

MIL-STD-1608C

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SUPERSEDING

MIL-STD-1608B

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



ANSC N/A

FSC 8410

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FOREWORD

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

2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, Natick, MA 01760-2490 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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

| <u>Specification</u> | <u>Title</u> |
|----------------------|---|
| MIL-C-21084(MC) | Coat, Woman's, Wool, Gabardine, Blue |
| MIL-C-21085(MC) | Coat, Women's Wool, Polyester/Wool |
| MIL-C-28922(MC) | Coat, Woman's, Summer, Green and White |
| MIL-C-29121(NU) | Coat, Woman's, Service, White |
| MIL-C-29124(NU) | Coat, Woman's, Blue, Dress |
| MIL-C-40143(GL) | Coats, Women's, Wool and Polyester/Wool |
| MIL-C-44101(GL) | Coat, Women's, Classic Design, Polyester/Wool |
| MIL-C-87160(USAF) | Coat, Women's, (Pants Suit) |
| MIL-U-28946(MC) | Uniform, Woman's; White; Dress (Officer's) |

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1. SCOPE

1.1 Scope. The scope of this standard is to provide standardized provisions for evaluating the quality of women's dress coats.

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

(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 listed in Table II as asterisk (*) defects. The selected asterisk defects are listed individually in Table III. The examination for selected defects will also include the measurement of those selected defects identified in Table IV.

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

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

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

2. REFERENCE DOCUMENTS

2.1 Government documents.

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

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STANDARD

FEDERAL

FED-STD-4 - Glossary of Fabric Imperfections

MILITARY

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

MIL-STD-109 - Quality Assurance Terms and Definitions

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

2.2 Other publications. The following document(s) form a part of this standard to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in DODISS shall be the issue of the nongovernment documents which is current on the date of the solicitation.

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

(Application for copies should be address to The American Association of Textile Chemists and Colorists, P.O. Box 12215, Research Triangle Park, NC 27709-9989).

(Nongovernment standards are generally available for reference from libraries. They are also distributed among nongovernment standards bodies and using Federal Agencies.)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this standard shall take precedence. Nothing in this standard, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. DEFINITIONS

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

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

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

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

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

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

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

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

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

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

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

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

3.8 Puckering. In the course of the sampling examination, seams suspected of being puckered shall be examined at a distance of 3 feet in comparison with the AATCC Photographic Comparative Rating (see 2.2), method 88B for seams. Puckering on a major portion of the suspected seam that equals or is worse than rating 3 for single needle seams or double needle seams shall be scored as a puckered seam.

4. GENERAL REQUIREMENTS

This section is not applicable to this standard.

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5. DETAIL REQUIREMENTS

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

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

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

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

5.5 Switching procedures.

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

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

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

(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

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(d) Production is at a steady rate; and

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

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

(a) A lot is rejected; or

(b) A lot is considered acceptable but exceeds the applicable first value (see NOTE to Table I); or

(c) Production becomes irregular or delayed; or

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

* 5.6 End item examination. The dress coats shall be buttoned on a model form or laid out flat on a table as required in Table II for inspection. The dress coats shall be examined and all defects shall be penalized as indicated in Table II of this standard. The sample size shall be as specified in Table I. The sample unit shall be one finished coat. The lot shall be unacceptable if:

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

OR

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

OR

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

* 5.6.1 Examination for measurable defects (Table IV). 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 IV. 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 IV. Additional dimensional measurements may be taken at any time in the remainder of the end item examination. The number of selected defects found and the points scored during this examination shall be included with the selected defects and point count scored for the entire specified sample size of the end item examination. The contractor shall clearly identify the units subjected to this measurement examination by stamping the identification/instruction label with a 1/2 inch stamp depicting a -D- using indelible ink.

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

5.7 Dimensional examination. The appropriate number of coats, determined from the Table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate coat specification. When a measurement deviates from a dimension and tolerance specified, the coat shall be penalized one point. Each sample unit shall be penalized one point when the sleeves are uneven in length by 3/8 inch or more.

The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point values. Each size of coat present in the lot shall be represented in the sample selected for this examination.

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

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

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

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

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TABLE I - SAMPLING PROVISIONS

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

NOTE: For the point values of the reduced inspection on 3 & 2 point defects. If the first value is exceeded, but the second value has not been exceeded, accept the lot but reinstate normal inspection (see 5.5.4b). The second value is the maximum acceptable point value.

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TABLE II - CLASSIFICATION OF DEFECTSA. GENERAL DEFECTS

| | <u>Point Value</u> |
|---|--------------------|
| I. PRESSING | |
| a. Pressing omitted (any specified operation) | 3 |
| b. Excess gloss | 1 |
| c. Edge bulky, i.e., not pressed solid | 1 |
| d. Lapel not roll pressed as specified | 1 |
| e. Sleeve not pressed as required | 1 |
| f. Armhole stretched | 2 |
| g. Armhole or shoulder not blocked | 2 |
| h. Inside of armhole not creased as required | 1 |
| i. Lining (except sleeve linings) not finish pressed | 1 |
| j. Any dart not pressed open or not pressed in the direction specified | 1 |
| k. Collar breakline not creased as specified | 1 |
| l. Wrinkles, creases or pressing impressions not removed | 1 |
| m. Any required seam not pressed open or not pressed smooth or flat for more than 1/2 inch | 1 |
| n. Finished pressed width of lapel not uniform (i.e. one side finishing 1/4 inch or more than other when measured across upper portion on horizontal, from forced out edge to lapel creaseline) | 2 |
| II. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES | |
| a. Hole, cut, tear, smash, visible mend, burn, scorched area or open place: | |
| 1. On outside | 3 |
| 2. On inside (longest dimension in any direction): | |
| (a) - up to 1/4 inch inclusive | 1 |
| (b) - more than 1/4 inch | 2 |
| b. Loose yarn, snagged thread, misweave, area of no dye penetration, dye streak, missing yarn, broken yarn, thin place, shade bar or woven in waste; more than 1/4 inch (largest dimension in any direction): | |
| 1. On outside | 2 |
| c. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching): | |
| 1. On outside | 2 |

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| | <u>Point Value</u> |
|---|--------------------|
| d. Needle chew on outside: | |
| 1. Up to 1/4 inch inclusive | 2 |
| 2. More than 1/4 inch | 3 |
| e. Knot or slub (see 3.2 on outside) | 1 |
| III. SHADED PART | |
| a. On outside: | |
| 1. Variation in shade between two or more parts (except parts which maybe cut from ends) | 3 |
| 2. Variation in shade within a part (except part which may be cut from ends) | 3 |
| 3. Part cut from ends badly shaded | 1 |
| b. On inside: | |
| 1. Any lining part badly shaded (except sleeve or hip linings) | 1 |
| 2. Sleeve or hip lining part badly shaded or pair not matching each other | 1 |
| IV. CLEANNESS | |
| a. Any spot or stain on outside (largest dimension in any direction): | |
| 1. Up to 3/8 inch inclusive | 1 |
| 2. More than 3/8 inch up to 3/4 inch inclusive | 2 |
| 3. More than 3/4 inch | 3 |
| b. Any marking exposed or visible on outside | 3 |
| c. Thread ends not trimmed: | |
| 1. Three or more on outside longer than 1/4 inch | 2 |
| 2. Five or more inside longer than 1/2 inch | 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 |

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| | <u>Point Value</u> |
|---|--------------------|
| V. COMPONENT AND ASSEMBLY | |
| a. Any component part or operation omitted (unless otherwise classified herein) | 3 |
| b. Any component not as specified (type, size, color, etc) | 3 |
| c. Any component part tight, twisted, distorted, pleated or full (unless otherwise classified herein) | 2 |
| d. Any operation not as specified (unless otherwise classified herein) | 1 |
| e. The edge of any component part required to be forced out having folds of more than 1/8 inch (unless otherwise classified herein) | 2 |
| VI. CUTTING | |
| a. Any component part not cut in accordance with specified pattern, directional line or pattern or in accordance with specifications requirement | 3 |
| b. Twill line of any outside part not running in specified direction | 3 |
| VII. SEAM AND STITCHING | |
| a. Accuracy of seaming: | |
| 1. Seam puckered (unless otherwise classified herein) | 1 |
| 2. Seam irregular, pleated or wavy (unless otherwise classified herein) | 2 |
| 3. Part of coat caught in any unrelated operation or stitching | 2 |
| 4. Blindstitching, tacking, or hand felling of armhole exposed on outside | 1 |
| 5. Machine felling or hand felling (other than around armhole) exposed on outside for a distance of 3/8 inch or more | 1 |
| 6. End of stitching when not caught in another seam or stitching not finished as specified | 1 |
| 7. Stitching overlapping end of thread break less than 1/2 inch | 1 |
| 8. End of a continuous line of stitching overlapped less than 1/2 inch or ends of label stitching overlapped less than 3 stitches | 1 |
| 9. Not specified color thread used on outside | 2 |
| 10. Needle perforations visible on outside | 2 |
| b. Gage of stitching and seam allowance: | |
| 1. Stitching irregular, not within range specified, or varies more than 1/16 inch when no range is specified (score only when condition exists on more than 1/2 the length of seam) | 1 |

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| | <u>Point Value</u> |
|---|--------------------|
| 2. Edge, top, or raised stitching sewn too close to edge resulting in damage to cloth | 3 |
| 3. Width of seam allowance varies more than 1/16 inch from allowance specified (score only when condition exists on more than 1/2 the length of seam) | 1 |
| c. Open seam (see 3.4 and 3.6): | |
| 1. On outside (excluding lower edge of undercollar): | |
| (a) - More than 3/4 inch | 3 |
| (b) - More than 1/2 inch up to 3/4 inch inclusive | 2 |
| (c) - Up to 1/2 inch inclusive | 1 |
| 2. On inside: Machine felling and hand felling (other than hand felling around armhole): | |
| (a) - More than 3/8 inch up to 2 inches (inclusive) | 1 |
| (b) - More than 2 inches | 2 |
| 3. On inside: Stitch type 301 and hand felling around armholes: | |
| (a) - Up to 2 inches inclusive | 1 |
| (b) - More than 2 inches | 2 |
| d. Raw edge: (see 3.7) | |
| 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 (excluding an edge that is not required to be turned under, pinked or overedged): | |
| (a) - 3/8 inch up to 2 inches inclusive | 1 |
| (b) - More than 2 inches | 2 |
| e. Seam and stitch type: | |
| 1. Not specified seam or stitch type | 3 |
| 2. Any line of stitching omitted or insecure | 2 |
| 3. Any line of stitching not beginning or ending where specified (unless otherwise classified herein) | 1 |
| 4. Looper thread or 401 stitch type on outside | 3 |

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| | <u>Point Value</u> |
|--|--------------------|
| f. Stitch tension: | |
| 1. Loose tension resulting in a loose seam | 3 |
| 2. Loosely exposed loops of lower or top thread on edge, top, or raised stitching | 2 |
| 3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching) | 3 |
| g. Stitches per inch (score only when condition exists on more than 1/2 the length of seam): | |
| 1. More than the maximum specified | 1 |
| 2. Less than the minimum specified: | |
| (a) - By one or two stitches | 1 |
| (b) - By three or more stitches | 2 |
| h. Runoff, skipped, or broken stitch: | |
| 1. Joining seam - use open seam classification | - |
| 2. Edge, top or raised stitching (more than 1/4 inch) | 1 |
| i. Bartack, backtack, tack, or tacking (except buttonhole bartack): | |
| 1. Missing, insecure, misplaced, not serving intended purpose, or not specified length or type | 2 |
| 2. Loose stitch tension | 1 |
| 3. Length not as specified by 1/16 inch or more | 1 |
| 4. Other than direction specified | 1 |
| VIII. BUTTONHOLE OR EYELET | |
| a. Misplaced or not positioned as specified | 3 |
| b. Omitted, added, not specified type or not finished as specified | 3 |
| c. Gimp omitted or ends of gimp not pulled thru to underside of cut first square bar buttonhole | 2 |
| d. Ragged edge, incomplete stitching, stitching not securely caught in fabric, bulky appearance, stitches not uniformly spaced or uncut stitches | 2 |
| e. Broken stitch or two or more skipped stitches | 2 |
| f. Buttonhole stitching extending beyond bartack | 2 |
| g. Bartack missing, loose or misplaced (not serving intended purpose) | 2 |
| h. Stitches per buttonhole, eyelet or bartack less than minimum number specified by: | |
| 1. One to three stitches | 1 |
| 2. Four or more stitches | 2 |

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| | <u>Point Value</u> |
|--|--------------------|
| i. Finished length or diameter not as specified | 2 |
| j. Tongue notch at one or both ends of piped buttonhole exposed, not securely tacked or bartacked on inside of raw edges exposed at corner | 3 |
| k. Piping uneven or not uniform in width by more than 1/16 inch | 1 |
| l. Width of piping not within tolerance specified or + 1/16 inch from required width when no tolerance is specified | 1 |
| m. Ends of piping spread apart or overlapped by more than 1/16 inch at one or both ends | 1 |
| n. Piping joining seam visible on outside of buttonhole | 1 |
| IX. BUTTON AND TOGGLE | |
| a. Omitted, broken or defective (see 3.5) | 2 |
| b. Out of horizontal or vertical alignment by: | |
| 1. 3/16 to 3/8 inch inclusive | 1 |
| 2. More than 3/8 inch | 2 |
| c. Misplaced, loose, not attached as specified or insecurely sewn | 1 |
| d. Shank wrapping (when required) omitted, loosely or insecurely wrapped, or not specified length | 2 |
| e. Part of garment pleated or puckered by button sewing | 1 |
| f. Stitch not locked at end of cycle (tug at the loose end of the thread when accessible to determine if it will ravel) | 2 |
| g. Tacking stitches omitted or insecure (hand sewn) | 2 |
| X. SNAP FASTENER | |
| a. Omitted, loose, broken, defective, or mismatched | 2 |
| b. Misplaced, not positioned or attached as specified | 1 |
| c. Tacking stitches omitted or insecure on one or more hand sewn fasteners | 1 |
| d. Stud and socket not aligned, causing bulge or twist on component or coat when fastened | 2 |
| e. Attachment stitches exposed on outside | 1 |
| Note: Stud and socket shall be checked for proper and secured by opening and closing fasteners several times. | |
| XI. FUSIBLE | |
| a. Omitted | 3 |
| b. Twisted, causing puckers or pleat on outside of parts which are fused | 3 |
| c. Any evidence of bleed through, delamination, bubbling or color change | 3 |

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COAT BUTTONED ON FORM

| | <u>Point Value</u> |
|--|--------------------|
| XII. POSITION AND ALIGNMENT OF FRONT, BACK, BUTTON OR BUTTONHOLE | |
| a. Top or lower button or buttonhole misplaced or not positioned as specified by: | |
| 1. 3/8 to 1/2 inch inclusive | 3 |
| 2. More than 1/2 inch | * |
| <u>For MIL-C-44101(GL) only:</u> | |
| 3. More than 1/8 to 1/4 inch higher than specified | 2 |
| 4. More than 1/4 to 1/2 inch higher than specified | 3 |
| 5. Lower than specified, or more than 1/2 inch higher than specified | * |
| b. Button and buttonhole not aligned, causing a bulge or twist on front | 3 |
| c. Spacing between front buttonholes varying more than 1/4 inch | 1 |
| d. Buttonholes unequally spaced from edge by 1/8 inch or more | 1 |
| e. Right front below bottom button swings to the right or left, when measured as a straight line extension of the front edge by more than 1/2 inch | 1 |
| f. Back shorter or longer than front by more than 1/2 inch | 3 |
| XIII. FRONTS | |
| a. Length: | |
| 1. With fronts buttoned or with buttonhole and corresponding eyelet in left front superimposed: | |
| (a) - Right front shorter than left front at bottom by: | |
| (1) - 1/8 to 1/4 inch inclusive | 2 |
| (2) - More than 1/4 inch | * |
| (b) - Right front longer than left front at bottom corner by: | |
| (1) - 1/8 to 1/4 inch inclusive | 2 |
| (2) - More than 1/4 inch | * |
| (c) - Left front at bottom corner exposed beyond bottom edge of right front by more than 1/8 inch | 2 |
| 2. Unbuttoned fronts uneven in length by 3/8 inch or more | 3 |

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| | <u>Point Value</u> |
|--|--------------------|
| b. Facing, front and bottom edges: | |
| 1. Front rolling outward below bottom button | 3 |
| 2. Facing tight, short, or twisted causing fullness or twist on fronts | 3 |
| 3. Front or bottom edge stretched, bulky or irregular | 1 |
| 4. Bottom corner or right front misshapen or distorted | 1 |
| 5. Facing full; lapel will not lie smooth and flat | 3 |
| 6. Facing exposed beyond front or bottom edge by more than 1/16 inch for a distance of more than 1 inch | 1 |
| 7. Bust curve or waist suppression not uniform on both fronts | 2 |
| 8. Right front edge indented opposite a buttonhole | 1 |
| XIV. POCKET, WELT, OR FLAP | |
| a. Misshapen or distorted - any point varying; | |
| 1. More than 1/4 inch with corresponding point on finished shaper | * |
| 2. 1/8 inch up to 1/4 inch (inclusive) with corresponding point on finished shaper | 3 |
| b. Not uniform in size or shape; any point varying more than 1/4 inch with corresponding point on matching part | 3 |
| c. Out of alignment in any direction or misplaced at any point by: | |
| 1. More than 3/8 inch | * |
| 2. More than 1/4 up to 3/8 inch inclusive | 3 |
| 3. More than 1/8 up to 1/4 inch inclusive | 2 |
| d. Side not parallel with front edge of coat by more than 1/4 inch | 1 |
| e. Twisted, puckered, or too full; pocket, welt or flap will not lie smooth or flat | 2 |
| f. Finished length, width, or depth not within tolerance specified | 1 |
| g. Lining or underside exposed beyond edge of patch pocket or flap more than 1/16 inch | 2 |
| h. Double welt pocket gapping by more than 1/4 inch or overlapping each other by more than 1/16 inch at any point | 1 |
| i. Notch or raw edge at corner exposed at end of welt or tongue notch not securely caught in the row of stitching or bartack of welt | 3 |
| j. Pocket opening too tight, i.e., fullness or puckering in side front or fuller than side front | 3 |
| k. Corners insecurely backtacked | 2 |

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| | <u>Point Value</u> |
|---|--------------------|
| 1. Top edge of raise stitching on welt through the underply of pocket | 3 |
| m. Corner tacks (when applicable) misplaced, omitted or not serving intended purpose | 2 |
| XV. COLLAR OR LAPEL | |
| a. Misshapen or distorted - any point varying: | |
| 1. More than 1/4 inch with corresponding point on finished shaper | * |
| 2. 1/8 inch up to 1/4 inch (inclusive) with corresponding point on finished shaper | 3 |
| b. Not uniform in size or shape - any point varying: | |
| 1. More than 5/16 inch with corresponding point on matching part | * |
| 2. More than 1/4 inch but not more than 5/16 inch with corresponding point on matching part | 3 |
| 3. More than 1/8 inch but not more than 1/4 inch with corresponding point on matching part | 2 |
| c. Twisted, short, tight or long, i.e., causing curled edges, puckering, fullness, or pleat on one or more collar or lapel parts or in seamline joining parts | 3 |
| d. Collar (top, under, or stand): | |
| 1. Collar off center at front by 1/4 inch or more with shoulder seamlines matching | 2 |
| 2. Collar edge or piping crooked, irregular or wavy | 2 |
| 3. Gorge seam not spread open (any portion), not straight, tacking insecure or tacking omitted | 1 |
| 4. Gorge seam length not uniform by 1/4 inch or more | 1 |
| 5. Undercollar exposed beyond collar edge by more than 1/16 inch or for a distance of more than 1 inch | 1 |
| 6. Center seam of undercollar not aligned with center seam of coat by more than 1/4 inch | 2 |
| 7. Undercollar joining seamline exposed below edge of collar across back | 3 |
| 8. Width not within tolerance specified of 1/4 inch from required width when no tolerance is specified | 2 |

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| | <u>Point Value</u> |
|---|--------------------|
| 9. Length of collar ends not within tolerance specified or (+) 1/4 inch from required length when no tolerance is specified | 2 |
| 10. Back end of gorge seam machine stitched less than 1 inch back of lapel breakline | 1 |
| 11. Breakline on undercollar not stitched, when required | 1 |
| 12. Collar interlining tight or twisted, causing puckers on undercollar | 1 |
| 13. Piping omitted | 3 |
| 14. Collar rolling up above breakline by: | |
| (a) - 1/8 inch up to 3/16 inch inclusive | 3 |
| (b) - More than 3/16 inch | * |
| e. Lapel | |
| 1. Gap between top edge of lapel and end of collar or overlap of collar end on lapel step on one side of coat not uniform with other side of coat by: | |
| (a) - 1/8 inch up to 1/4 inch inclusive | 2 |
| (b) - More than 1/4 up to 5/16 inch inclusive | 3 |
| (c) - More than 5/16 inch | * |
| 2. Front part of coat exposed by more than 1/16 inch or for a distance of more than 1/2 inch on step or front edge of lapel | 2 |
| 3. Length of lapel step not within tolerance specified or (+) 1/4 inch from required length when no tolerance is specified | 2 |
| 4. Bridle tape not held taut causing breakline to finish flat or to be misplaced (i.e. tape extending beyond breakline on lapel side) | 3 |
| 5. Fullness (not smooth and flat) | 2 |
| 6. Bridle tape misplaced: | |
| (a) - At gorge: | |
| (1) - more than 3/8 inch behind lapel breakline | 3 |
| (2) - Bridle tape basted onto or extending beyond breakline on lapel side | * |
| (3) - More than 5/8 inch behind lapel breakline | * |
| (b) - At 1-1/2 inches from lapel bottom: | |
| (1) - more than 5/8 inch behind lapel breakline | 3 |
| (2) - bridle tape basted onto or extending beyond breakline on lapel | * |
| (3) - bridle tape more than 7/8 inch behind lapel breakline | * |
| (c) - Bridle tape end not within 1 to 1-1/2 inches from bottom of lapel | 2 |

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| | <u>Point Value</u> |
|--|--------------------|
| XVI. SHOULDERS | |
| a. Improperly joined or set, causing shoulder or back to twist | 3 |
| b. Shoulder seamline curved towards back from normal position at armhole end by: | |
| 1. More than 3/8 inch | 2 |
| 2. 1/4 inch up to 3/8 inch inclusive | 1 |
| c. Vertical seamlines on front and back of coat staggered 1/4 inch or more at shoulder seamline | 2 |
| XVII. SHOULDER PAD | |
| a. Not properly set, causing shoulder to twist, pucker, or bulge | 3 |
| b. Misplaced, not serving intended purpose, i.e., too far back or too far forward, not completely or securely caught in armhole tacking | 3 |
| XVIII. SHOULDER STRAP (LOOP) | |
| a. Not uniform in size or shape, any point varying: | |
| 1. More than 3/8 inch with corresponding point on matching prt | 3 |
| 2. 1/4 inch up to 3/8 inch inclusive with corresponding point on matching part | 2 |
| b. Length or width not within tolerance specified or 1/4 inch when no tolerance is specified | 2 |
| c. Misplaced so that shoulder seamline is exposed | 3 |
| d. Set upside down exposing underside seamline | 3 |
| e. Strap will not lie flat, twists, or bulges when buttoned, fastened, or tacked | 2 |
| f. Piped edge is puckered, wavy, or irregular in width | 1 |
| g. Poorly shaped | 1 |
| h. One strap further forward or backward of the shoulder seamline from position of other strap by more than 1/4 inch | 2 |
| i. End of strap not positioned within tolerance specified or 1/8 inch when no tolerance is specified from finished edge of collar or undercollar neck joining seamline | 2 |
| j. Ends of both shoulder straps unequally placed from finished edge of collar or undercollar neck joining seamline by more than 1/4 inch | 2 |
| k. Button partially or fully covered by collar when specified not to be covered | 1 |

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| | <u>Point Value</u> |
|--|--------------------|
| XIX. ARMHOLE | |
| a. Stretched causing excessive fullness on back between shoulder and underarm | 3 |
| b. Crooked or puckered seamline | 2 |
| c. Tape or armhole tacking stitches visible on outside | 2 |
| d. Armhole not tacked as specified | 2 |
| XX. SLEEVE HEAD WADDING | |
| Not tacked to armhole as specified, omitted when specified, tacking incomplete, insecure, misplaced, or not serving intended purpose | 2 |
| XXI. SLEEVE | |
| a. Set improperly, sleeve hangs with break or twist | * |
| b. Sleeve reversed, i.e., right sleeve set in left armhole | 3 |
| c. Fullness misplaced or concentrated in one area | 3 |
| d. Tight at armholes, i.e., roll effect not present on front or back of sleeve | 3 |
| e. Front edge of sleeve either too far front or too far back when measured from its normal hanging position by: | |
| 1. More than 2 inches | 3 |
| 2. More than 1 inch up to 2 inches inclusive | 2 |
| f. Lining too long, extends below bottom edge of sleeve or bags below felling to sleeve hem by 1/2 inch or more | 1 |
| g. Wigan twisted, tight or pleated causing puckering on outside of sleeve | 2 |
| h. Underarm sleeve seamline not aligned with side seamline by 1/4 inch or more, or not aligned uniformly with side seams by 1/4 inch or more | 2 |
| i. Backarm seamlines unequal distance from shoulder seamlines or forearm (inseam) seamlines unequally spaced from side seamlines by more than 3/8 inch | 1 |
| j. Bottom edge of sleeve uneven by: | |
| 1. 1/4 inch to 3/8 inch inclusive | 1 |
| 2. More than 3/8 inch | 2 |
| k. Tacking of sleeve lining seam to sleeve seam omitted, insecure or incomplete | 1 |
| l. Bottom edge of braid from bottom of sleeve not within tolerance specified or (+) 1/4 inch from required distance when no tolerance is specified | 2 |

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| | <u>Point Value</u> |
|---|--------------------|
| m. Edges of braid at backarm seam staggered: | |
| 1. 1/8 inch to 1/4 inch inclusive | 1 |
| 2. More than 1/4 inch | 2 |
| n. Sleeve lining twisted, tight, or short causing fullness or twist on outside of sleeve | 3 |
| o. Braid stitched too tightly to sleeves causing puckers; or stitched too loosely causing puckers or pleat on braid | 2 |
| XXII. SLEEVE CUFF (Regular and Ornamental) | |
| a. Full, tight, puckered, or twisted | 2 |
| b. Point of cuff not uniformly shaped or not forced out to a sharp point | 2 |
| c. Uneven in width or cuffs not uniform in width by 1/4 inch or more | 1 |
| d. Sleeve seamline in cuff not aligned with sleeve seamline above cuff by 1/4 inch or more | 1 |
| e. Top edge of cuffs at backarm or underarm seamline staggered more than 1/8 inch | 2 |
| f. Finished height of cuff at point, backarm seamline or forearm seamline not as specified | 2 |
| g. Ornamental piece poorly shaped, set on crooked or misplaced | 2 |
| h. Edge of cuff irregular by 1/8 inch or more | 2 |
| i. Flat part (stitch portion) of tubular braid exposed on edge of cuff for a length of 1/4 inch or more | 1 |
| j. Piping omitted | 3 |
| XXIII. FITTING | |
| a. Body lining: | |
| 1. Tight, short, or twisted causing fullness or twist on outside of coat | 3 |
| 2. Lining too long, exposed beyond bottom edge of coat | 2 |
| b. Interlining: | |
| 1. Tight, short, or twisted causing fullness or twist on outside of coat | 3 |
| 2. Too full, causing front to have a wavy appearance or not lie smoothly | 3 |

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| | <u>Point Value</u> |
|---|--------------------|
| XXIV. DART OR PLEAT | |
| a. Omitted | 3 |
| b. Dart not tapered to a point causing bulge on outside | 2 |
| c. Corresponding darts unequal in length by more than 1/2 inch | 2 |
| d. Fold not facing direction specified | 1 |
| e. Darts or pleats not uniformly positioned | 2 |
| f. Not pressed flat | 1 |
| g. Length, depth, location, or construction other than specified | 2 |
| XXV. BINDING, CORD, BRAID, OR PIPED EDGE | |
| a. Tight or loose causing puckered, curled or wavy edge | 3 |
| b. Width not as specified | 1 |
| c. Edge not properly forced out | 1 |
| d. Not securely caught to fabric | 2 |
| XXVI. BOTTOM HEM | |
| a. Twisted, puckered, or pleated | 2 |
| b. Irregular in width by more than 1/4 inch | 1 |
| c. Finished width not within tolerance specified or 1/4 inch from width required when no tolerance is specified | 1 |
| d. Seam lines in hem turnup not aligned with coat seam lines by more than 1/4 inch | 1 |
| XXVII. BELT | |
| a. Not attached or positioned as specified | 3 |
| b. Misshappen, twisted, or distorted | 2 |
| XXVIII. VENT AND VENT OPENING | |
| a. Left vent edge stretched or not properly constructed causing vent to spread open | 3 |
| b. Left vent edge crooked or irregular; or vent lining or tape short or twisted, causing fullness on outside | 2 |
| c. Left vent longer or shorter than right vent by: | |
| 1. 1/4 inch to 1/2 inch inclusive | 1 |
| 2. More than 1/2 inch | 2 |
| d. Diagonal row of stitching across top of vent omitted | 2 |
| e. Vent not topstitched as specified | 1 |
| f. Felling on bottom corners of lining and vent omitted or not secure | 2 |
| g. Bottom turn-up exposed or visible on left vent edge | 1 |

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| | <u>Point Value</u> |
|---|--------------------|
| XXIX. INSIDE POCKET | |
| a. Tacking on front edge of pocket to interlining omitted or insecure | 2 |
| b. Width of opening or depth of pocket not within tolerances specified | 1 |
| c. Opening gapped by more than 1/4 inch or welts overlapped by more than 1/16 inch at any point | 1 |
| XXX. SHIELDS | |
| a. Tacking of lower edge omitted, insecure or not located as specified | 1 |
| b. Finished length or width not within tolerance specified or 1/4 inch from required measurement when no tolerance is specified | 1 |
| c. not positioned as specified by more than 1/2 inch | 2 |
| d. One or both, omitted | 2 |
| e. Top edge not securely caught in armhole tacking or stitching | 1 |
| f. Puckered, pleated or twisted | 1 |
| g. Top or bottom raw edge of binding on shield (when applicable) not turned under and caught in stitching | 1 |
| h. Binding (when applicable) omitted on one or both armhole shields | 2 |
| i. Binding (when applicable) not securely stitched to fabric | 1 |
| XXXI. HANGER | |
| a. Omitted or insecure | 2 |
| b. Misplaced 1/2 inch or more off center with center back | 1 |
| c. Finished length not as specified by more than 1/2 inch | 1 |
| d. Not specified type or construction | 1 |
| e. Spread of hanger loop not as specified by more than 1/2 inch | 1 |
| XXXII. LABEL | |
| a. Missing, incorrect, or illegible: | |
| 1. Size, instruction, or combination label | 3 |
| 2. Identification label | 1 |
| b. Not attached as specified or location incorrect | 1 |
| c. Stitching through printing | 1 |
| d. Misplaced by more than 1/2 inch from location specified | 1 |

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| | <u>Point Value</u> |
|---|--------------------|
| XXXIII. FACING | |
| a. Vertical tacking of hip facing to back side seam allowance extending less than 1/2 inch or more than 3/4 inch from top of hip facing | 1 |
| XXIV. LINING (FRONT AND BACK) | |
| a. Felling on lower back edge of facing or bottom front end of lining omitted | 1 |
| b. Not securely tacked at side seam or shoulder seam | 1 |
| c. Twisted or full but not affecting smoothness on outside | 1 |
| d. Center back pleat at top omitted | 2 |
| e. Bellows on bottom edge omitted | 2 |
| XXXV. INSTRUCTION TAG | |
| a. Missing, incorrect, or illegible | 1 |
| b. Not attached as specified | 1 |
| XXXVI. PINKING | |
| Omitted on bottom of sleeves or sleeve lining | 1 |

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TABLE III - SELECTED DEFECTS

ALIGNMENT OF FRONT, BUTTON OR BUTTONHOLE

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

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Top front button or buttonhole misplaced lower or more than 1/2 inch higher than specified.

LENGTH OF BUTTONED COAT

Right front shorter or longer than left front at bottom by more than 1/4 inch.

POCKET, WELT, OR FLAP

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

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

LAPEL OR COLLAR

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

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

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

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

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

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

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

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

SLEEVE

Set improperly, sleeve hangs with break or twist.

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* TABLE IV. MEASUREABLE DEFECTS 1/ALIGNMENT OF FRONT BUTTON OR BUTTONHOLE

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

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Top front button or buttonhole misplaced lower or more than 1/2 inch higher than specified.

POCKET OR FLAP

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

LAPEL OR COLLAR

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

SLEEVE

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

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

6. INFORMATION FOR GUIDANCE ONLY

* 6.1 Intended use. The coats are intended for use by female military personnel of the Department of Defense. The coats are to be worn as part of the Dress uniform.

* 6.2 Subject term (key word) listing.

Coat, uniform
Coat, dress
Quality assurance
Uniform, woman

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

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Army - GL
Air Force - 11

Preparing activity:

Navy - NU

Project No. 8410-0682

Review activities:

Navy - MC
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