

INCH-POUND

MIL-STD-1490G

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SUPERSEDING

MIL-STD-1490F

17 April 1989

MILITARY STANDARD  
PROVISIONS FOR EVALUATING QUALITY  
OF  
COATS, MEN'S, DRESS



AMSC N/A

FSC 8405

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## FOREWORD

1. This military standard is approved for use by all Departments and Agencies of the Department of Defense.
2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be used in improving this document should be addressed to: U.S. Army Natick Research, Development, and Engineering Center, Natick, MA 01760-5019, 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 coats procured by the Department of Defense. The objectives of this standard are to:
  - a. Provide standard description for defects.
  - b. Standardize examination requirements.
4. Coats in this standard are separated into two groups.

Group A coats are the standard dress coats used by the Army, Air Force, and Marine Corps. These coats are basically 4-button single-breasted design with two patch breast pockets. Specifications for Group A coats are:

MIL-C-3771 (MC)	- Coat, Man's: Wool, Serge, Green (With Belt)
MIL-C-24924 (MC)	- Coat, Man's, Polyester/Wool, Gabardine Green (With Belt)
MIL-C-27438 (USAF)	- Coat, Man's, Service
MIL-C-43368 (GL)	- Coats, Man's, Tropical and Serge, Polyester/Wool, Army Green 344
MIL-C-44211 (GL)	- Coats, Man's, Tropical and Serge, Polyester/Wool, Army Green 344, Fusible
MIL-C-82186 (MC)	- Coat, Man's: Polyester/Wool, Green (With Belt)

Group B coats are the standard dress coats for the Navy. These coats are basically 3-button double-breasted design. Specifications for Group B coats are:

MIL-C-29106 (NU)	- Coat, Man's, Wool, Winter
MIL-C-29107 (NU)	- Coat, Man's, Polyester/Wool, Summer

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## 1. SCOPE

1.1 Purpose. This standard provides standardized provisions for evaluating the quality of dress coats.

1.2 Application guidance. This standard will be made applicable to contracts by references in the appropriate coat specifications. These specifications require that: (a) as a final step in the contractor's production control plan before formation of a lot, each coat shall be buttoned on a model form and examined for selected defects, and (b) a coat containing a selected defect shall not be included in the end item lot. Selected defects are those defects in table III which are identified by an asterisk (\*) in the "Point value" column. The selected asterisk defects are listed individually in table IV. This examination for selected defects will also include the measurement of those selected defects identified in table IV with an asterisk.

1.2.1 Model form. The model forms (for the selected defects examination specified in 1.2, and for examination of defects XI through XVII in table III) shall be men's forms conforming to the measurements specified below. The coat sizes listed shall be examined on the appropriate model form size as specified in table I.

TABLE I. Model form measurements

Coat size	Model form size	Model form measurements (+ 1/2 inch)		
		Chest	Waist	Seat-Hip
<u>Army and Navy:</u>				
30-31	30	32	26	32
32-33	32	34	28	34
34-35	34	36	30	36
36-37	36	38	32	38
38-39	38	40	34	40
40-41	40	42	36	42
42-43	42	44	38	44
44-45	44	46	40	46
46-47	46	48	42	48
48-50	48	50	44	50
<u>Marine Corps:</u>				
30-33	30	32	26	32
34-35	32	34	28	34
36-37	34	36	30	36
38-39	36	38	32	38
40-41	38	40	34	40
42-43	40	42	36	42
44-45	42	44	38	44
46-47	44	46	40	46
48-49	46	48	42	48
50	48	50	44	50

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2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

STANDARDS

FEDERAL

FED-STD-4 - Glossary of Fabric Imperfections

MILITARY

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

MIL-STD-109 - Quality Assurance Terms and Definitions

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, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS 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 6.2).

AMERICAN ASSOCIATION OF TEXTILE CHEMISTS AND COLORISTS (AATOC)

Technical Manual of the American Association of Textile Chemists and Colorists

Method 88 B (Two photographs) - Photographic Comparative Rating of Single  
and Double Needle Seams

(See back of Method 88B - Appearance of  
Seams and Durable Press Items After  
Repeated Home Laundering)

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

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(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.

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3. DEFINITIONS

3.1 Fabric defects. Definitions of fabric defects, where applicable, shall be in accordance with FED-STD-4.

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

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. A seam shall be classified as open when one or more stitches joining a seam are broken or run-off, 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. A raw edge is defined as any edge not finished as specified including any protruding edge on the outside of the coat.

3.6 Defective button. A button shall be considered defective when it has a sharp, rough, cracked, or split edge; has a scratch, dent, blemish or embedded foreign matter, loose shank, or loose shell; or is shaded.

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

Outside - Any part of coat that is visible when the completely buttoned coat is observed on the model form. Areas also included are the undersleeve, under the pocket flaps (when untacked), and the area covered by the overlap of the back vent.

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

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 AATOC photographic comparative rating Method 88 B for seams. Puckering on a major portion of the suspected seam that equals or is worse than rating 3 for single needle seams or 3 for double needle seams shall be scored as a puckered seam.



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## 4. GENERAL REQUIREMENTS

4.1 General requirements. This standard contains the provisions for end item examination, dimensional examination, and packaging inspection for dress coats. If there are any inconsistencies between the requirements of the appropriate dress coat specification and the provisions of this standard, the specification shall control. This standard assigns to the listed defects, point values of 1, 2, or 3, depending on degree of severity. The higher point values are assigned to those defects having a more detrimental effect on the appearance or serviceability of the item. The selected defects identified by an asterisk (\*) in the "point value" column of table III are those defects having the most detrimental effect on appearance or serviceability of the item.

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## 5. DETAILED REQUIREMENTS

5.1 End item examination. Dress coats shall be buttoned on a model form or laid out on a table as required in table III for inspection. The dress coats shall be examined and all defects shall be penalized as indicated in table III. The sample size and maximum acceptance values and numbers shall be as specified in table II. 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 exceeds the applicable maximum acceptable point value

or

c. The number of selected defects (asterisk \* defects) exceeds the maximum allowed for the sample size (see table II).

TABLE II. Sampling provisions

Type of inspection	Lot size	Sample size	Maximum acceptance number for selected defects (*defect)	Maximum acceptable point values	
				3&2 point defects	3,2,&1 point defects
Normal	Up thru 50	20	0	5 points	11 points
	51 thru 150	32	0	7 points	17 points
	151 thru 280	50	0	11 points	20 points
	281 thru 500	80	0	14 points	28 points
	501 thru 1200	125	1	23 points	39 points
	1201 thru 3200	200	1	29 points	54 points
	3201 thru 10,000	315	2	42 points	81 points
	10,001 thru 35,000	500	3	60 points	120 points
	35,001 and over	800	5	91 points	180 points
Tightened	Up thru 50	20	0	4 points	8 points
	51 thru 150	32	0	5 points	12 points
	151 thru 280	50	0	8 points	15 points
	281 thru 500	80	0	11 points	20 points
	501 thru 1200	125	1	17 points	30 points

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TABLE II. Sampling provisions (cont'd)

Type of inspection	Lot size	Sample size	Maximum acceptance number for selected defects (*defect)	Maximum acceptable point values	
				3&2 point defects	3,2,&1 point defects
Tightened (cont'd)	1201 thru 3200	200	1	22 points	46 points
	3201 thru 10,000	315	2	36 points	67 points
	10,001 thru 35,000	500	3	54 points	100 points
	35,001 and over	800	5	81 points	150 points
Reduced	Up thru 280	20	0	3-7 points 1/	10 points
	281 thru 500	32	0	6-12 points 1/	18 points
	501 thru 1200	50	0	10-16 points 1/	25 points
	1201 thru 3200	80	0	12-21 points 1/	35 points
	3201 thru 10,000	125	1	21-30 points 1/	46 points
	10,001 thru 35,000	200	1	27-37 points 1/	67 points
	35,001 and over	315	2	37-48 points 1/	100 points

- 1/ If the first value is exceeded but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.8.4b). The second value is the maximum acceptable point value.

TABLE III. Classification of defects 1/

Defect	Point value
I. <u>MATERIAL DEFECTS AND WORKMANSHIP DAMAGE</u>	
a. Any hole, cut, tear, run 2/, smash, mend, burn, scorched area, or open place:	
1. On outside	3
2. On inside (longest dimension in any direction):	
(a) Up to 1/4 inch, inclusive	1
(b) More than 1/4 inch up to 3/8 inch	2
(c) More than 3/8 inch	3
b. Loose yarn, snag 2/, barre 2/, uneven knitting 2/, 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) on outside	2
c. Permanent fold, pleat, or crease in cloth (when caught in seaming or stitching) on outside	3

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TABLE III. Classification of defects 1/ (cont'd)

<u>Defect</u>	<u>Point value</u>
I. <u>MATERIAL DEFECTS AND WORKMANSHIP DAMAGE (cont'd)</u>	
d. Visible needle hole(s) (no thread present) or needle chew, ie, presence of scuffed or broken yarns caused by stitching:	
1. On outside:	
(a) Up to 1/4 inch inclusive	2
(b) More than 1/4 inch	3
2. On inside:	
(a) Up to 1/2 inch inclusive (Army and Navy only)	1
(b) More than 1/2 inch	2
e. Knot or slub (see 3.2) on outside	2
II. <u>SHADED PART</u>	
a. On outside:	
1. Variation in shade within a part or between parts (except parts cut from ends):	
(a) Army and Navy	3
(b) Seriously affecting appearance - Air Force and Marine Corps	3
(c) Affecting appearance, but not seriously - Air Force and Marine Corps	2
2. Part cut from ends shaded, seriously affecting appearance	2
b. On inside:	
1. Any lining part shaded, seriously affecting appearance (except sleeve linings)	1
2. Sleeve lining part shaded, seriously affecting appearance, pairs not matching each other	1
III. <u>PRESSING</u>	
a. Pressing omitted (entire item)	3
b. Excess gloss, causing serious change in appearance	2
c. Edge bulky, i.e., not pressed solid	2
d. Lapel not roll pressed as specified	2
e. Sleeve not pressed as required	2
f. Armhole stretched	2
g. Armhole not blocked	2
h. Inside of armhole not creased as required	2
i. Lining (except sleeve linings) not finish pressed	2
j. Any required seam not pressed open or not pressed smooth and flat for more than 1/2 inch	2
k. Waist dart not pressed as specified	2
l. Collar breakline not creased	2

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
III. <u>PRESSING</u> (cont'd)	
m. Finished pressed width of lapel not uniform (i.e., one side finishing 1/4 inch or more than other when measured across upper portion on horizontal from forced out edge to lapel crease line)	2
n. Improper pressing, i.e., pleat, pressed fold, or crease (on outside)	2
IV. <u>CLEANNESS</u>	
a. Spot or stain on outside:	
1. Up to 1/4 inch inclusive in longest direction	2
2. More than 1/4 inch in longest direction	3
b. Any marking exposed or visible on outside	3
c. Five or more thread ends on outside not trimmed to 3/8 inch or less	1
d. Two or more shade or size tickets on coat	1
e. Basting thread (including monofilament thread or fragments of monofilament thread) not completely removed from outside	1
V. <u>COMPONENT AND ASSEMBLY</u>	
a. Any component part or operation omitted (unless otherwise classified herein)	3
b. Any component not as specified	3
c. Any component part tight, twisted, distorted, pleated, or full (unless otherwise classified herein)	2
d. Any operation not performed as specified (unless otherwise classified herein)	2
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. <u>CUTTING</u>	
a. Any component part not cut in accordance with specified pattern or directional lines on patterns, or not in accordance with specification requirements	3
b. Twill line of any outside part not running in specified direction	3
VII. <u>SEAMS AND STITCHING</u>	
a. Accuracy of seaming:	
1. Seam puckered (on outside) (see 3.8):	
(a) From 1/4 to 1/2 the length of seam	1
(b) More than 1/2 the length of seam	2

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
VII. <u>SEAMS AND STITCHING (cont'd)</u>	
a. Accuracy of seaming: (cont'd)	
2. Seam irregular, pleated, or wavy (unless otherwise classified herein)	2
3. Any part of coat caught in an unrelated operation or stitching	2
4. Blindstitching, tacking, or hand felling of armhole exposed on outside	1
5. Machine felling or hand felling (other than around armhole) exposed for a distance of 3/8 inch or more	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	1
8. End of a continuous line of stitching overlapped less than 1/2 inch	1
9. Not specified color thread used on outside	2
10. Needle perforations clearly visible on outside of coat	3
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. Seam allowance not as specified by 1/16 inch (1/8 inch - Air Force) or more (score only when condition exists on more than half the length of the seam)	1
3. Irregular or not within range specified or varies more than 1/16 inch (1/8 inch - Air Force) when no range is specified (score only when condition exists on more than half the length of the seam)	1
c. Open seam: (see 3.4)	
1. On outside (excluding lower edge of under-collar):	
(a) More than 3/4 inch	3
(b) More than 1/2 inch up to 3/4 inch inclusive	2
(c) Up to 1/2 inch inclusive	1
2. On inside: machine felling and hand felling (other than hand felling around armhole):	
(a) More than two skipped stitches or 1/4 inch up to 2 inches inclusive	1
(b) More than 2 inches	2
3. On inside: stitch type 301 and hand felling around armhole	
(a) More than 3/8 inch up to 2 inches inclusive	1
(b) More than 2 inches	2

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
VII. <u>SEAMS AND STITCHING</u> (cont'd)	
d. Raw edge: (see 3.5)	
1. On outside:	
(a) Up to 1/2 inch inclusive	1
(b) More than 1/2 inch up to 3/4 inch inclusive	2
(c) More than 3/4 inch	3
2. On inside:	
(a) 3/8 inch up to 2 inches inclusive	1
(b) More than 2 inches	2
e. Seam and stitch type:	
1. Not specified seam or stitch type	3
2. Any line of stitching omitted or insecure	2
3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein)	1
4. Looper thread of 401 stitch type on outside	1
f. Stitch tension:	
1. Loose tension resulting in a loose seam:	
(a) 1/4 up to 1/2 length of seam inclusive	1
(b) More than 1/2 length of seam up to 3/4 length of seam inclusive	2
(c) More than 3/4 length of seam	3
2. Loosely exposed loops of lower or top thread on edge, top, or raised stitching	2
3. Tight tension (stitches break when strain is applied in the direction of the seam or stitching)	3
g. Stitches per inch (score only when condition exists on more than half the length of seam):	
1. More than the maximum specified (affecting construction or appearance)	1
2. Less than the minimum specified:	
(a) By one or two stitches (Army and Navy); by two stitches (AF&MC)	1
(b) By three or more stitches	2
h. Run-off, skipped, or broken stitch:	
1. Joining seam - use open seam classification (see VIIC)	-
2. Edge, top, or raised stitching (more than 1/4 inch)	1
i. Bartack, tack, or tacking (except buttonhole bartack):	
1. Missing, insecure, misplaced, not serving intended purpose	2
2. Loose stitch tension	1
3. Not specified size or type	1

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TABLE III. Classification of defects 1/ (cont'd)

<u>Defect</u>	<u>Point value</u>
VIII. <u>BUTTONHOLE OR EYELET</u>	
a. Omitted, added, not specified type, or not finished as specified	3
b. Stitched buttonhole or eyelet:	
1. Gimp omitted, uncut, finished length or diameter not as specified, or end of gimp not pulled through to underside on square bar type buttonholes	2
2. Ragged edge, incomplete stitching, stitching not securely caught in fabric, bulky appearance, stitches not uniform, or loose tension	2
3. Broken stitch, or two or more skipped stitches	2
4. Buttonhole stitching extending beyond bartack	2
5. Bartack missing, loose or misplaced (not serving intended purpose)	2
6. Stitches per buttonhole, eyelet, or bartack less than specified by:	
(a) One to three stitches	1
(b) Four or more stitches	2
c. Bound buttonhole:	
1. Finished length not as specified	3
2. Tongue notch at one or both ends exposed, or not securely tacked on inside of raw edges at ends	3
3. Piping uneven, or top and bottom piping not uniform in width by more than 1/16 inch	1
4. Width of piping not within tolerance specified, or $\pm 1/16$ inch from required width when no tolerance is specified	1
5. Any open seam (ie, any visible opening between binding and shell fabric on inside or outside)	2
6. Ends of piped buttonhole spread apart or overlapped by more than 1/16 inch	1
7. Any stitching visible on piping on outside	1
8. Piping joining seam visible on inside	1
IX. <u>BUTTON OR TOGGLE</u>	
a. Omitted, broken, or defective (see 3.6)	2
b. Out of horizontal or vertical alignment by:	
1. 3/16 to 3/8 inch	1
2. More than 3/8 inch	2
c. Misplaced, loose, not attached as specified, or insecurely sewn	1
d. Tacking stitches omitted or insecure (hand sewn)	1



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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
IX. <u>BUTTON OR TOGGLE</u> (cont'd)	
e. Button sewn with wings of eagle or shield in other than upright position (front and flap buttons) or shoulder loop buttons sewn to coat with the spread wings of the eagle, or shield not in specified position	1
f. Shank wrapping (when required) omitted, loose, or insecurely wrapped	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. <u>SNAP FASTENER</u> (when applicable)	
a. Stitching of stud visible on outside of flap	2
b. Missing, loose, broken, defective, or mismatched	1
c. Misplaced or not positioned as specified	1
d. Tacking stitches omitted or insecure on one or more handsewn fasteners	1
XI. <u>ALIGNMENT OF FRONT BUTTON OR BUTTONHOLE</u>	
a. Top front button or buttonhole of Group A coat (see page ii) out of horizontal alignment with breast pocket flap buttons:	
1. By more than 1/2 inch	*
2. By more than 3/8 inch but not more than 1/2 inch	3
b. Button or buttonhole misplaced:	
1. For Group A Army and Air Force coats, bottom front button or buttonhole varies from 7/8 inch (Army coats) or 3/4 inch (Air Force coats) above top edge of lower pocket flap by:	
(a) More than 1/8 inch up to 1/4 inch (Army coats)	1
(b) More than 1/4 inch up to 3/8 inch	2
2. Top front button or buttonhole of Group B coat or lower front button or buttonhole (all coats) misplaced:	
(a) By more than 3/8 inch but not more than 1/2 inch (Army coats)	3
(b) By more than 1/2 inch	*
c. Left front rolling outward below bottom front button	3
d. Button and buttonhole not aligned, causing a bulge or twist on front	3
e. Front buttonhole position (from inside edge of eyelet):	
1. Less than 5/8 inch but not less than 3/8 inch, or more than 3/4 inch but not more than 7/8 inch from edge	1

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XI. <u>ALIGNMENT OF FRONT BUTTON OR BUTTONHOLE (cont'd)</u>	
2. Less than 3/8 inch or more than 7/8 inch from edge	2
3. Unevenly spaced from edge by 1/8 inch or more	1
f. Spacing between front buttonholes varying more than 1/4 inch	1
g. Button on left front of Group B coat not in horizontal alignment with button on right front by:	
1. 1/4 inch but not more than 1/2 inch	1
2. More than 1/2 inch but not more than 1 inch inclusive	2
3. More than 1 inch	3
h. Anchor button not aligned with buttonhole, causing a noticeable bulge or twist on front	3
XII. <u>LENGTH OF BUTTONED FRONT</u>	
a. Left front shorter than right front at bottom by:	
1. More than 1/4 inch	*
2. More than 1/8 inch up to 1/4 inch inclusive	3
b. Left front longer than right front at bottom by:	
1. More than 1/4 inch	*
2. More than 1/8 inch up to 1/4 inch inclusive	3
XIII. <u>POCKET OR FLAP</u>	
a. Misshapen or distorted - any point varying:	
1. More than 1/4 inch from specified dimension or with corresponding point on finished shaper	*
2. 1/8 up to 1/4 inch (inclusive) from specified dimension or with corresponding point on finished shaper (except Marine Corps)	3
b. Not uniform in size or shape - any point varying more than 1/4 inch with corresponding point on matching part	3
c. Out of alignment or misplaced by (horizontal or vertical):	
1. All coats except Group A Marine Corps coats: 3/	
(a) More than 3/8 inch	*
(b) More than 1/4 inch up to 3/8 inch inclusive	3
(c) 1/8 inch up to 1/4 inch inclusive	2
2. Group A Marine Corps coats only: 4/	
(a) More than 3/16 inch (vertical)	*
3. Flap not in horizontal alignment (Group A Marine Corps coats only):	
(a) More than 3/16 inch	*
(b) More than 1/8 inch up to 3/16 inch inclusive	3

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XIII. <u>POCKET OR FLAP</u> (cont'd)	
d. Flap (any):	
1. Twisted or bulged when snapped or tacked (as applicable) and buttoned	3
2. Full	2
3. Bottom corner of flap curled upwards; stitching joining flap to front not caught through twill cloth stay piece or flap not completely covering pocket opening	2
4. Misplaced, not positioned as specified	2
5. Raw edge beneath top edge of flap; corner of flap not securely backstitched	1
6. Buttonhole out of alignment with point at center of flap by more than 1/8 inch or not positioned as specified	1
7. Overedge stitching omitted	1
e. Breast pocket flap: Group A coat	
1. Point at center of flap from center of pocket pleat:	
(a) More than 1/8 inch up to 1/4 inch inclusive	2
(b) More than 1/4 inch	3
2. Lower side edge of flap covering side of pocket less than 1/16 or more than 3/16 inch	*
3. When pocket flaps are tacked at each corner:	
(a) Tacking visible on outside of flap	1
(b) Less than 2 stitches on hand tacking	1
f. Breast pocket: Group A coat	
1. Side pocket not parallel with front edge of coat by: 5/	
(a) More than 3/8 inch	3
(b) 1/4 inch up to 3/8 inch	2
2. Fold of pleat on outside: pleat off center at lower edge of flap by 1/4 inch or more; or pleat set on crookedly or slanted by 1/8 inch or more	2
3. Twill cloth exposed on pocket edge (when lined pocket construction is used or twill cloth tight or short causing fullness or puckers in outside of pocket)	2
4. Pleat not stitched closed; width of pleat not as specified; or edge stitching not catching portion of pocket under pleat	2
5. Stitching at end of pocket opening not securely stitched through stay piece; or end of stitching at end of pocket not backtacked as specified	1

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XIII. <u>POCKET OR FLAP</u> (cont'd)	
g. Lower pocket opening: Group A coat	
1. Opening gapped by 1/4 inch or more or length of opening not as specified	1
2. Width of corded or piped edge not as specified by more than 1/8 inch	1
3. Front edge of flap not parallel with front edge of coat by more than 1/4 inch when coat is buttoned	1
4. End of facing not caught in twill cloth pocket seaming	1
5. Bartacking at ends of pocket opening omitted or insecure	1
h. Welt pocket: Group B coat	
1. Top edge of welt short causing puckers in front, or too loose causing welt to gap by 1/4 inch or more at any point	2
2. Tape stitching exposed and visible on outside surface	1
3. Diagonal reinforcing row of stitching on corners of welt, omitted or insecure	1
4. Tacking at top front corner or tacking to seam allowance of hanging pocket along front edge to interlining omitted or insecure	2
5. Cash pocket in inside right lower pocket omitted or misplaced, i.e., more than 1 inch from center of pocket	1
6. Notch exposed beyond outside end of welt or not securely caught within the row of stitching at end of welt	3
7. Any portion of welt setting seam on one or more pockets not spread open for a distance of 1/2 inch or more	1
8. Top back edge of welt not equidistant from side seam by more than 3/4 inch	1
9. Finished width of welt on hip pockets less than 1-1/8 inches or more than 1-1/4 inches	1
10. Finished width of welt on outside breast pocket less than 7/8 inch or more than 1 inch	1
11. Finished width or depth not as specified	1
i. Lower patch pockets: Group A Marine Corps coats	
1. Top edge of pocket set less than 3/4 inch or more than 1-1/4 inch below top edge of flap	2
2. Binding on top edge omitted or not securely caught in fabric, causing binding to pull away from fabric	3

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XIII. <u>POCKET OR FLAP (cont'd)</u>	
i. Lower patch pockets: Group A Marine Corps coats (cont'd)	
3. Fullness at pocket opening affecting appearance	1
4. Button and buttonhole not aligned causing a noticeable bulge or twist on pocket or flap when buttoned, affecting appearance	2
5. Bottom edge of pocket not parallel with bottom edge of coat by 1/4 inch or more	2
6. Pocket corners not securely stitched	2
7. Tightness at pocket opening affecting appearance	2
XIV. <u>LAPEL OR COLLAR</u>	
a. Misshapen or distorted - any point varying 1/4 inch or more with corresponding point on finished shaper	*
b. Not uniform in size or shape - any point varying:	
1. More than 5/16 inch with corresponding point on matching part	*
2. More than 1/4 inch but not more than 5/16 inch with corresponding point on matching part	3
3. More than 1/8 inch but not more than 1/4 inch with corresponding point on matching point	2
c. Twisted, short, or tight causing collar or lapel to turn out	3
d. Collar:	
1. Collar rolling up above collar breakline by:	
(a) 1/8 inch to 3/16 inch (inclusive)	3
(b) More than 3/16 inch	*
2. Long, i.e., setting away from neck, or lapel rolling higher than 2 inches above top front button or buttonhole	3
3. Tight at joining to gorge seam or across back, causing excessive fullness or pleats on:	
(a) Lapel	3
(b) Across outside back	2
4. Collar edge:	
(a) Crooked, irregular, or wavy	2
(b) Undercollar exposed along collar edge for 1/4 inch or more	1
5. Gorge seam not spread open (any portion): not straight; tacking insecure or tacking omitted	1
6. Gorge seams not uniform in length by 1/4 inch or more (measure from collar breakline to end of gorge seam notch)	1
7. Tacking in corner of undercollar to lapel omitted or insecure	1

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XIV. <u>LAPEL OR COLLAR (cont'd)</u>	
d. Collar: (cont'd)	
8. Top collar full, having pucker or folds 1/8 inch or more from edge of undercollar	2
e. Undercollar:	
1. Interlining pleated, affecting smoothness of top collar	2
2. Center seam more than 1/4 inch from center back seam; width of undercollar stand at center back seam not as specified	1
3. Interlining or undercollar tight causing pleat or puckers on undercollar of neck of coat	1
4. Lower raw edge of undercollar not enclosed within felling stitches for more than 3/4 inch	1
5. Blind tacking at corner of collar and lapel exposed on outside of coat	1
6. Bottom edge of undercollar exposed beyond collar edge	2
f. Lapel:	
1. Gap between top edge of lapel and end of collar on one side of coat not uniform with other side of coat by:	
(a) More than 1/8 inch up to 1/4 inch (all except Air Force)	2
(b) More than 1/4 up to 3/8 inch (Army, Navy and Air Force)	3
(c) More than 3/8 inch (Army, Navy and Air Force)	*
(d) More than 1/4 inch (Marine Corps)	*
2. Top edge of lapel and end of collar gapping more than 1/4 inch (Army and Navy peak lapel coats)	3
3. Puckers or pleat	3
4. Lapel edge irregular or wavy	2
5. Lapel edge not fully forced out (i.e., having folds of more than 1/8 inch), or front part exposed on lapel edge	2
6. Bridle tape not held taut, causing points of lapel or collar to roll outward and not finish flat or to be misplaced (i.e., tape extending beyond breakline on lapel side)	3
7. Fullness (not smooth and flat)	2
8. Bridle tape misplaced: (Army, Navy and Marine Corps)	
(a) At gorge:	
(1) More than 3/8 inch behind lapel breakline	3

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XIV. <u>LAPEL OR COLLAR</u> (cont'd)	
f. Lapel: (cont'd)	
(2) Bridle lapel basted onto or extending beyond breakline on lapel side	*
(3) More than 5/8 inch behind lapel breakline	*
(b) At 1-1/2 inches from lapel bottom:	
(1) More than 5/8 inch behind lapel breakline	
(2) Bridle tape basted onto or extending beyond breakline on lapel side	*
(3) Bridle tape more than 7/8 inch behind lapel breakline	*
(c) Bridle tape end not within 1 to 1-1/2 inches from bottom of lapel	2
XV. <u>SHOULDER CONSTRUCTION</u>	
a. Improperly joined or set, causing shoulder or back to twist	3
b. Shoulder seam curved towards back from normal position at armhole end by:	
1. More than 3/8 inch	2
2. 1/4 inch up to 3/8 inch, inclusive	1
XVI. <u>SHOULDER PAD</u>	
Not completely caught in armhole tacking; or misplaced, not serving intended purpose, i.e., too far back or too far forward	3
XVII. <u>SHOULDER LOOP</u>	
a. Not uniform in size or shape - any point varying:	
1. More than 3/8 inch with corresponding point on matching part	3
2. 1/4 inch up to 3/8 inch (inclusive) with corresponding point on matching part	2
b. Misplaced, i.e., shoulder seam exposed or loop will not lay flat when buttoned causing bulge or twist	2
c. Button not aligned with buttonhole causing bulge or twist on loop or pucker on shoulder	2
d. Point of loop extending beyond collar creaseline	1
e. Width of loop at sleevehead or at base of point not as specified	1
f. Buttonhole 1/4 inch or more off center, or buttons not uniformly set by more than 1/4 inch	1

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XVII. <u>SHOULDER LOOP</u> (cont'd)	
g. Back edge of loop more than 3/4 inch from shoulder seam at armhole; point of loop back of shoulder seam or point of loop more than 1/2 inch forward of shoulder seam	1
h. Position of shoulder loop button from collar edge not as specified:	
1. Less than 1/8 inch but not covered by collar edge or more than 1/2 inch	1
2. Partially covered by collar edge (half of button or less)	1
3. Button more than half covered by collar edge	1
i. Interlining not caught in seaming of loop	1
j. Other than one piece construction	1
k. Set upside down exposing underside seam	*
l. Back edge of loop more than 1/2 inch from shoulder seam (Group A Marine Corps coats only)	2
XVIII. <u>ARMHOLE OR SHOULDER</u>	
a. Fullness or puckering in any of the following locations:	
1. Over shoulder in back area	3
2. In collar or shoulder area	3
3. Between lapel and sleeve seam	3
b. Puckering on front or back of coat around armhole from back seam to forearm seam	3
c. Stretched, affecting appearance	3
d. Crooked seam; armhole not completely tacked; sleevehead pad not completely tacked; or sleevehead pad misplaced, not serving intended purpose	2
XIX. <u>SLEEVE</u>	
a. Setting and hang:	
1. Break or twist on sleeve, or top sleevehead too short	*
2. Sleeve fullness misplaced or concentrated in one area	3
3. Sleeve tight, i.e., front or back part of sleeve not having roll effect at armhole	3
4. Sleeve too far front or back, i.e., front edge of sleeve away from center of lower flap button or center of pocket:	
(a) Front creased edge of sleeve more than 2-1/2 inches or less than 1 inch behind	



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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XIX. <u>SLEEVE</u> (cont'd)	
a. Setting and hang: (cont'd)	
center of lower flap button or forward of button (Group A Marine Corps coats only)	*
(b) More than 2 inches $\phi$ /	3
(c) More than 1 inch up to 2 inches, inclusive $\phi$ /	2
5. Sleeve lining too long, causing lining to sag below bottom edge of sleeve by more than 1/4 inch	1
b. Construction of sleeve:	
1. Wigan twisted, tight, or pleated, causing ridge or puckering on outside of sleeve	2
2. Bottom edge of wigan not extending to bottom edge of sleeve by more than 1/8 inch, or tacking on bottom turn up to wigan omitted or insecure	1
3. Sleeve lining seam out of alignment more than 3/4 inch with sleeve seam at armhole or at bottom of sleeve	1
4. Sleeve bottom edge uneven by more than 1/4 inch	1
5. Tacking on sleeve lining seam to sleeve seam omitted, insecure, or incomplete for a distance of more than 6 inches from top or bottom edge	1
6. Sleeve lining twisted, tight, or short causing fullness or twist on outside of sleeve	3
c. Sleeve braid:	
1. Edge of braid not positioned as specified, ends of braid finished at forearm seam, or ends of braid staggered more than 1/8 inch at joining seam	2
2. Stitched to sleeve tightly causing puckers; or stitched loosely causing puckers or pleat on braid	2
d. Sleeve cuffs:	
1. Height of cuffs at front and back edges:	
(a) More than 3-5/8 inches or less than 3-1/8 inches at front	3
(b) More than 3-1/2 inches or less than 3 inches at back	3
2. Height of cuffs at point on top sleeve more than 6-1/4 inches or less than 5-3/4 inches	3
3. Top edge on top sleeve part poorly shaped, affecting appearance	2

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XIX. <u>SLEEVE</u> (cont'd)	
d. Sleeve cuffs: (cont'd)	
4. The point of cuff not centered between lower backarm and forearm creased edges of sleeves by more than 3/16 inch	2
5. Cuffs not uniform in size or shape with corresponding points by more than 1/4 inch	*
XX. <u>FITTING</u>	
a. Fitting of body and yoke lining: tight, short, or twisted causing fullness or twist on outside of coat	3
b. Fitting of front interlining:	
1. Tight or short, causing fullness on outside of coat	3
2. Too full, causing coat front to have a wavy appearance or not lie smoothly	3
XXI. <u>FRONT AND BOTTOM EDGE</u>	
a. Front rolling outward below bottom button	3
b. Front edge stretched, puckered or folded more than 1/8 inch on front or bottom edge, front edge irregular, or bottom corner of left front miss-happen or distorted	2
c. Left front below bottom button swings to right or left of the perpendicular by more than 1/2 inch	1
XXII. <u>VENT OPENING</u>	
a. Left vent edge stretched, causing vent to spread open	3
b. Left vent edge crooked or irregular; or right vent lining tight, short, or twisted, causing fullness on outside of right vent	2
c. Left vent 1/4 inch or more longer or shorter than right vent, or bottom turnup exposed or visible on left front edge	1
d. Diagonal row of stitching across top of vent opening omitted	1
e. Vent not topstitched as specified (Marine Corps coats only)	1
XXIII. <u>SIDE SEAM OR CENTER BACK SEAM</u>	
a. Side seam or center back seam puckered	3
b. Side seam or center back seam full	2
c. Side seam or center back seam twisted (i.e., having a diagonal twist on front or back of coat)	3

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XXIV. <u>BELT LOOP</u>	
a. Any end not securely stitched	2
b. Loop set at an angle (more than 3/16 off perpendicular)	2
c. Length or width not as specified	1
d. Bottom folded edge of loop more than 1/4 inch above top edge of lower edge	1
e. Not positioned as specified	1
f. Under loop on left side omitted	2
g. Length of under loop not as specified	1
XXV. <u>BELT</u>	
a. Interlining omitted	3
b. Pointed end poorly shaped, affecting appearance	1
c. Square end of belt not overedged	1
d. Lining or interlining short, full, or twisted, causing fullness or twists on outer side of belt, affecting appearance	1
e. Width of belt not as specified	1
f. Irregular in width by 1/8 inch or more, affecting appearance	2
g. Belt keeper:	
1. Omitted	3
2. Length of belt keeper not as specified when measured from bartack to folded end	2
3. Finished width not as specified	1
h. Belt fastener:	
1. Omitted	3
2. Finished width not as specified	1
3. Finished length not as specified	1
4. Fastener not securely bartacked	1
5. Buttonhole not stitched through double thickness of fastener	1
6. Fastener button:	
(a) Stitched through outer cloth	1
(b) Misplaced, causing a noticeable bulge or twist on belt, affecting appearance	2
7. Purling of buttonhole on reverse side	1
8. Ends of buttonhole not securely tacked:	
(a) Tacking on one end of buttonhole omitted or insecure	1
(b) Tacking on both ends of buttonhole omitted or insecure	2

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TABLE III. Classification of defects 1/ (cont'd)

<u>Defect</u>		<u>Point value</u>
XXV.	<u>BELT</u> (cont'd)	
	i. Buttonhole (position):	
	1. Center of buttonhole to end of belt:	
	(a) Less than 7/8 inch but not less than 3/4 inch or more than 1-1/8 inches	1
	(b) Less than 3/4 inch	2
	2. Off-center by more than 1/4 inch	2
	3. Purling of buttonhole finished on underside of belt	1
	j. Button on overedged end of belt (position):	
	1. Less than 3-1/2 inches or more than 3-3/4 inches from the overedged end	1
	2. Button not stitched through outer cloth	2
	3. Misplaced, causing turnback to be exposed beyond edge of belt	1
XXVI.	<u>WAIST SEAM</u>	
	a. Not pressed open	2
	b. Excessively stretched, affecting appearance	2
	c. Staggered more than 1/4 inch when fronts are buttoned	1
XXVII.	<u>WAIST DART</u>	
	Seam not pressed open	2
XXVIII.	<u>BREAST POCKET</u> (Tacking)	
	One or both corners of stay piece of breast pockets not tacked or not securely tacked to the interlining	1
XXIX.	<u>FRONT WAIST DART</u> (Construction and tacking)	
	a. Waist dart seam not pressed as specified	1
	b. Tacking of waist dart seam to interlining omitted or insecure	1
XXX.	<u>LOWER POCKET</u> (Tacking)	
	Top front corner or top edge of stay piece of lower pocket not tacked or not securely tacked to interlining	1
XXXI.	<u>HANGER</u>	
	End not secure or length not as specified	1
XXXII.	<u>FRONT FACING</u>	
	a. Short, tight, or twisted, causing fullness or twist on fronts	3
	b. Exposed beyond edge of left front by more than 1/16 inch	1

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XXXII. <u>FRONT FACING</u> (cont'd)	
c. Tacking catching through pocket or forepart	1
d. Tacking on back edge to interlining insecure or incomplete for a distance of more than 2-1/2 inches below shoulder seam, more than 2 inches above pocket opening, or more than 2 inches above bottom of coat; or felling at bottom corner of facings omitted or insecure	1
XXXIII. <u>INSIDE POCKET</u>	
a. Opening not extending into facing or extending into armhole	1
b. Tacking along front edge of twill cloth pocket through facing and interlining (hand):	
1. Omitted or insecure	1
2. Extending for a distance of less than 5 inches	1
c. Stay piece not extending to armhole seam, stay piece not stitched to lining, pocket opening badly gapped, width of opening or depth of pocket not as specified	1
d. Tacking on back upper corner to interlining omitted or insecure	1
XXXIV. <u>LABEL</u>	
a. Missing, incorrect, or illegible:	
1. Size, label, instruction label, or combination label	3
2. Identification label	1
b. Not attached as specified, misplaced, or stitching through the printing	1
XXXV. <u>CARDBOARD INSTRUCTION FOLDER</u>	
Missing, incorrect, or illegible	1
XXXVI. <u>SIZE TICKET</u>	
a. Missing, incorrect, or illegible	1
b. Not securely tacked to right front sleeve	1
XXXVII. <u>BACK YOKE</u>	
a. Width of center pleat less than specified, center pleat omitted, or width of bottom hem not as specified	1
b. Felling at lower edge of yoke lining to side seam outlet omitted or insecurely felled on one or both sides	1

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TABLE III. Classification of defects 1/ (cont'd)

<u>Defect</u>		<u>Point value</u>
XXXVIII.	<u>FRONT BODY LINING</u>	
a.	Pleat omitted at shoulder, underarm dart omitted, pleat along bottom or sides omitted	2
b.	Lining exposed below bottom edge of coat	2
c.	Felling on bottom corners of lining and vent omitted or insecure	1
d.	Pleat on center back lining omitted	2
e.	Hand or machine felling stitch caught through fold of bottom pleat or side pleat for 1/4 inch or more restricting bellow of pleat	1
XXXIX.	<u>RIGHT VENT LINING</u>	
a.	Top edge not completely covering edge of center back seam outlet	1
b.	Diagonal stitching across top of vent not full width of left back seam allowance	1
XL.	<u>LINING SIDE OF ARMHOLE</u>	
	Backstitching at armpit of armhole, from forearm seam of sleeve to side seam omitted (hand sewing only)	1
XLI.	<u>BINDING ON COAT</u> (when applicable)	
a.	Not caught on fabric, causing binding to pull away from fabric easily	1
b.	Binding tight, causing edge of seam to curl and not lie flat	2
c.	Back folded edge of body lining not covering end of binding	1
XLII.	<u>BOTTOM HEM AND TURNUP</u>	
a.	Hem and back parts twisted or irregular in width by 1/4 inch or more	1
b.	Tacking on turnup of front to front omitted or insecure	1
XLIII.	<u>LEFT FRONT FLY</u>	
a.	Omitted	3
b.	Raised stitching along front edge omitted	2
c.	Width of fly stitching from open edge less than 2 inches or more than 2-3/4 inches	1
XLIV.	<u>SWEAT SHIELD</u>	
a.	Placed so that front edge covers inside pocket opening 1/4 inch or more, or 1/2 inch or more back of forearm seam of sleeve lining	1

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TABLE III. Classification of defects 1/ (cont'd)

Defect	Point value
XLIV. <u>SWEAT SHIELD</u> (cont'd)	
b. Top edge not securely caught in armhole tacking or stitching	1
c. Tacking on lower edge omitted or insecure	1
d. Puckered, pleated, or twisted	1
e. Constructed of other than required material	1
f. Top or bottom raw edge of binding on shield (when applicable) not turned under and caught in stitching	1
g. Binding (when applicable) omitted on one or both armhole shields	2
h. Binding (when applicable) not securely stitched to fabric	1
XLV. <u>FUSING</u>	
a. Delamination	
- Partial or complete delamination on any fused component	*
- Bubbling on any fused component	*
b. Any strike through or bleed through	*
c. Any resin transfer to coat	
- On any fused component	*
- Non-fused component	3

- 1/ Defects I through X are general defects.  
 Defects XI through XXVII should be inspected for with the coat completely buttoned and buckled on a model form.  
 Defects XXVIII through XLV should be inspected for with the coat spread out on a table.
- 2/ For knitted fabric imperfection definitions, see MIL-STD-1491.
- 3/ The following focal points shall be measured in the examination for this condition:
1. Flap: top corner of flap nearest front edge of coat and front edge of flap just before the curved corner.
  2. Patch pocket: bottom of straight edge nearest front edge of coat.
  3. Welt pocket: top corner of pocket nearest front edge of coat.
- 4/ The following focal points are applicable only to Marine Corps coats:
1. Front edge of breast pocket not in vertical alignment with the front edge of the lower flap.

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2. Upper front corner of lower patch pocket not set back 1/8 inch and the lower corner of the pocket not set back 3/8 inch from the above vertical alignment.
- 5/ Measure from straight front edge of coat to front edge of pocket at top (at the top front buttonhole or button position), and also at bottom of pocket. Any difference between measurements is the amount pocket is not parallel with front edge.
- 6/ Excluding Group A Marine Corps coats.

TABLE IV. Selected defectsALIGNMENT OF FRONT BUTTON OR BUTTONHOLE

Top front button or buttonhole of Group A coat (see page ii) out of horizontal alignment with breast pocket flap buttons by more than 1/2 inch.

Top front button or buttonhole of Group B coat or lower front button or buttonhole of Group A or B coat misplaced by more than 1/2 inch.

LENGTH OF BUTTONED COAT

Left front shorter or longer than right front at bottom by more than 1/4 inch.

POCKET OR FLAP

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

Out of alignment or misplaced by more than 3/8 inch. 1/ (All but Marine Corps coats) \*

Out of alignment or misplaced by more than 3/16 inch 2/ (Group A Marine Corps coats only) \*

Flaps not in horizontal alignment by more than 1/4 inch (Group A Marine Corps coats only) \*

LAPEL OR COLLAR

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

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

Collar:

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

Lapel:

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

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



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TABLE IV. Selected defects (cont'd)LAPEL OR COLLAR (cont'd)Lapel: (cont'd)

- Bridle tape more than 5/8 inches behind lapel breakline at gorge.
- Bridle tape basted onto or extending beyond breakline on lapel side at lapel bottom.
- Bridle tape more than 7/8 inch behind lapel breakline at lapel bottom.

SLEEVESetting and hang:

- Break or twist on sleeve, or top sleevehead too short.
- Front creased edge of sleeve more than 2-1/2 inches or less than 1 inch behind center of lower flap button or forward of button (Group A Marine Corps coats only). \*

SHOULDER LOOP \*

- Set upside down exposing underarm seam.

- 1/ The following focal points shall be measured in the examination for this condition:
  1. Flap: top corner of flap nearest front edge of coat.
  2. Patch pocket: bottom of straight edge nearest front edge of coat.
  3. Welt pocket: top corner of pocket nearest front edge of coat.
- 2/ The following focal points are applicable only to Marine Corps coats:
  1. Front edge of breast pocket not in vertical alignment with the front edge of the lower flap.
  2. Upper front corner of lower patch pocket not set back 1/8 inch and the lower corner of the pocket not set back 3/8 inch from the above vertical alignment.

5.1.1 Examination for table V measurable defects. As a part of the end item examination, the applicable number of dress coats specified below shall be measured to determine the presence of defects listed in table V. At least one coat from each size in the lot shall be included in the sample. When the number of sizes in the lot exceeds the sample size, the sizes to be included in the sample shall be randomly selected from among all the sizes. The sample shall be examined for all end item characteristics as well as being measured for the defects in table V. Additional dimensional measurements may be taken at any time in the remainder of the end item examination. The

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number of selected defects found and the points scored during this examination shall be included with the selected defects and point count scored for the entire specified sample size of the end item examination. The contractor shall clearly identify the units subjected to this measurement examination by stamping the identification/instruction label using indelible ink with a 1/2 inch stamp depicting a D.

<u>Lot size</u>	<u>Sample size</u>
Up thru 500	8
501 thru 3200	13
3201 thru 35,000	20
35,001 and up	32

TABLE V. Measurable defects 1/Group A - Army CoatsAlignment of Front Button or Buttonhole

Top front button or buttonhole of coat out of horizontal alignment with breast pocket flap button by more than 1/2 inch.

Lower front button or buttonhole of coat misplaced by more than 1/2 inch.

Pocket or Flap

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

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

Lapel or Collar

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

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

Lapel

Top edge of lapel and end of collar gapping more than 1/4 inch.

Sleeve

Sleeve too far front or back, i.e., front edge of sleeve away from center of lower flap button or center of pocket by more than 2 inches.

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TABLE V. Measurable defects 1/ (cont'd)

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Group A - Marine Corps CoatsAlignment of Front Button or Buttonhole

Top front button or buttonhole of coat out of horizontal alignment with breast pocket flap buttons by more than 1/2 inch.

Lower front button or buttonhole of coat misplaced by more than 1/2 inch.

Pocket or Flap

Out of alignment or misplaced by more than 3/16 inch.

Flaps not in horizontal alignment by more than 1/4 inch.

Lapel or Collar

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

Sleeve

Sleeve too far front or back, i.e., front creased edge of sleeve more than 2-1/2 inches or less than 1 inch behind center or forward of lower flap button.

Group A - Air Force CoatsAlignment of Front Button or Buttonhole

Top front button or buttonhole of coat out of horizontal alignment with breast pocket flap buttons by more than 1/2 inch.

Lower front button or buttonhole of coat misplaced by more than 1/2 inch.

Pocket or Flap

Out of alignment or misplaced by more than 3/16 inch.

Sleeve

Sleeve too far front or back, i.e., front edge of sleeve away from center of lower flap button or center of pocket by more than 2 inches.

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

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**5.2 Dimensional examination.** The appropriate number of dress coats specified below shall be examined for conformance to the dimensional requirements cited in the table of measurements of the applicable dress coat specification. When a measurement deviates from the dimension and tolerance specified, the dress coat shall be penalized one point. Each sample unit shall be penalized one point when the sleeves are uneven in length by 1/4 inch up to 3/8 inch, and two points when the sleeves are uneven in length by more than 3/8 inch. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value specified below. Each size of dress coat present in the lot should be represented in the sample selected for this examination.

Lot size	Sample size	Maximum acceptable point value
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 dress coat specification. 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 packaged. The lot shall be unacceptable if one or more points are scored for this examination.

Examine	Defect
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application
Materials	Any component missing, damaged, or not as specified
Workmanship	Inadequate application of components, such as incomplete sealing or closure of flaps, improper taping, loose strapping, or inadequate stapling Bulged or distorted container Open or noncontinuous heat sealed seams of polyethylene bag 1/
Content	Number of intermediate packages per shipping container is more or less than required

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Number of coats per intermediate package is more or less than required 2/  
 Size shown on one or more coats not as specified on shipping container 2/

Preservative (Naphthalene flakes) Improperly applied or missing 1/

1/ When applicable.

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

5.4 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirements
Palletization	Pallet pattern not as specified Interlocking of loads not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

5.5 Inspection procedures. Inspection procedures shall be as specified in MIL-STD-105, except where otherwise indicated in this standard.

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

5.7 Continuation of inspection. Normal, tightened, or reduced inspection shall continue unchanged on successive lots except where switching procedures in 5.8 require change.

#### 5.8 Switching procedures.

5.8.1 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).

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

5.8.3 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 sixty percent of the total ~~maximum~~ acceptable point values for 3 and 2 point defects from the preceding 10 lots; and
- c. The total number of points for 3, 2, and 1 point defects in the sample from the preceding 10 lots is equal to or less than seventy-five percent of the total ~~maximum~~ acceptable point values for 3, 2, and 1 point defects from the preceding 10 lots; and
- d. Production is at a steady rate; and
- e. Reduced inspection is considered desirable by the procurement quality assurance element administering the contract.

5.8.4 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 table II); or
- c. Production becomes irregular or delayed; or
- d. Other conditions warrant that normal inspection be instituted.

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## 6. NOTES

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

6.1 Intended use. This standard is intended to provide a standardized procedure for evaluating quality of dress coats procured by the Department of Defense.

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

6.3 Subject term (key word) listing.

Apparel  
Clothing  
Examination  
Inspection  
Outerwear  
PFEQ  
Uniform

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

## CONCLUDING MATERIAL

## Custodians:

Army - GL  
Navy - NU  
Air Force - 11

## Preparing activity:

Army - GL  
(Project 8405-0178)

## Review activities:

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

