

INCH-POUND

MIL-STD-1609C

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SUPERSEDING

MIL-STD-1609B

31 January 1984

MILITARY STANDARD  
PROVISIONS FOR EVALUATING QUALITY  
OF WOMEN'S SKIRTS



AMSC N/A

FSC 8410

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### FOREWORD

1. This specification 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 provides a standardized procedure for evaluating the quality of skirts procured for the Department of Defense. It is intended to list in a single document, defects irrespective of fabrics (i.e. wool or polyester/wool) or end use.
4. The objectives of this standard are to:
  - a. Provide standard descriptions for skirt defects.
  - b. Standardize examination requirements.

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

<u>MILITARY SPECIFICATION</u>	<u>CLASSIFICATION</u>	<u>TITLE</u>
MIL-S-21087(MC)	D	Skirt, Women's Wool, Polyester/Wool
MIL-U-28946(MC)	D	Uniform, Woman's, White, Dress (Officer's)
MIL-S-29122(NU)	D	Skirt, Woman's, Blue, Dress
* MIL-S-29376(MC)	D	Skirt, Woman's Maternity
* MIL-S-29394(MC)	D	Skirt, Women's, Evening Dress, U.S. Marine Band (Musicians)
* MIL-S-29429(MC)	D	Skirt, Women's
* MIL-S-29629(NU)	D	Skirt, Woman's (With Welt Pockets)
* MIL-S-44102	D	Skirt, Woman's, Classic Design, Polyester/Wool
MIL-S-82126(MC)	D	Skirt, Women's, Evening and Mess Dress
MIL-S-83234(USAF)	D	Skirts, Women's Blue
* MIL-S-87053(NU)	D	Skirt, Woman's, Belted
 <u>PURCHASE DESCRIPTION</u>		
* PD AESC 85-3	D	Skirt, Women's, Blue

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## 1. SCOPE

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

1.2 Application. This standard will be made applicable to contracts by reference in the appropriate skirt specifications. These specifications require:

(a) As a final step in the contractor's production control plan before formation of a lot, each skirt shall be laid flat and smooth on a table and examined for selected defects and

(b) Any skirt containing a selected defect shall not be included in the end item lot. Selected defects are those defects listed in Table IV which are identified by an asterisk (\*) in the Point Value column. The selected defects (\*) are also listed individually in Table V.

## 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 shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

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

\* 2.2 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. The fabric defect definitions applicable to the standard are described in FED-STD-4 and MIL-STD-1491. All other defect descriptions in this standard are intended to be self-explanatory.

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 skirts.

3.3 Quality assurance terms. 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 runoff, or when two or more continuous skipped stitches occur. On a double stitched seam, a seam is considered open when either side is open.

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

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

Outside - Any part of the skirt that is visible when the skirt is laid flat on a table.

Inside - Any part of the skirt that is not visible when the skirt is laid flat on a table.

3.7 Defective button. A button shall be considered defective when it has a sharp, rough, cracked or split edge; scratched, nicked, gouged, pitted or rough surface; imbedded foreign matter; mottled or badly shaded.

3.8 Puckering. In the course of the sampling examination, seams suspected of being puckered shall be examined at a distance of 3 feet in comparison with the AATCC photographic comparative rating (see 7.2) 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.

## 4. GENERAL REQUIREMENTS

This standard contains the provisions for end item examination, dimensional examination and the packaging inspection requirements for dress, semi-dress, and utility skirts. If there are any inconsistencies between the requirement of the appropriate skirt specification and the provision of the standard, the specification shall control.

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This standard assigns to the listed defects, point values of 1, 2, or 3 depending on severity. The higher point values are assigned to those defects having the more detrimental effect on the appearance or serviceability of the item.

The defects indicated by an asterisk (\*) in the point value column in Table IV are those defects having the most detrimental effect on the appearance or serviceability of the item.

Citation of specifications under Table IV defect classifications is for convenience only and may not include all current specifications to which these classifications apply.

## 5. SAMPLE AND INSPECTION PROVISIONS

\* 5.1 End item examination. The skirt shall be examined and all defects shall be penalized as indicated in Table IV of this standard. "D" signifies dress skirts. "SD" signifies semi-dress skirts. "U" signifies utility skirts. The sample size based on lot size, and the acceptance values for selected defects, 3 and 2 point defects, and total (3, 2, and 1 point) defects shall be as specified in Tables I, II, or III as applicable. The sample unit shall be one finished skirt. 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 this sample size (see Table I).

5.2 Dimensional examination. The appropriate number of skirts, determined from the table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate skirt specification. When a measurement deviates from a dimension and tolerance specified, the skirt shall be penalized one point. The lot shall be unacceptable if the total point value resulting from this examination exceeds the maximum acceptable point value. Each size skirt present in the lot should be represented in the sample selected for this examination.

<u>Lot Size</u>	<u>Sample Size</u>	<u>Maximum Acceptable Point Value</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



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\* 5.3 Examination of packaging requirements. An examination shall be made to determine that packaging, packing, and marking comply with Section 5 requirements of this standard. Defects listed below shall be scored one point. The sample size for this examination shall be five shipping containers fully prepared for delivery. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot shall be unacceptable if one or more points are scored for this examination.

<u>Examine</u>	<u>Defect</u>
Marking (exterior and interior)	Omitted, incorrect, illegible, of improper size, location, sequence, or method of application.
Materials	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.
	Open and noncontinuous heat sealed seams and closure of polyethylene bag <u>1/</u>
	Omission of vent hole in polyethylene bag <u>1/</u>
	Alternative polyethylene bag not provided with tuck or reverse flap <u>1/</u>
	Incorrectly fabricated bag <u>1/</u>
Content	Number of unit packages, bundles, or intermediate packages per shipping container is more or less than required.
	Number of skirts per bundles or intermediate package is more or less than required <u>2/</u>
	Size shown on one or more skirts not as specified on shipping container. <u>2/</u>
Preservation (Naphthalene flakes)	Improperly applied or missing. <u>1/</u>

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1/ When applicable.

2/ For this defect, one bundle or intermediate package from each shipping container in sample shall be examined.

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## 6. INSPECTION

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

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

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

6.4 Switching procedures.

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

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

6.4.3 Normal to reduced. When normal inspection is in effect, reduced inspection shall be instituted providing 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.

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

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

7. NOTES

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

\* 7.1 Intended use. This document is intended to provide a standardized description of defects and examination requirements for evaluating the quality of woman's skirts procured for the Department of Defense.

7.2 The AATCC Photographic Comparative Rating of Single and Double Needle Seams (Method 88B, 2 photos) is available from:

The American Association of Textile Chemists and Colorists  
P.O. Box 12215  
Research Triangle Park, NC 27709-2215

\* 7.3 Changes from previous issue. The margins of this standard 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.

\* 7.4 Subject term (key word) listing.

Defects, classification of  
Defects, clothing  
Defects, fabric  
Defects, women's skirts  
Uniform, dress  
Uniform, semi-dress  
Uniform, utility  
Uniform, woman's

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TABLE I - Sampling Provisions for Dress ("D") Skirts

		Sample Size	Maximum Acceptance Number for Selected Defects (see 5.1c)	Maximum Acceptable Point Values	
Lot Size				3&2 point Defects	1/ 3, 2 & 1 point Defects
Normal Inspection	Up thru 90	20	0	4 points	10 points
	91 thru 150	32	0	6 points	15 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	26 points	54 points
	3201 thru 10,000	315	2	35 points	79 points
	10,001 thru 35,000	500	3	51 points	117 points
	35,001 and over	800	5	79 points	180 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	15 points
	281 thru 500	80	0	10 points	21 points
	501 thru 1200	125	1	15 points	31 points
	1201 thru 3200	200	1	20 points	47 points
	3201 thru 10,000	315	2	30 points	67 points
	10,001 thru 35,000	500	3	46 points	101 points
	35,001 and over	800	5	70 points	153 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	9-14 points	22 points
	1201 thru 3200	80	0	11-19 points	35 points
	3201 thru 10,000	125	1	19-27 points	47 points
	10,001 thru 35,000	200	1	22-31 points	87 points
	35,001 and over	315	2	31-41 points	101 points

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

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TABLE II - Sampling Provisions for Semi-Dress ("SD") Skirts

	<u>Lot Size</u>	<u>Sample Size</u>	<u>Maximum Acceptable Point Values</u>	
			<u>3&amp;2 point 1/ Defects</u>	<u>3,2 &amp; 1 point Defects</u>
Normal Inspection	Up thru 500	50	11 points	22 points
	501 thru 1200	80	13 points	31 points
	1201 thru 3200	125	21 points	41 points
	3201 thru 10,000	200	29 points	60 points
	10,001 thru 35,000	315	40 points	90 points
	35,001 and over	500	61 points	135 points
Tightened Inspection	Up thru 500	50	9 points	18 points
	501 thru 1200	80	12 points	27 points
	1201 thru 3200	125	14 points	36 points
	3201 thru 10,000	200	23 points	52 points
	10,001 thru 35,000	315	35 points	79 points
	35,001 and over	500	52 points	117 points
Reduced Inspection	Up thru 1200	32	5-13 points	23 points
	1201 thru 3200	50	9-18 points	31 points
	3201 thru 10,000	80	15-23 points	41 points
	10,001 thru 35,000	125	21-29 points	60 points
	35,001 and over	200	29-37 points	90 points

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

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TABLE III - Sampling Provisions for Utility ("U") Skirts

		Sample Size	Maximum Acceptable Point Values	
Lot Size			3 & 2 Point <u>1/</u> Defects	3,2 & 1 Point Defects
Normal Inspection	Up thru 500	50	13 points	24 points
	501 thru 1200	80	21 points	33 points
	1201 thru 3200	125	29 points	45 points
	3201 thru 10,000	200	40 points	66 points
	10,001 and over	315	61 points	99 points
Tightened Inspection	Up thru 500	50	11 points	18 points
	501 thru 1200	80	13 points	27 points
	1201 thru 3200	125	21 points	36 points
	3201 thru 10,000	200	29 points	53 points
	10,001 and over	315	40 points	79 points
Reduced Inspection	Up thru 1200	32	10-18 points	21 points
	1201 thru 3200	50	14-22 points	30 points
	3201 thru 10,000	80	21-29 points	40 points
	10,001 and over	125	29-37 points	52 points

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

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TABLE IV - Classification of Defects

Defect	Point Value		
	D	SD	U
<u>I. Material Defect and Damage</u>			
a. Hole, cut, tear, smash, mend, burn, drill hole, run, multiple float, scorched area, or open place:			
1. On outside.	3	3	3
2. On inside (longest dimension in any direction):			
(a) - up to 1/4 inch inclusive.	1	1	1
3. (b) - more than 1/4 inch.	2	2	2
b. Missing yarn, broken yarn, thin place, shade bar, misweave, woven in waste, loose yarn, snag, barre, uneven knitting, area of no dye penetration or dye streak; more than 1/2 inch (largest dimension in any direction) on outside.	2	2	2
c. Knot or slub (see 3.2 on outside).	1	1	1
d. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching) on outside.	3	3	3
e. Needle chew on outside:			
1. Up to 1/4 inch inclusive.	2	2	1
2. More than 1/4 inch.	3	3	3
<u>II. Shaded Part</u>			
a. Variation in shade within an outside part or between outside parts (except parts which may be cut from ends).	3	2	1
b. Any part cut from ends which does not approximate shade of skirts.	1	1	1
c. Any part required to be cut from one piece of material shaded.	3	3	2
<u>III. Cleanness</u>			
a. Spot or stain on outside visible at 3 feet (largest dimension in any direction):			
(a) - up to 3/8 inch inclusive.	1	1	1
(b) - more than 3/8 inch.	2	2	1

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TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
III. <u>Cleanness</u> (cont'd)			
b. Any marking exposed or visible on outside.	3	3	1
c. More than three thread ends not trimmed to 1/4 inch or less on outside.	2	2	1
d. More than five thread ends not trimmed to 1/2 inch or less on inside.	1	1	1
e. Two or more shade or size tickets not removed.	1	1	1
IV. <u>Cutting.</u>			
a. Any component not cut in conformance with specified patterns, directional lines on patterns or not in accordance with specification requirements.	3	3	3
V. <u>Component Assembly</u>			
a. Any component part omitted or required operation omitted (unless otherwise classified).	3	3	3
b. Any component part twisted, distorted, pleated, misshaped, tight or full (unless otherwise classified).	2	2	2
c. Any component not as specified.	3	3	3
d. Any operation not as specified (unless otherwise classified).	1	1	1
e. The edge of any component part required to be forced out having folds of more than 1/8 inch (unless otherwise classified).	2	2	1
VI. <u>Pressing</u>			
a. Omitted.	3	3	3
b. Excess gloss.	1	1	1
* c. One or more skirt or lining seams, including ends, not pressed open or pressed to one side (as applicable)	2	1	1
d. Dart(s) or any seam(s) not pressed flat on outside.	1	1	1
e. Poorly pressed:			
1. On permanent crease or durable press.	3	3	3
2. On other than permanent crease or durable press.	2	1	1
f. Permanent crease (other than specified).	3	3	3



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TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
VII. <u>Seams and Stitching</u>			
a. Accuracy of seaming.			
1. Seam irregular, twisted, pleated, or wavy (unless otherwise classified herein).	2	1	1
2. Seam puckered (score only when on major portion of seam) (see 3.8).	1	1	1
3. Any part of skirt caught in an unrelated operation or stitching.	3	2	2
4. End of stitching when not caught in other seam or stitching not backtacked as specified.	1	1	1
5. Thread break not secured back of break or stitched back of break less than 1/2 inch.	1	1	1
6. Ends of a continuous line of stitching not overlapped as specified.	1	1	1
7. Not specified color thread or various shades used on outside of skirts.	3	2	1
b. Gage of stitching and seam allowance:			
1. Gage irregular or not within range specified or varies more than 1/16 inch when no range is specified (score only when condition exists on more than 1/2 the length of the seam).	1	1	1
2. Edge top or raised stitching sewn too close to edge, resulting in damage to cloth.	3	2	2
3. Seam allowance not as specified by 1/16 inch or more (score only when condition exists on more than 1/2 the length of the seam).	2	2	2
c. Open seam.			
1. On outside (except bottom hem):			
(a) - up to 1/2 inch inclusive.	1	1	1
(b) - more than 1/2 inch up to 3/4 inch inclusive.	2	2	2
(c) - more than 3/4 inch.	3	3	3
2. Bottom hem more than 3/8 inch.	1	1	1
3. On inside:			
(a) - more than 3/8 inch up to 2 inches inclusive.	1	1	1
(b) - more than 2 inches.	2	2	2
d. Runoff.			
1. On joining seam score as open seam.	-	-	-
2. Edge, top or raised stitching.	1	1	1

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TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
VII. <u>Seams and Stitching</u> (cont'd)			
e. Raw edge. 1/ (see 3.5)			
1. On outside:			
(a) - Up to 1/2 inch inclusive.	1	1	1
(b) - More than 1/2 inch up to 3/4 inch inclusive.	2	2	2
(c) - More than 3/4 inch.	3	3	3
2. On inside:			
(a) - 1/2 inch up.	1	1	1
f. Seam and stitch type:			
1. Not specified seam or stitch type.	2	2	2
2. Looper thread of 401 or 406 stitch type on outside.	3	3	3
3. Any required line of stitching omitted or not secure.	2	2	2
4. Any line of stitching not beginning or ending where specified (unless otherwise classified herein).	1	1	1
g. Broken stitch on edge, top or raised stitching when seam is seamed, turned and stitched:			
1. Up to 3/8 inch inclusive.	1	1	1
2. More than 3/8 inch.	2	2	2
h. Skipped stitches for a distance of more than 1/4 inch on edge, top or raised stitching when seam is seamed, turned and stitched.	1	1	1
i. Stitch tension:			
1. Loose tension resulting in a loose seam:			
(a) - Up to 1/2 inch inclusive.	1	1	1
(b) - More than 1/2 inch up to 3/4 inch inclusive.	2	2	2
(c) - More than 3/4 inch.	3	3	3
2. Loosely exposed loops of lower or top thread on edge, top or raised stitching.	2	2	2
3. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching).	3	3	3

1/ Raw edge resulting from missing, incomplete or loose serging on any part of skirt, when required, shall be scored as a raw edge on inside.

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TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
VII. <u>Seams and Stitching</u> (cont'd)			
j. Stitches per inch (to be scored only when the condition exists on more than half the length of the seam or stitching):			
1. More than the maximum specified.	1	1	1
2. Less than the minimum specified:			
(a) - By one or two stitches.	1	1	1
(b) - By three or more stitches	2	2	2
k. Bartack, tack, or tacking (except buttonhole bartack):			
1. Missing, not secure, misplaced, not serving intended purpose or not specified size or type.	1	1	1
2. Loose stitch tension.	1	1	1
VIII. <u>Buttonhole</u>			
a. Omitted, added, not specified type or not finished as specified.	3	3	3
b. Misplaced or not positioned as specified; out of alignment with other buttonhole or button resulting in bulge or twist when buttoned.	3	3	3
c. Gimp omitted; uncut buttonhole; or ends of gimp not pulled through to underside.	2	2	2
d. Ragged edge; incomplete stitching; stitching not securely caught in fabric.	2	2	2
e. Broken stitch or two or more skipped stitches.	2	1	1
f. Buttonhole stitching extending beyond bartack; stitches per buttonhole less than minimum specified.	1	1	1
g. Bartack missing, loose or misplaced (not serving intended purpose).	2	2	2
IX. <u>Button</u> - One or more			
a. Omitted, broken, or defective.	1	1	1
b. Misplaced, loose; not attached as specified; or insecurely sewn.	1	1	1
c. Shank wrapping (when required) omitted or loosely wrapped.	-	-	1
d. Stitching of one or more not locked at end of cycle (tug at the loose end of the thread when accessible to determine if it will ravel).	1	1	1
e. Button stitching on pointed end of waistband tab exposed on outside of skirt.	1	1	1

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TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
<b>X. <u>Label or Marking</u></b>			
a. Not attached or affixed as specified, misplaced, or stitching through the printing.	1	1	1
b. Missing, incorrect, illegible or strike through:			
1. Size label, instruction or combination label.	3	3	3
2. Identification label.	1	1	1
*3. Removable size ticket (where applicable).	3	3	3
<b>XI. <u>Waistband or Waist Facing</u></b>			
a. Twisted.	*	3	2
b. Not uniform in width by more than 1/8 inch	1	1	1
c. Pointed end poorly shaped.	1	1	1
d. Width of finished waistband or waist facing not as specified.	2	2	1
e. Pointed end of waistband extension from edge of skirt not as specified.	2	1	1
f. Hanger loop(s) omitted or not securely caught in joining seam of waistband or waist facing.	1	1	1
g. Hanger loop(s) length (folded) not as specified.	1	1	1
h. Hanger loop(s) not positioned as specified from either side of right side seam or back edge of placket.	1	1	1
i. Square end of waistband extension from slide fastener seam not as specified.	2	2	1
j. Row of stitching joining underside of waistband or waist facing to skirt exposed on surface of skirt for a distance of 1 inch or more.	1	1	1
k. Tacking of inside fold of lining dart exposed on outside of skirt.	2	-	-
l. Bottom edge of waist facing not tacked to inside fold of one or more lining darts or bottom of side opening in lining not tacked to left side seam allowance of skirt.	1	-	-
m. Waistband or body of skirt exhibiting fullness at waistband joining seam.	2	2	2
* n. Waistband non-slip tape (as applicable)			
1. Not type specified	2	-	-
2. Not positioned on inner waistband as specified	1	-	-
3. Stitching penetrating rubber threads	2	-	-
4. Tape overlapping waistband tab extension	1	-	-

## MIL-STD-1609C

TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
<b>XII. <u>Skirt Side or Center Back Opening</u></b>			
*a. Length of side or center back opening uneven at top (examination to be performed with slide fastener closed and button or hook and eye closed):			
1. By more than 1/2 inch.	*	3	3
2. By 1/4 inch up to 1/2 inch (inclusive).	3	2	2
b. Lower end of placket piece not caught in stitching across welt	2	2	2
c. Placket piece or welt twisted, pleated or tight.	*	3	2
d. Placket piece not completely caught in waistband or waist facing joining seam.	2	2	2
e. Welt edge stretched.	2	2	2
f. Welt stitching irregular.	2	2	2
*g. Row of stitching along slide fastener edge of side or center back opening exposed beyond edge of welt when slide fastener is closed.	2	2	1
h. Stitching on front or back of skirt side or center back opening too close to slide fastener preventing slider to pass freely.	*	3	3
*i. Slide fastener chain misplaced (set too high or low) or coil/stop not positioned as specified.	2	2	2
j. Slide fastener tape stitched too loose or too tight, causing placket to bulge when placket is closed.	3	3	2
k. Stops at top of slide fastener more than tolerance limits specified or more than 1/4 inch when no tolerance is specified from waistband or waist facing joining seam line.	2	1	1
l. Top of fastener tapes not securely caught in waistband or waist facing joining seam line.	2	2	1
m. Chain scoops of slide fastener with top stops extending into waistband or waist facing joining seam line.	2	2	2
n. Slide fastener defective, affecting function.	3	3	3
*o. Bottom stop of slide fastener:			
1. Missing.	3	3	3
2. Misplaced by more than 1/8 inch.	1	1	1
3. Misplaced by 1/4 inch or more.	2	2	2

## MIL-STD-1609C

TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
<b>XIII. <u>Hook and Eyes</u></b>			
MIL-S-82126(MC), MIL-S-29629(NU), and MIL-S-87053(NU)			
a. End (curved end) of one or both hook(s) nearer or farther from the pointed end on the inner side of the waistband than the base of the point by more than 1/8 inch.	1	-	-
b. One or both hook(s) on inner side of waistband at base of pointed end less than 1/8 inch or more than 3/8 inch from top or lower edge of extension of pointed end.	1	-	-
c. Eye on square end of waistband or its corresponding hook on inner side of pointed end of waistband not centered between top and bottom edges of the waistband by more than 1/4 inch.	1	-	-
d. One or more eye(s) not aligned with corresponding hook(s) causing either the lapping of the pointed (front) or square (back) end of the waistband to be fuller or tighter than the other when the skirtband is fastened.	3	-	-
<b>XIV. <u>Linings</u></b>			
* MIL-S-21087(MC), MIL-S-29122(NU), MIL-S-29629(NU), MIL-S-82126(MC), MIL-S-83234(USAF), MIL-S-87053(NU), and PD AESC 83-3			
a. Tight, short or twisted causing fullness or twist on outside of skirt.	3	-	-
b. Gore seam line(s) in lining not aligned with corresponding gore seam lines in skirt at waistline or at bottom of side or center opening by more than 1/4 inch.	2	-	-
c. Folded edge of side front or center back lining more than 3/16 inch from slide fastener chain.	1	-	-
d. Folded edge of side back lining more than 1/8 inch back of the stitching joining the placket to the back of the side opening.	1	-	-

## MIL-STD-1609C

TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
<b>XV. <u>Hem Tape</u></b>			
a. Omitted.	3	2	-
b. Length of tape not as specified.	3	2	-
c. Tape not enclosed in envelope or not securely attached to hanger loop or buttonhole.	1	1	-
d. Overlapping end of tape on bottom edge of skirt not turned under or lapped over the other end as specified.	1	1	-
<b>XVI. <u>Pinking</u> (when required)</b>			
a. Omitted on any seam, placket or bottom edge more than 1 inch.	2	1	-
<b>XVII. <u>Darts</u></b>			
a. Twisted or puckered.	2	1	1
b. Corresponding darts not positioned uniformly by 1/2 inch or more.	1	1	1
c. Ends of darts extending below drill holes not as specified.	1	1	1
d. Inside folded edge of dart(s) not turned toward center front or back of skirt or lining.	1	1	1
e. Thread ends trimmed more than specified or left more than 1/2 inch long or when automatic machinery is used, not securely backtacked.	1	-	-
f. Not securely caught in waistband forming seam.	1	1	1
<b>*XVIII. <u>Welt Pocket</u></b>			
MIL-S-29122(NU), MIL-S-29629(NU), and MIL-S-87053(NU) as applicable			
a. Top edge of welts, short, causing puckers on front or too loose causing welt to gap.	2	-	-
b. Welt poorly shaped or not uniform in shape or size.	2	-	-
c. Reinforcing row of stitching on corners of welt, omitted or not secure.	1	-	-
d. Finished depth of welt when measured from top of welt to bottom at each end and at center, less than 1 inch or more than 1-1/8 inches.	2	-	-

## MIL-STD-1609C

TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
<b>*XVIII. <u>Welt Pocket</u> (cont'd.)</b>			
e. Finished width of welt when measured across center of welt less than 4-1/8 inches or more than 4-3/8 inches.	2	-	-
f. Welts out of horizontal alignment when measured from bottom of waistband to top corners of welt by:			
- 1/8 inch up to 1/4 inch (inclusive).	2	-	-
- More than 1/4 inch.	3	-	-
g. Welt out of alignment with each other when measured from bottom of waistband straight down to top edge of outside end of welt by 1/4 inch or more.	2	-	-
h. Welts out of alignment with each other when measured from bottom of waistband straight down to top of inside end of welt by 1/4 inch or more.	2	-	-
i. The sum of the measurements taken in g and h for each pocket welt, shall not deviate 1/2 inch or more when compared to the sum of the measurements for the opposite pocket welt.	*	-	-
j. Bottom of pockets out of horizontal alignment when measured from bottom of waistband to center of pocket by 1/4 inch or more.	2	-	-
k. Stitching of front ply of pocketing to welt performed simultaneously with stitching of welts to skirt.	1	-	-
l. Raw edges or notches showing around outside of welt.	3	-	-
m. Bottom ply of pocket not completely caught in waistband joining seam.	2	-	-
n. Bulging, pulling, twisting, or distortion of facing or pocketing affecting appearance on the outside of the skirt.	2	-	-
o. Distance measured along top of welt from top corner of inside welt end to gore seam covered by the welt shall not deviate by 1/4 inch or more from same measurement taken on the opposite pocket.	2	-	-

NOTE: Defects XVIIId-f relate to the individual measurements of each welt on a skirt.

Defects XVIIIg-i relate to the measurements of one welt compared to the opposite welt on one skirt.



## MIL-STD-1609C

TABLE IV - Classification of Defects (Continued)

Defect	Point Value		
	D	SD	U
<b>XIX. <u>ID/Change Pocket</u></b>			
MIL-S-83234(USAF), MIL-S-44102(GL) and PD AESC 85-3			
a. Width of pocket less than 2-5/8 inches or more than 2-7/8 inches.	1	-	-
b. Depth of pocket less than 3-3/4 inches or more than 4-1/4 inches.	1	-	-
c. Top of pocket not completely caught in waistband joining seam.	2	-	-
d. Bartacks missing or misplaced (not serving intended function).	2	-	-
<b>XX. <u>Back Kick Pleat</u></b>			
MIL-S-87053(NU) and MIL-S-29629(NU)			
a. Length not as specified.	1	-	-
b. Pleat poorly formed, twisted or puckered.	2	-	-
c. Topstitching more than 7/16 or less than 3/8 inch.	1	-	-
<b>XXI. <u>Belt loop</u></b>			
a. Omitted or covering stitch on outside.	2	2	2
b. Set at an angle (more than 3/16 inch off perpendicular), not secure, not attached as specified, length too short constricting waistband, width not as specified, or poorly shaped.	2	2	1
c. Misplaced by more than 3/4 inch, length too long causing gap of material to extend more than 1/8 inch above waistband or finished length more than 1/4 inch longer than specified.	1	1	1
d. Finished length not as specified.	1	1	1
e. Tacking or bartacking visible on outside (when applicable).	1	1	1
f. Turn under of top and/or bottom loop not as specified.	1	1	1
g. Not dropped as specified.	1	1	1
h. Not positioned as specified.	2	2	1

## MIL-STD-1609C

TABLE V - Selected DefectsWAISTBAND OR WAIST FACING

1. Twisted.

SKIRT SIDE OR CENTER BACK OPENINGS

1. Placket piece or welt twisted, pleated, or tight.
2. Stitching on front or back of skirt side or center back openings too close to slide fastener preventing slider to pass freely.
- \*3. Length of side or center back opening uneven at top (examination to be performed with slide fastener closed and button or hook and eye closed) by more than 1/2 inch.

WELT POCKET

MIL-S-29122(NU), MIL-S-29629(NU), and MIL-S-87053(NU)

1. The sum of the measurements taken in TABLE IV, Defects XVIII Ig and XVIII H for each pocket welt, shall not deviate 1/2 inch or more when compared to the sum of the measurements for the opposite pocket welt.

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## Preparing Activity:

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Project No. 8410-0735

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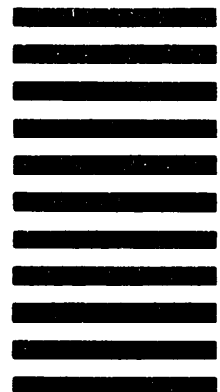
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