. Permanent crease (other than a specified crease)			
1. Occurring anywhere on the outside of trouser, except within 1 inch of the inseam	3	3	3
2. Occurring within 1 inch of the inseam:			
(a) - less than 1/2 inch in length in any direction	1	1	1
(b) - more than 1/2 inch in length in any direction	2	2	2
g. Burned or scorched.	3	2	2
h. Gloss or impressions not removed	2	-	-
IV <u>CLEANNESS</u>			
a. Any spot or stain on outside visible at least 3 feet (smallest dimension in any direction) 2/:			
1. In Zones I or II			
(a) - 1/4 to 3/8 inch inclusive 3/	1	1	1
(b) - 3/8 to 3/4 inch inclusive	2	1	1
(c) - more than 3/4 inch	2	2	1
2. In Zone III 3/:			
- more than 1/2 inch	1	1	1
b. Thread ends			
1. All trousers except MIL-T-44047:			
(a) Three or more not trimmed to 1/4 inch or less on outside	2	1	1
(b) Five or more not trimmed to 1/2 inch or less on inside	2	1	1
2. MIL-T-44047 trousers only:			
Five or more thread ends not trimmed to 1/2 inch or less on outside or nine or more threads ends not trimmed to 1/2 inch or less on the inside.	-	-	1
c. Thread end caught for a distance of more than 1/4 inch in line of stitching on outside	1	1	1
d. Two or more shade or size tickets not removed	1	1	1
e. Any size or shade marking or residue on outside, score as spot or stain (see IVa)			
f. Durable press trouser contains residual fiber particles, lint, dust, or other foreign substance	1	1	1
g. Ten or more loose threads of 1 inch or more not removed throughout (inside and outside)	2	1	1
h. Stay or holding stitching not removed, if visible on the outside	-	-	1
i. Resewn or restitched seams not cleaned	2	2	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
V. <u>COMPONENT AND ASSEMBLY</u>			
a. Any component part or operation omitted (unless otherwise classified herein)	3	3	3
b. Any component not as specified	3	3	3
c. Any component part tight, twisted, distorted, pleated or full to the degree that serviceability or appearance is affected (unless otherwise classified herein)	2	2	2
d. Any operation not as specified (unless otherwise classified herein)	2	1	1
e. The edge of any component part required to be forced out having folds of more than 1/8 inch (unless otherwise classified herein)	2	2	1
VI <u>CUTTING</u>			
a. Any component part not cut in accordance with specified pattern or directional lines on patterns, or not in accordance with document requirements	3	3	3
b. Twill line of any outside part not running in specified direction	3	3	3
VII. <u>SEAMS AND STITCHING</u>			
a. Accuracy of seaming:			
1. Seam irregular, twisted, pleated, or wavy	3	2	1
NOTE: For MIL-T-44047 and MIL-T-43497; pleats shall be scored when they exceed 1/4 inch in length and 1/16 inch in depth of fold.			
2. Seam puckered (score only when on major portion of seam) (see 3.8)	1	1	1
3. Any part of trouser caught in an unrelated operation or stitching (unless otherwise specified herein)	3	2	2
4. End of stitching when not caught in other seams or stitching not backstitched as specified (except stitching for attaching labels and automatic stitching)	2	1	1
5. Thread break secured by stitching back of the break less than 1/2 inch	2	1	1
6. Ends of a continuous line of stitching overlapped less than 1/2 inch	2	1	1
7. Not specified color thread used on outside	3	2	1
8. Not specified color thread used on inside	1	1	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
VII. SEAMS AND STITCHING (cont'd)			
9. Stitching for attaching labels or automatic stitching not finished as specified	1	1	1
b. Gage of stitching and seam allowance:			
1. Edge of seam irregular (score only on major portion of seam)	1	-	1
2. Edge or raised stitching sewn too close to edge, resulting in damage to cloth	3	3	2
3. Seam allowance not as specified or varies more than 1/8 inch (score only when on more than 1/2 the length of the seam)	2	2	2
4. Seam allowance not as specified or varies more than 1/8 inch for the total length of the seam	3	3	2
c. Open seam (see 3.4)			
1. On all seams except leg bottoms and label stitching:			
(a) - up to 1/2 inch (inclusive)	1	1	1
(b) - more than 1/2 inch up to 3/4 inch (inclusive)	2	2	2
(c) - more than 3/4 inch	3	3	3
2. Leg bottoms more than 3/8 inch	1	1	1
3. Label stitching	1	1	1
d. Runoff:			
1. On joining seam, score as open seam			
2. Edge or raise stitching			
(a) - 1/4 to 1/2 inch inclusive	1	1	1
(b) - more than 1/2 inch	2	2	2
e. Raw edge <u>4/</u> (see 3.5)			
1. On outside:			
(a) - up to 1/2 inch inclusive	1	1	1
(b) - more than 1/2 inch up to 3/4 inch inclusive	2	2	1
(c) - more than 3/4 inch	3	3	2
2. On inside:			
- 1 inch or more	2	1	1
3. On inside or outside of trousers caused by excessive seam allowance protruding from a double lapped, double stitched seam	-	-	1
f. Seams and stitch type:			
1. Not specified seam or stitch type	2	2	2
2. Looper thread of 401 or 406 stitch type on outside	3	3	3
3. Any line of stitching omitted	3	3	3
4. Any line of stitching not beginning or ending where specified (unless otherwise classified herein)	1	1	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
VII. <u>SEAMS AND STITCHING</u> (cont'd)			
g. Broken, missing, or skipped stitches on edge or raised stitching (when seam is seamed, turned, and stitched)			
1. 1/4 to 1/2 inch inclusive	1	1	1
2. More than 1/2 inch	2	1	1
n. Stitch tension:			
1. Loose tension resulting in a loose seam:			
(a) - up to 1/2 inch inclusive	1	1	1
(b) - more than 1/2 inch up to 3/4 inch inclusive	2	2	2
(c) - more than 3/4 inch	3	3	3
2. Loose tension on raised or edge stitching resulting in exposed loose thread	1	1	1
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching):			
(a) <u>Seat seam:</u>			
(1) - anywhere on either or both rows of stitching	3	3	3
(2) - seam not completely resewn (when applicable)	3	3	3
(3) - Seam repaired using a 301 stitch	3	3	3
(b) <u>All other seams</u>	3	3	3
1. Stitches per inch (to be scored only when the condition exists on the major portion of seam or stitching):			
1. One less than minimum	1	1	1
2. Two or more less than minimum	2	2	2
3. Two more than maximum	1	1	1
4. Three or more than maximum	2	2	2
j. Stay or holding stitches not removed and visible on outside (except for size label holding stitches)	1	1	1
VIII. <u>BUTTONHOLE</u>			
a. Omitted, added, not specified type, or not finished as specified	3	3	2
b. Misplaced resulting in bulge or twist when buttoned	3	3	2
c. Gimp omitted, uncut buttonhole, end of gimp not pulled through to underside, incomplete stitching, or stitching not securely caught in fabric	2	1	1
d. Ragged edge, broken stitch, or two or more skipped stitches:			
1. On outside	2	2	1
2. On inside	1	1	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	L
VIII. <u>BUTTONHOLE</u> (cont'd)			
e. Buttonhole stitching extending beyond bartack or stitches per buttonhole not as specified:			
1. On outside	2	2	1
2. On inside	1	1	1
f. Finished cut length not as specified	1	1	1
g. Purling not on side specified	1	1	1
IX. <u>BUTTON</u>			
a. Missing, broken, defective (see 3.6), misplaced, not as specified, or insecurely sewn	1	1	1
b. Any part of trousers pleated or puckered by button attachment	1	1	1
c. Stitching not locked at end of cycle (tug at loose end of thread, when accessible, to determine whether it will ravel)	1	1	1
d. Shank wrapping omitted or not trimmed to less than 1/4 inch when hand sewn or 205 stitch type is used	1	1	1
X. <u>SNAP FASTENER</u>			
Broken, bent, cracked, improperly clinched, or failing to effect a secure closure or to open freely	-	-	3
XI. <u>HOOK AND EYE</u>			
a. Hook or eye damaged affecting function, or not securely attached	3	3	3
b. Hook or eye not positioned as specified causing bulge, twist, distortion, or pucker on outside	3	3	2
XII. <u>BARTACK OR TACK</u>			
a. Missing, insecure, misplaced, not serving intended purpose, or not specified length or type:			
1. Bartack for attachment	2	2	2
2. Bartack for reinforcement	1	1	2
b. Loose stitch tension	1	1	1
c. Width of two or more bartacks more than 1/32 inch wider than specified	1	-	-

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XIII. <u>WAIST ADJUSTMENT STRAP ON TAB</u>			
a. Improperly threaded; i.e., causing buckle to finish on reverse side or to function improperly	-	2	2
b. Not positioned as specified	-	1	1
c. End of strap or tab not finished as specified	-	1	1
d. Buckle defective, affecting function	-	2	2
e. Not attached as specified	-	1	1
XIV. <u>SLIDE FASTENER THONG</u>			
a. Length of thong not as specified	-	1	1
b. End of thong not finished as specified	-	1	1
XV. <u>HOOK AND LOOP TAPE</u>			
a. Misplaced or defective, i.e., not serving intended purpose	-	1	1
b. Length snorter than specified	-	1	1
XVI. <u>DRAWCORD</u>			
a. Not attached or inserted as specified	-	1	1
b. Finished length of drawcord not as specified	-	1	1
c. End of drawcord not finished as specified	-	1	1
d. Eyelet misplaced or not positioned as specified	-	1	1
XVII. <u>BINDING</u> (applicable to MIL-T-21704, MIL-T-21705, and MIL-T-87038 only)			
a. Not securely caught in fabric causing binding to pull easily away from fabric	-	-	3
b. Binding tight causing puckering or pleating	-	-	1
c. More than two splices	-	-	1
d. Badly twisted	2	-	2
e. Width of finished binding not as specified	1	-	1
f. More than one shade of material in joined bias strips	-	-	1
g. Other than bias cut	-	-	1
h. Bind of raw edges omitted	3	-	3
XVIII. <u>BUCKLE</u> (applicable to MIL-T-21704 and MIL-T-21705 only)			
a. Any omitted, or having broken, rough, or sharp edge	-	-	3
b. Coating omitted or not as specified	-	-	3

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XIX. <u>SUSPENDER LOOP</u>			
a. Misplaced by more than 1/4 inch	-	1	1
b. Not attached as specified	-	1	1
XX <u>LEG TIE TAPE</u>			
a. Length not as specified	-	1	1
b. Ends not finished as specified	-	1	1
c. Not attached as specified	-	1	1
XXI. <u>WAISTBAND</u>			
a. Width of finished waistband or waistband lining not as specified	1	1	1
b. Lining exposed on outside:			
1. Up to 1 inclusive	1	1	1
2. More than 1 inch	2	2	1
c. Waistband joining seam staggered at seat seam (center back) by:			
1. 1/4 inch up to and including 3/8 inch	1	1	1
2. More than 3/8 inch	2	2	2
d. Waistband stitching varying more than 1/8 inch	1	1	-
e. Outlet not securely stitched to back of trousers along bottom rows of stitching of waistband joining seam	1	1	1
f. Non-slip tape:			
1. Not specified type	2	2	-
2. Not part of waistband (when stated)	1	1	-
g. Waistband not uniformly stitched to top of trousers causing waviness of waistband or top of trousers	2	1	1
XXII. <u>BELT LOOP</u>			
a. Omitted or covering stitch on outside	2	2	2
b. Set at an angle (more than 3/16 inch off perpendicular), insecure, not attached as specified, length too short constricting waistband, width not as specified, or poorly shaped	1	1	1
c. Misplaced by more than 1/4 inch, length too long causing gap of material to extend more than 1/8 inch above waistband, or finished length more than specified	1	1	1
d. Finished length shorter than specified	1	1	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXII. <u>BELT LOOP</u> (cont'd)			
e. Tacking or bartacking visible on outside (where applicable) (not applicable to Marine Corps dress trousers)	1	-	-
f. Turnunder of loop not trimmed as specified or not trimmed to 1/2 inch when no requirement is specified	1	1	1
g. Bottom end of one or more loops (except center-back loop) not securely caught in waist seam (Army and Marine Corps trousers only)	2	-	-
h. Center back loop not on seat seam	2	2	-
i. Center back loop adjacent to seat seam (on right or left), more than 1/4 inch from seat seam	-	-	1
j. Bottom bartack less than 1/4 inch or more than 1/2 inch below waistband seam	1	1	-
k. Tacking not extending full width of loop by 1/8 inch or more	1	1	-
XXIII. <u>BACK RISER</u> (applicable to MIL-T-21704 and MIL-T-21705 only)			
a. Rows not equidistant or not extending to back darts	-	-	1
b. Other than five parallel rows of stitching between darts	-	-	1
c. Interlining omitted	-	-	3
XXIV. <u>BACK DARTS</u> (applicable to MIL-T-21704 and MIL-T-21705 only)			
a. One or both not properly tapered causing bulge, twist, or fullness	-	-	2
b. Other than cut out type	-	-	1
c. Left dart not extending into flap	-	-	1
d. Fold of raised seam turned towards outseam	-	-	1
XXV. <u>LEG ADJUSTMENT STRAPS</u> (applicable to MIL-T-21704 and MIL-T-21705 only)			
a. One or both straps incorrectly threaded through buckle	-	-	3
b. One or both straps omitted, or improperly positioned or secured	-	-	3
c. Short, not permitting garment to be smooth when strap is extended full length	-	-	1
d. Lower edge of webbing less than 2 or more than 2-1/4 inches from the turned under edge of binding	-	-	1
e. Folded edge of webbing on front section less than 4-1/8 or more than 4-5/8 inches from center of outseam	-	-	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXV. <u>LEG ADJUSTMENT STRAPS</u> (applicable to MIL-T-21704 and MIL-T-21705 only) (cont'd)			
f. Folded edge of webbing on back section less than 4-3/8 or more than 4-7/8 inches from center of outseam	-	-	1
g. Out of horizontal alignment by more than 1/4 inch	-	-	1
h. Reversed assembly, i.e., pull or adjustment strap not towards back when worn	-	-	2
i. Finished hem or turn under not in accordance with dimensions and tolerances specified	-	-	1
XXVI. <u>FRONT OPENING</u>			
a. Length of fly uneven at top (examination to be performed with slide fastener closed and hook and eye or button unfastened)			
1. By more than 1/2 inch	-	3	2
2. By 1/4 inch up to 1/2 inch (inclusive)	3	2	1
b. Fly facing exposed beyond front edge, seam joining right fly to front exposed when fly is closed, or left facing set more than 1/4 inch inward from front edge	3	2	1
c. Stitching on left fly, irregular or not positioned as specified or not terminating where specified	2	2	1
d. Raw edge or right fly extension not turned under, or the turned edge not stitched to edge of crotch seam allowance	1	-	-
e. Fly tab not positioned as specified	1	-	-
f. Tack or bartack securing buttonhole fly exposed on outside surface of left front edge	2	2	2
g. Buttonhole in fly tab not positioned as specified	1	-	-
h. Button not positioned as specified causing distortion on front when buttoned	2	-	-
XXVII. <u>FLY EXTENSION ON RIGHT SIDE</u> (applicable to MIL-T-21704 and MIL-T-21705 only)			
a. Bottom edge not caught in fleece crotch seam	-	-	3
b. Tacking of bottom edge to fleece left front:			
- omitted or insecure	-	-	2
- less than 1-1/2 inches from fleece crotch seam	-	-	1
XXVIII. <u>KNEE STAY</u> (applicable to MIL-T-21704 and MIL-T-21705 only)			
a. Misplaced, i.e., not serving intended purpose	-	-	2
b. Omitted or not securely caught in either outseam or inseam	-	-	3

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXIX. <u>SLIDE FASTENER</u>			
Operate slider on chain twice, opening and closing the complete length of chain and locking slider each time			
a. Slide pull becomes detached or slider disengages from either row of scoops	3	3	3
b. Chain becomes unmeshed or does not mesh properly	3	3	3
c. Any required component missing or not properly assembled	3	3	3
d. Slider lock does not retain slider when pull is in down position on non-automatic lock, or when pull is released on automatic lock, when the open chain above the slider is lightly pulled apart	2	2	2
e. Slider binds, catches, or sticks at any point or does not function properly	2	2	2
f. Fastener is not type or style specified	1	1	1
g. Chain (scoops) installed upside down	1	1	1
h. Cut, tear, or hole in slide fastener tape	3	3	3
i. Stitching too close to metal edge not permitting slider to pass freely	3	3	3
j. Tape set too loose or too tight causing bulge, twist or fullness in closed fly on top end of tape; tape not caught as specified; or staple not securely clinched at bottom of chain, or slide fastener chain misplaced (set too high or low) or tape not attached as specified	2	2	2
k. Edge of chain not positioned within specified range at top or bottom from finished edge of left fly or end of metal scoops uneven at top by more than 3/16 inch	1	1	1
l. Slide fastener stop too high by 1/2 inch or more	2	2	2
XXX. <u>POCKET OR FLAP</u>			
a. Any one pocket or flap (excluding cargo pocket) out of alignment by (at any point when measured from the waistband seam):			
1. More than 1/2 inch	*	3	2
2. More than 3/8 inch up to 1/2 inch inclusive	3	2	-
3. More than 1/4 inch up to 3/8 inch inclusive	2	1	-
b. Pocket or flap set on higher or lower than companion pocket or flap by (when measured from the waistband seam):			
1. More than 1/2 inch	*	3	2
2. More than 3/8 inch up to 1/2 inch inclusive	3	2	-
3. More than 1/4 inch up to 3/8 inch inclusive	2	1	-

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXX1. <u>POCKET</u>			
a. General (all):			
1. Notch exposed at pocket opening	3	3	3
2. Top of pocketing not securely inserted under waistband	2	2	2
3. Top of pocketing not evenly inserted under waistband causing bulge or distortion on outside	2	2	2
4. Length of pocket opening not as specified	2	2	1
5. Pocket opening gapped by 1/4 inch or more	1	1	1
6. Depth of pocket not as specified	1	1	1
7. Pocketing caught in unrelated stitching	2	2	2
8. Raw edge or unfinished seam on inside of selesia side and rear pockets (not finished seam)	1	1	1
9. Facing or bearer:			
(a) excessive fullness in bearer causing a pleat that is caught in bartack	2	2	2
(b) excessive fullness or pleat	1	1	1
b. Side pocket or hanging type pocket:			
1. Facing or bearer not caught in bartack at each end of opening; facing or bearer not extending below bottom bartack and above top bartack	3	3	3
2. Facing exposed on outside	2	1	1
3. Pocketing notched more than 1/4 inch beyond width of outseam allowance on the underside	1	1	1
4. Pocket stay not extending above and below bartacks, or bottom end of stay not turned under	1	-	-
5. Bartack extends beyond outseam, less than 1/16 inch or more than 1/8 inch	1	1	1
6. Top or bottom of pocket opening more than 1/8 inch from outseam joining seam	1	1	-
7. Pocket facing too tight or loose causing edge of pocket opening to be wavy	1	-	-
8. Pocket facing stitching not positioned 1/8 inch from folded edge of pocket opening (varies more than 1/16 inch)	1	-	-
c. Hip pocket (cord or welt type):			
1. Cord or welt not specified width or varies in width by more than 1/16 inch	2	2	-
2. Stitching of pocket opening at top edge not through reinforcement piece for a distance of 1/2 inch or more (welt construction only)	-	1	-

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXXI. <u>POCKET</u> (cont'd)			
3. Reinforcement piece visible at top edge of pocket opening (welt construction only)	-	1	-
4. Buttonhole tab length not as specified or spacing between bartacks not as specified	1	1	-
5. Pocketing material or white threads visible on outside	1	1	-
6. End of cord, bearer, or welt not caught in the edge stitching of pocketing	1	1	-
7. Inside end of pockets at bartack not equidistant from center back seam:			
(a) - up to size 38:			
- difference of more than 1/2 inch	1	1	1
(b) - size 39 and up:			
- difference of more than 3/4 inch	1	1	1
8. Buttonhole tab off center by more than 1/4 inch	1	1	1
d. Patch pocket.			
1. Poorly shaped, or not uniform shape or size by more than 1/4 inch	-	2	2
2. Fullness or tightness at opening	-	1	1
3. Rows of stitching on facing irregular in width by 3/16 inch or more	-	1	1
4. Facing tight or twisted	-	1	1
5. Bulky finish at side seam below pocket opening	-	1	1
6. Edge of pocket opening not stitched as specified	-	1	1
7. Not positioned as specified	-	1	1
8. Tape on facing omitted	-	1	1
e. Right leg patch pocket (applicable to MIL-T-21705 only)			
1. Pleat other than bellows type or omitted	-	-	2
2. Finished welt less than 1-1/8 or more than 1-3/8 inches wide	-	-	1
3. Length of opening less than 8-7/8 or more than 9-3/8 inches wide	-	-	1
4. Misplaced, i.e., bellows off center with outseam by more than 1/4 inch	-	-	1
5. Top edge of welt less than 3/4 inch or more than 1-1/4 inches from top edge of flap	-	-	1
f. Dart:			
1. Not type specified; not properly tapered causing bulge, twist, fullness, or opening	2	1	1
2. Lower end not extending into pocket opening	1	1	1
3. Incomplete	1	1	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXXI. <u>POCKET</u> (cont'd)			
g. Pocket flap:			
1. Corner of flap caught in bartacks at end of opening, restricting freedom of flap	2	2	2
2. Pocket flap not uniform in shape and size by more than 1/4 inch	2	1	1
3. Pocket flap not completely covering pocket opening by:			
(a) - more than 3/8 inch	3	3	3
(b) - more than 3/16 inch up to 3/8 inch inclusive	2	2	1
(c) - more than 1/8 inch up to 3/16 inch inclusive	1	1	1
4. Pocket flap lining exposed on outside	3	2	1
5. Pocket bearer not caught in flap stitching	2	2	-
6. Pocket flap not set specified distance from pocket by 1/8 inch or more	-	-	1
7. Flap not completely covering pocket opening (applicable to Marine Corps trousers only).			
a. Up to 1/16 inch inclusive	1	1	-
b. More than 1/16 inch	2	2	-
h. Compass pocket:			
1. Top of pocket more than 1/4 inch below waistband	-	1	1
2. Buttonhole more than 1/4 inch off center	-	1	1
3. Hem less than 1 or more than 1-1/2 inches wide	-	1	1
i. Cargo pocket:			
1. Pleats turned towards front	-	1	1
2. Bellows side finished on front	-	1	1
3. Front edge of flap not stitched down over pocket	-	1	1
4. Snap fastener socket clinched through outer ply of flap	-	2	2
5. Leg tie out of alignment with buttonhole by more than 1 inch	-	1	1
6. Leg tie tape less than 39 or more than 41 inches	-	1	1
7. Leg loop length less than 3-3/4 or more than 4 inches	-	1	1
j. Knife pocket:			
1. Any part except top edge caught in thigh pocket stitching	-	1	1
2. Top not completely caught in thigh pocket setting seam	-	1	1
3. Sides not folded as specified	-	1	1
k. Shin pocket:			
1. Pocket on right side not in alignment with corresponding pocket by more than 1/4 inch	-	1	1
2. Top end of side fastener facing front of trousers	-	1	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXXI. <u>POCKET</u> (cont'd)			
1. Waistband pockets			
1. Pocket opening tight or full causing puckers on front or gapping of opening	2	-	-
2. Top edge of pocket opening caught in waistband	2	-	-
XXXII. <u>SEAMS</u> (Seat and crotch)			
a. Seat seam outlet omitted or less than specified by more than 1/2 inch on total width of both seams	1	1	-
b. Seat seam lining outlet at waistband omitted or less than specified by more than 1/2 inch on total width of both seams	1	1	-
c. Crotch seam stitching more than 1/4 inch above bartack at base of fly	1	1	1
d. Width of inseam outlet at crotch less than specified	1	-	-
e. Any seam not lapped as specified	-	1	1
f. Inseam staggered at crotch more than specified (center to center) or crotch and seat seam staggered at inseam more than specified (center to center)	2	1	1
g. Crotch reinforcement piece missing or insecurely attached	2	-	-
h. (for MIL-T-87038)			
1. Reinforcement tape omitted	3	-	-
2. Reinforcement tape not securely caught in seam	2	-	-
3. Reinforcement tape not centered on seam or not finished as specified	1	-	-
XXXIII. <u>LEG BOTTOM</u>			
a. Not finished as specified	1	1	1
b. Width of hem not as specified or irregular by more than 1/4 inch	1	1	1
XXXIV. <u>BOTTOM LEG EXTENSION</u> (applicable to MIL-T-21704 and MIL-T-21705 only)			
Short or twisted, causing a noticeable twist or fullness on outside	-	-	2
XXXV. <u>LABEL</u>			
a. Not attached as specified, misplaced, or stitching through the printing	1	1	1

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXXV. <u>LABEL</u> (cont'd)			
b. Missing, incorrect, or illegible:			
1. Size label, instruction label, removable size ticket (when applicable), or combination label	3	3	3
2. Identification label	1	1	1
XXXVI. <u>ORNAMENTATION</u>			
a. Stripes not completely caught in waistband seam	3	-	-
b. Stripes not even with edge of side pocket by more than 1/16 inch	1	-	-
c. Bottom of stripes not centered over outseam	1	-	-
d. Stripes twisted, bulging or pleated	3	-	-
XXXVII. <u>EDGE SEALANT</u>			
a. Penetration less than 1/32 of an inch:			
1. For a distance of 1 to 6 inches	1	1	-
2. For a distance greater than 6 inches	2	2	-
b. Omitted:			
1. For a distance 1 to 4 inches	1	1	-
2. For a distance greater than 4 inches	2	2	-
c. Any sealant on outside of finished trousers	3	3	-
d. Frayed or ragged edges	1	1	-
e. Edge sealant crumbles or flakes	2	2	-
XXXVIII. <u>SEAT PATCHES</u>			
Uneven at top by more than 3/4 inch	-	-	2
XXXIX. <u>FUSING</u>			
a. Bubbling or delamination on fused components	-	-	3
b. Any strike through or bleed through	-	-	2
c. Any resin transfer:			
1. On any fused component	-	-	2
2. On any nonfused component	-	-	3
d. Color fading on fused parts, i.e., fused parts shaded from rest of garment	-	-	2

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TABLE IV. Trousers visual defects (cont'd)

Defect	Point value		
	D	SD	U
XXXX. <u>EYELETS</u> (applicable to MIL-T-43654 and MIL-T-87038)			
a. One or more omitted	3	-	3
b. Eyelets misplaced causing bulge or puckers	2	-	1
c. Stitches not securely caught in fabric (stitches pull away from fabric)	3	-	3
d. One or more broken or more than two skipped stitches in one or more eyelets	2	-	2
e. Not specified size, type or number of stitches	2	-	2
f. Purling on wrong side	2	-	1
g. Loose stitch tension	2	-	1
h. Fabric inside of eyelet not completely cut or removed	2	-	1
i. Threads ends of eyelet not trimmed to within 1/4 inch or trimmed closer than 1/8 inch	1	-	1

1/ Drill hole - This defect should not be scored when visible on the inside of trousers, provided that the component as attached to outside of trousers fully covers the drill hole.

2/ For this defect use the zones shown in illustration I.

3/ On white dress trousers, any spot or stain up to 3/8 inch inclusive in all zones shall be a 1-point defect.

4/ Raw edge resulting from missing, incomplete, or loose serging on leg bottom or any part of trousers shall be scored as a raw edge on inside.

TABLE V. Selected defects for dress (D) trousersFRONT OPENING

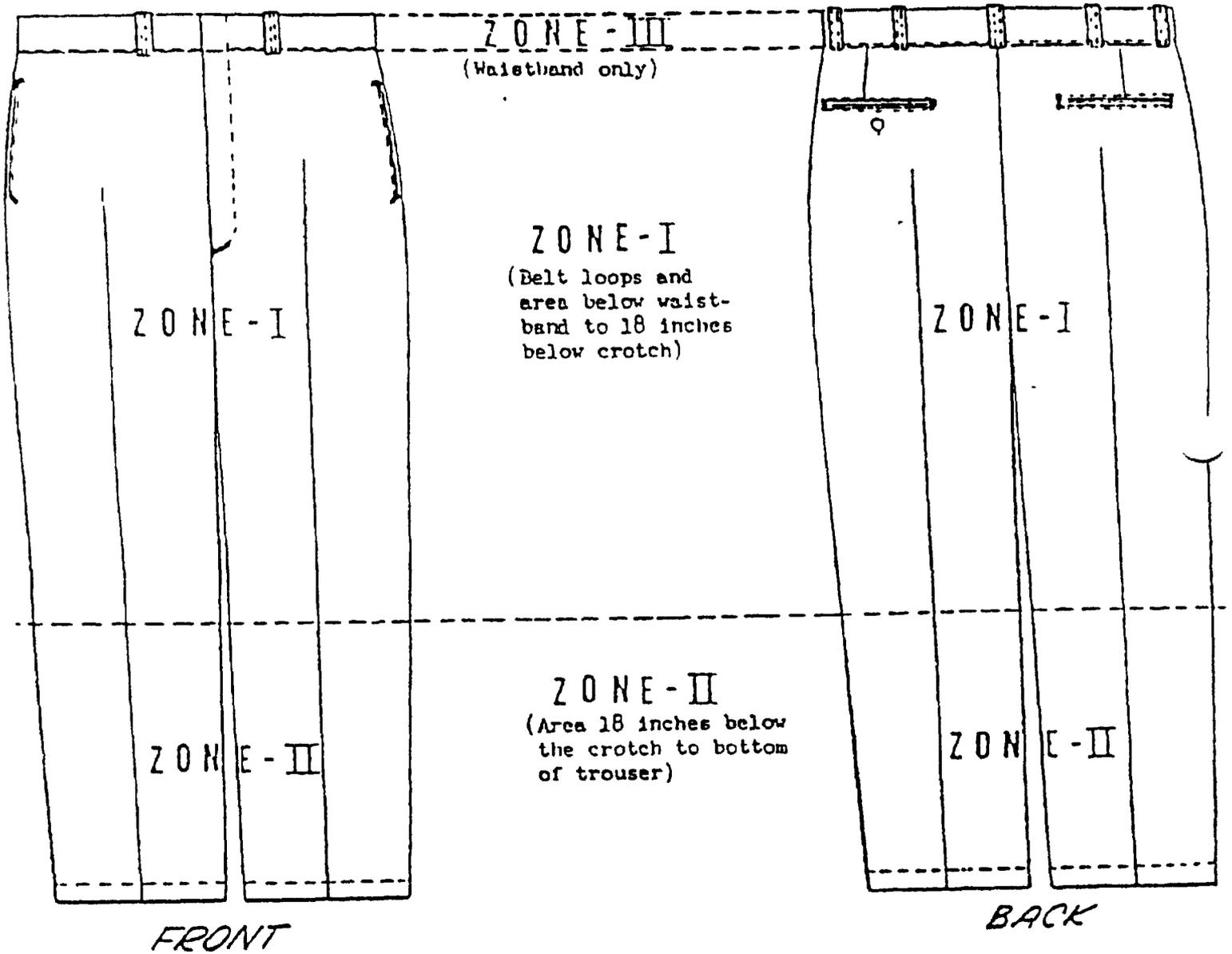
Length of fly uneven at top by more than 1/2 inch (examination to be performed with slide fastener closed and hook and eye or button unfastened).

POCKET OR FLAP

Any one pocket or flap out of alignment by (at any point when measured from the waistband seam) more than 1/2 inch.

Pocket or flap set on higher or lower than companion pocket or flap by (when measured from the waistband seam) more than 1/2 inch.

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CONCLUDING MATERIAL

Custodians:

Army - GL
Navy - NU
Air Force - 11

Preparing activity:

Army - GL
(Project 8405-0113)

Review activities:

Army - MD
Navy - AS, MC
Air Force - 82, 99
DLA - CT

User activity:

Coast Guard - CG

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

INSTRUCTIONS

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

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RECOMMEND A CHANGE:	1. DOCUMENT NUMBER MIL-STD-1488G	2. DOCUMENT DATE (YYMMDD) 90/03/30
3. DOCUMENT TITLE PROVISIONS FOR EVALUATING QUALITY OF TROUSERS		
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed)		
5. REASON FOR RECOMMENDATION		
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a. NAME (Last, First, Middle, Initial)	b. ORGANIZATION	
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7. PREPARING ACTIVITY		
a. NAME U.S. Army Natick Research, Development, and Engineering Center ATTN: STRNC-ES	b. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (508)651-5221	(2) AUTOVON 8-256-5221
c. ADDRESS (Include Zip Code) Kansas Street Natick, MA 01760-5014	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	