

MIL-STD-1668B  
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MILITARY STANDARD  
PROVISIONS FOR EVALUATING QUALITY  
OF  
CLOTH COVERALLS



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MIL-STD-1668B

DEPARTMENT OF DEFENSE

WASHINGTON, DC 20301

Provisions for Evaluating Quality of Cloth Coveralls

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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.

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## FOREWORD

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

The objectives of this standard are to:

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

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

|             |   |
|-------------|---|
| MIL-C-2202  | - Coveralls, Men's, Cotton, Sateen          |
| MIL-C-14610 | - Coveralls, Explosive Handlers'            |
| MIL-C-21850 | - Coveralls, Catapult, Crewmen's            |
| MIL-C-27845 | - Coveralls, Men's, CMU-3/P                 |
| MIL-C-29111 | - Coveralls, Explosive Handlers, (Women's)  |
| MIL-C-41833 | - Coveralls, Mechanics, Cold Weather        |
| MIL-C-43339 | - Coveralls, Industrial, Lint-Free          |
| MIL-C-43570 | - Coveralls, Safety, Industrial             |
| MIL-C-82297 | - Coveralls, Arc Preventive                 |
| MIL-C-83141 | - Coveralls, Flyer's Summer, Fire Resistant |
| MIL-C-87000 | - Coveralls, Men's                          |
| MIL-C-87093 | - Coveralls, (Flame Resistant)              |
| MIL-C-87230 | - Coveralls, Flyers', CWU-64/P              |

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1. SCOPE

1.1 Purpose. The purpose of this standard is to provide standardized provisions for evaluating the quality of cloth coveralls.

1.2 Application. This standard will be made applicable to contracts by reference in the appropriate coverall specification. If there are any inconsistencies between the requirements of the applicable specification and this standard, the specification will govern.

2. REFERENCED DOCUMENTS

\* 2.1 Government documents.

\* 2.1.1 Specifications, standards, and handbooks. The following standards and handbooks form a part of this standard 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.

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

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

\* 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 the DODISS shall be the issue of the nongovernment documents which is current on the date of the solicitation.

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

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

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\* 2.3 Order of precedence. In the event of a conflict between the text of this standard 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.

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

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

3.4 Terms "outside" and "inside". The terms "outside" and "inside" as used in this standard are defined as follows:

Outside - Any part that is visible when coverall is completely fastened except under the collar, under sleeve tabs, under pocket flaps, and under protective flap.

Inside - Any part that is not visible when coverall is completely fastened, including under the collar, under sleeve tabs, under pocket flaps, and under protective flap.

3.5 Open seam. The seam shall be classified open when one or more stitches joining a seam are broken or when two or more continuous skipped or runoff stitches occur.

3.6 Raw edge. Raw edge is defined as any edge not finished as specified, including any protruding edge on the outside of the coveralls.

3.7 Defective button. A button shall be considered defective when it has a sharp, rough, cracked, or split edge that will affect the serviceability of the coveralls or cause injury to the wearer.

3.8 Defective metal component. A metal component shall be considered defective when it has a rough or sharp edge, burr, fracture, corrosion or malformation that will affect the serviceability of the coverall or cause injury to the wearer.

3.9 Puckering. In the course of the sampling examination, seams suspected of being puckered shall be examined at a distance of 3 feet in comparison with the AATCC photographic comparative rating (see 7.1) for seams. Puckering 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.

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## 4. GENERAL

4.1 This standard contains the provisions for end item examination, dimensional examination, and packaging examination requirements for coveralls. The 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 more detrimental affect on the appearance or serviceability of the item.

## 5. SAMPLE AND INSPECTION PROVISIONS

5.1 End item examination. The coveralls 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 coverall. The lot shall be unacceptable if:

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

OR

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

5.2 Dimensional examination. The appropriate number of coveralls, determined from the table below, shall be examined for conformance to the dimensional requirements cited in the table of measurements of the appropriate coverall specifications. When a measurement deviates from a dimension and tolerance specified, the coverall shall be penalized one point. Each coverall shall also be penalized one point when the sleeves or legs are uneven in length by 1/2 inch or more. The lot shall be unacceptable if the total point value exceeds the maximum acceptable point values specified below. Each size coverall present in the lot shall be represented in the sample selected for this examination.

Normal Inspection:

| <u>Lot size</u> | <u>Sample size</u> | <u>Maximum Acceptable Points</u> |
|-----------------|--------------------|----------------------------------|
| Up thru 500     | 8                  | 0                                |
| 501 thru 3200   | 13                 | 1                                |
| 3201 and up     | 20                 | 2                                |

Tightened Inspection: 1/

| <u>Lot Size</u> | <u>Sample size</u> | <u>Maximum Acceptable Points</u> |
|-----------------|--------------------|----------------------------------|
| Up thru 500     | 13                 | 0                                |
| 501 and up      | 20                 | 1                                |

1/ Tightened inspection should be instituted when two out of five consecutive lots have been rejected.

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5.3 Examination of packaging requirements. An examination shall be made to determine the packaging, packing, and marking requirements are in compliance with Section 5 of the appropriate coverall specification. 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. Polyethylene bags improperly sealed. Bulged or distorted container.  |
| Content                         | Number of intermediate packages per shipping container is more or less than required.<br>Number of coveralls per intermediate package is more or less than required. <u>1/</u><br>Size shown on one or more coveralls not as specified on shipping container. <u>1/</u> |

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

## 6. INSPECTION

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

6.2 Initiation of inspection. Normal inspection will be used at the start of inspection unless otherwise directed by the responsible authority.

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).



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

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

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

b. The total number of points for 3 and 2 point defects in the samples from the preceding 10 lots is equal to or less than 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 responsible authority.

6.4.4 Reduced to normal. When reduced inspection is in effect, normal inspection shall be reinstated 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 I); or

c. Production becomes irregular or delayed; or

d. Other conditions warrant that normal inspection be instituted.

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Table I - Sampling provisions for cloth coveralls

|                          | Lot Size         | Sample Size | Maximum Acceptable Point Values |                        |
|--------------------------|------------------|-------------|---------------------------------|------------------------|
|                          |                  |             | 3 & 2 Point Defects             | 3, 2 & 1 point Defects |
| Normal Inspection        | Up thru 150      | 20          | 5 points                        | 12 points              |
|                          | 151 thru 280     | 32          | 7 points                        | 16 points              |
|                          | 281 thru 500     | 50          | 13 points                       | 25 points              |
|                          | 501 thru 1200    | 80          | 19 points                       | 31 points              |
|                          | 1201 thru 3200   | 125         | 27 points                       | 43 points              |
|                          | 3201 thru 10,000 | 200         | 38 points                       | 63 points              |
|                          | 10,001 and over  | 315         | 58 points                       | 93 points              |
| Tightened Inspection     | Up thru 500      | 50          | 7 points                        | 16 points              |
|                          | 501 thru 1200    | 80          | 12 points                       | 25 points              |
|                          | 1201 thru 3200   | 125         | 18 points                       | 37 points              |
|                          | 3201 thru 10,000 | 200         | 28 points                       | 57 points              |
|                          | 10,001 and over  | 315         | 41 points                       | 85 points              |
| Reduced Inspection<br>1/ | Up thru 280      | 13          | 2-6 points                      | 10 points              |
|                          | 281 thru 500     | 20          | 3-9 points                      | 16 points              |
|                          | 501 thru 1200    | 32          | 7-14 points                     | 24 points              |
|                          | 1201 thru 3200   | 50          | 12-18 points                    | 30 points              |
|                          | 3201 thru 10,000 | 80          | 16-21 points                    | 38 points              |
|                          | 10,001 and over  | 125         | 23-28 points                    | 43 points              |

1/ In 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.

\* 6.5 Changes from previous issue. The margins of this specification 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.

\* 6.6 Subject term (key word) listing.

Coveralls, Cloth  
Coveralls, Defects of  
Coveralls, Inspection of  
Coveralls, Quality of

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Table II - Classification of Defects

|   | <u>Point Value</u> |
|---|--------------------|
| <b>I. <u>MATERIAL DEFECT(S) AND WORKMANSHIP DAMAGE(S)</u></b>   |                    |
| a. Hole, cut, tear, smash, mend, scorched area or open place:   |                    |
| 1. On outside (longest dimensions in any direction):  |                    |
| (a) Up to 1/4 inch inclusive  | 2                  |
| (b) More than 1/4 inch  | 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. Knot or slub on outside (see 3.2)  | 1                  |
| c. Permanent fold, pleat or crease in cloth (when caught in seaming or stitching):                            |                    |
| - On outside  | 2                  |
| d. Missing or broken yarn on outside (longest dimension in any direction):                                    |                    |
| - More than 1 inch  | 1                  |
| e. Needle holes visible on outside, more than 2 inches in length  | 1                  |
| f. Vinyl laminated fabric (MIL-C-21850 only):   |                    |
| 1. Tear or abraded area   | 1                  |
| 2. Objectional odor   | 1                  |
| 3. Vinyl cracks when bent   | 1                  |
| <b>II. <u>SHADED PART(S)</u></b>  |                    |
| Shade varying within a part or between two or more parts on outside (except parts which may be cut from ends) | 2                  |
| <b>III. <u>CLEANNES</u></b>   |                    |
| a. Any spot, stain or marking on outside, clearly noticeable (largest dimension in any direction):            |                    |
| - More than 1/4 inch  | 1                  |
| b. Two or more lot, shade or size tickets not removed   | 1                  |
| *c. Thread ends or floats   |                    |
| 1. On outside of coveralls:   |                    |
| (a) Four to five threads not trimmed 1/4 inch or removed  | 1                  |
| (b) Six to eight threads not trimmed 1/4 inch or removed  | 2                  |
| (c) Nine or more threads not trimmed 1/4 inch or removed  | 3                  |
| 2. On inside of coveralls:  |                    |
| (a) Six to eight threads not trimmed 1/2 inch or removed  | 1                  |
| (b) Nine to ten threads not trimmed 1/2 inch or removed   | 2                  |
| (c) Eleven or more threads not trimmed 1/2 inch or removed  | 3                  |

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Table II - Classification of Defects (Cont'd)

|  | <u>Point Value</u> |
|--|--------------------|
| <b>IV. <u>COMPONENT(S) AND ASSEMBLY</u></b>  |                    |
| a. Any component part, reinforcement piece or operation omitted (unless otherwise classified herein)   | 3                  |
| b. Any component not as specified  | 3                  |
| c. Any operation not performed as specified  | 2                  |
| d. Any component part tight, twisted, distorted, puckered, or pleated (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   | 1                  |
| <b>V. <u>CUTTING</u></b>   |                    |
| Any component part not cut in accordance with specified pattern, directional lines on patterns; or not in accordance with specification requirements               | 3                  |
| <b>VI. <u>SEAM(S) AND STITCHING(S)</u></b>   |                    |
| a. Accuracy of seaming:  |                    |
| *1. Any part of coverall caught in any unrelated stitching operation   | 2                  |
| 2. Seam noticeably puckered or irregular (unless otherwise specified herein)   | 1                  |
| 3. End of stitching when not caught in other seams or stitching not backstitched as specified  | 1                  |
| 4. Thread break repaired by stitching back of the break less than 1/2 inch   | 1                  |
| 5. Ends of a continuous line of stitching overlapped less than 1/2 inch  | 1                  |
| 6. Shade of thread used on outside not as specified  | 1                  |
| 7. Restricted seam not neatly accomplished, affecting appearance   | 1                  |
| 8. Seams staggered 3/8 inch or more at junction when measured from center to center of seams   | 1                  |
| b. Gauge of stitching:   |                    |
| 1. Edge or top stitching sewn too close to edge resulting in serious damage to cloth   | 3                  |
| 2. Irregular, affecting appearance noticeably  | 1                  |
| 3. Gauge not within range specified or varies more than 1/8 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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Table II - Classification of defects (Cont'd)

|   | <u>Point Value</u> |
|---|--------------------|
| VI. <u>SEAMS(S) AND STITCHING(S)</u> (Cont'd)   |                    |
| c. Seam allowance:  |                    |
| - Width of seam allowance not as specified by 1/8 inch<br>(score only when condition exists on more than 1/2<br>the length of seam) | 1                  |
| d. Open seam (see 3.4 and 3.5):   |                    |
| 1. On outside, except hems:   |                    |
| (a) Less than 3/4 inch  | 1                  |
| (b) 3/4 inch or more  | 2                  |
| 2. On inside and hems:  |                    |
| - More than 3/8 inch  | 1                  |
| e. Runoff, skipped or broken stitches:  |                    |
| 1. Joining seams, use open seam classification  |                    |
| 2. Edge or top stitching, more than 1/4 inch<br>(when not resulting in an open seam)  | 1                  |
| f. Raw edges (see 3.6):   |                    |
| 1. On outside:  |                    |
| (a) Less than 3/4 inch  | 1                  |
| (b) 3/4 inch or more  | 2                  |
| 2. On inside and hems:  |                    |
| (a) 1 to 2 inches   | 1                  |
| (b) 2 inches or more  | 2                  |
| g. Seam and stitch type:  |                    |
| 1. Not specified seam or stitch type  | 2                  |
| 2. Looper thread of 401 or 406 stitch type on outside   | 3                  |
| 3. Any line of stitching omitted  | 3                  |
| 4. Any line of stitching not beginning or ending<br>where specified or insecure   | 1                  |
| 5. Any seam or pleat not lapped or folded in<br>direction specified   | 2                  |

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Table II - Classification of Defects (Cont'd)

|   | <u>Point Value</u> |
|---|--------------------|
| VI. <u>SEAM(S) AND STITCHING(S)</u> (Cont'd)  |                    |
| h. Stitch tension:  |                    |
| 1. Loose tension resulting in loosely exposed loops of lower or top thread (score only when condition exists on more than 1/2 the length of seam) | 2                  |
| 2. Tight tension (stitches break when normal strain is applied in the direction of the seam or stitching)   | 3                  |
| 3. Loose tension resulting in a loose seam:   |                    |
| (a) Less than 3/4 inch  | 1                  |
| (b) 3/4 inch or more  | 2                  |
| i. Stitches per inch (score only when condition exists on more than 1/2 the length of seam):  |                    |
| 1. One stitch less than the minimum or any number in excess of the maximum specified  | 1                  |
| 2. Two or more stitches less than the minimum specified   | 2                  |
| j. Bartack, backtack, or tack:  |                    |
| 1. Missing, insecure, misplaced, not serving intended purpose, or not specified size or type:   |                    |
| (a) For attachment  | 2                  |
| (b) For reinforcement   | 1                  |
| 2. Loose stitch tension   | 1                  |
| 3. Length not as specified by + 1/16 inch or more   | 1                  |
| 4. Other than direction specified (vertical or horizontal)  | 1                  |
| 5. Number of stitches less than specified by three or more  | 1                  |
| VII. <u>BUTTONHOLE(S)</u>   |                    |
| a. Omitted, added or not finished as specified  | 3                  |
| * b. Not positioned as specified  | 3                  |
| c. Finished length not as specified   | 2                  |
| d. Not securely caught in fabric causing stitches to pull away from fabric  | 2                  |
| e. Not specified type, uncut buttonhole, incomplete stitching or gimp omitted   | 2                  |
| * f. Spacing between buttonholes not positioned as specified by 1/4 inch or more  | 2                  |

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Table II - Classification of Defects (Cont'd)

|   | <u>Point Value</u> |
|---|--------------------|
| VII. <u>BUTTONHOLE(S)</u> (Cont'd)  |                    |
| g. Ragged edge, purling not finishing toward side specified or end not securely tacked  | 1                  |
| h. One or more broken stitches or two or more skipped stitches  | 1                  |
| i. Stitches per buttonhole less than the minimum specified by three or more stitches  | 1                  |
| VIII. <u>BUTTON(S)</u> (See 3.7)  |                    |
| a. Omitted, broken or defective   | 2                  |
| b. Misplaced or not positioned as specified   | 2                  |
| c. Stitching not locked at end of cycle (tug at loose end of the thread, when accessible, to determine whether it will ravel) | 1                  |
| d. Any part of coverall pleated or puckered by button attachment  | 1                  |
| e. Not specified type, size or color  | 1                  |
| f. Loose or insecurely sewn   | 1                  |
| IX. <u>SNAP FASTENER(S) AND GROMMET(S)</u> (See 3.8)  |                    |
| a. Omitted  | 3                  |
| b. Broken or defective  | 3                  |
| c. Misplaced or not positioned as specified   | 2                  |
| d. Clinched too tightly, cutting surrounding material   | 3                  |
| e. Socket out of alignment with stud resulting in a noticeable bulge or twist when fastened                                   | 2                  |
| f. Improperly clinched, failing to effect a secure closure or to open freely  | 3                  |
| g. Not specified type, size, color or finish  | 1                  |
| h. Reinforcement piece omitted, when required   | 2                  |
| * i. More than three cracks in snap fastener post   | 3                  |
| NOTE: Stud and socket shall be checked for proper and secure clinching by opening and closing fastener several times.         |                    |
| X. <u>FASTENER TAPE(S)</u> (hook and loop)  |                    |
| a. Omitted  | 3                  |
| b. Misplaced or not positioned as specified, i.e., not serving intended purpose   | 2                  |
| c. Type, color, or width not as specified   | 1                  |
| d. Stitched too loose or too tight causing noticeable puckering or twist on outside   | 2                  |

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Table II - Classification of Defects (Cont'd)

|  | <u>Point Value</u> |
|--|--------------------|
| <b>XI. <u>SLIDE FASTENER(S)</u> (See 3.8)</b>  |                    |
| a. Any part of metal fastener assembly defective or missing, scoops of chain unevenly matched or stitching too close to metal edge, not permitting slider to pass freely | 3                  |
| b. Cut or tear in tape   | 3                  |
| c. Not positioned as specified   | 2                  |
| d. Tape set too loose or too tight causing noticeable bulge, twist, or puckering on closed front or pocket   | 2                  |
| e. Not functioning properly  | 3                  |
| f. Tape not attached as specified  | 2                  |
| g. Ends of chain at top uneven by 3/16 inch or more  | 1                  |
| h. Thong omitted on top slider   | 2                  |
| i. Any untrimmed or loose threads that impair the ease of operations of any slide fastener.  | 3                  |
| <b>XII. <u>REINFORCEMENT PIECE(S) OR TAPE(S)</u></b>   |                    |
| a. Omitted   | 2                  |
| b. Misplaced, not serving intended purpose   | 1                  |
| c. Length or size not as specified   | 1                  |
| <b>XIII. <u>LABEL(S) AND SYMBOL(S)</u></b>   |                    |
| a. Omitted   | 2                  |
| b. Inscription incomplete, incorrect or illegible  | 1                  |
| c. Insecurely attached or not stitched on all four sides   | 1                  |
| d. Position not as specified   | 1                  |
| <b>XIV. <u>HANGER LOOP</u></b>   |                    |
| a. Omitted   | 2                  |
| b. Spread measurement between ends not as specified  | 1                  |
| c. Misplaced or not attached as specified  | 1                  |
| d. Length or width not as specified  | 1                  |
| e. Not securely caught   | 1                  |
| <b>XV. <u>TAB(S)</u> (leg, waist, sleeve, front)</b>   |                    |
| a. Too tight, loose or twisted when fastened   | 1                  |
| b. Irregular in width by 3/16 inch or more   | 1                  |
| c. Finished length not as specified  | 1                  |
| d. Misplaced or not positioned as specified  | 2                  |
| e. Constructed in other than specified manner  | 2                  |



## MIL-STD-1668B

Table II - Classification of Defects (Cont'd)

|   | <u>Point Value</u> |
|---|--------------------|
| XV. <u>TAB(S)</u> (leg, waist, sleeve, front) (Cont'd)                            |                    |
| f. Insecurely or not completely caught in stitching                               | 2                  |
| g. Omitted  | 3                  |
| h. Unequal distance from seam or edge   | 1                  |
| XVI. <u>SLEEVE(S)</u>   |                    |
| a. Sleeves reversed   | 3                  |
| b. Pleated or excessive fullness at armhole                                       | 2                  |
| c. Tight at armhole causing puckers on front or back                              | 2                  |
| d. Width of cuff not as specified   | 1                  |
| e. Cuff twisted or puckered   | 1                  |
| XVII. <u>HEM(S)</u> (sleeve, leg, neck, pocket)                                   |                    |
| a. Finished width not as specified  | 1                  |
| b. Irregular in width by 1/4 inch or more on more than 1/2 the length of seam     | 1                  |
| c. Elastic webbing omitted  | 3                  |
| d. Elastic webbing caught in stitching forming hem                                | 2                  |
| XVIII. <u>WRISTLET(S) AND ANKLET(S)</u> (knitted)                                 |                    |
| a. Not type or size specified   | 2                  |
| b. Not attached as specified  | 2                  |
| c. Not double thickness   | 1                  |
| XIX. <u>ELBOW AND KNEE PAD(S)</u> (MIL-C-21850 only)                              |                    |
| a. Misplaced by more than 3/4 inch from pattern marks                             | 1                  |
| b. Puckered, twisted, pleated, or poorly shaped, affecting appearance             | 1                  |
| XX. <u>COLLAR(S) AND LAPEL(S)</u>   |                    |
| a. Points poorly shaped or not of uniform shape                                   | 2                  |
| * b. Points uneven in length:   |                    |
| (1) 1/4 inch up to and including 3/8 inch   | 1                  |
| (2) More than 3/8 inch  | 2                  |
| c. Ends of collar not securely stitched to lapels                                 | 2                  |
| d. Collar off center 1/2 inch or more than shoulder seams at neckline are matched | 1                  |
| e. Width finishing less than specified  | 1                  |
| f. Edge or point not forced out   | 1                  |
| g. Ends of collar curled  | 1                  |

## MIL-STD-1668B

Table II - Classification of Defects (Cont'd)

|  | <u>Point Value</u> |
|--|--------------------|
| h. Spread or overlap of collar ends at neck opening not as specified when buttoned                             | 1                  |
| i. Collar binding (MIL-C-21850 only):  |                    |
| 1. Not securely caught in fabric causing binding to pull away easily from fabric                               | 3                  |
| 2. More than one splice  | 1                  |
| 3. Other than bias cut   | 1                  |
| <b>XXI. <u>FRONT CLOSURE</u></b>   |                    |
| a. General:  |                    |
| 1. Front noticeably twisted, puckered, or bulging when fastened  | 3                  |
| 2. Fronts uneven at neck by 1/2 inch or more when closed   | 2                  |
| 3. Base of front opening twisted or poorly finished  | 1                  |
| b. Protective fly (MIL-C-2202 only):   |                    |
| 1. Width at top or bottom not as specified   | 1                  |
| 2. Not inserted under back edge of lapel and front facings   | 1                  |
| 3. Base of fly not turned under when stitched  | 1                  |
| <b>XXII. <u>POCKET(S) AND FLAP(S)</u></b>  |                    |
| a. General:  |                    |
| 1. Omitted   | 3                  |
| 2. Finished length or width not as specified   | 2                  |
| 3. Not positioned as specified by 1/2 inch or more   | 2                  |
| 4. Corner of pocket or flap not securely tacked  | 1                  |
| 5. Welts overlapping 3/16 inch or more   | 1                  |
| 6. Poorly shaped, not of uniform size or attached crookedly, affecting appearance                              | 1                  |
| 7. Flap not covering front side edge of pocket or extends beyond front side edge of pocket by 1/4 inch or more | 1                  |
| 8. Noticeably twisted or puckered  | 1                  |
| 9. Construction not as specified   | 1                  |
| *10. Flap topstitch not covering raveled edges on underside of flap  | 1                  |

## MIL-STD-1668B

Table II - Classification of Defects (Cont'd)

|   | <u>Point Value</u> |
|---|--------------------|
| *11. Out of horizontal or vertical alignment at any point from pocket to pocket or flap to flap by:<br>(Determination may be made by a straight edge) |                    |
| a. More than 1/2 inch   | 3                  |
| b. More than 3/8 inch up to and including 1/2 inch  | 1                  |
| *12. Drill holes (when allowed) not covered by pocket or flap stitching   | 2                  |
| b. Lattice pocket (MIL-C-14610 and MIL-C-29111)   |                    |
| 1. Length or width of stripping not as specified  | 1                  |
| 2. Ends of horizontal strips extend less than 3/8 inch or more than 5/8 inch beyond the sides of the vertical strips                                  | 1                  |
| 3. Top horizontal strip not even with the top edges of vertical strips  | 1                  |
| 4. Center horizontal strip off center by more than 1/2 inch   | 1                  |
| 5. Misplaced, set on crookedly, or constructed of more or less than the number of strips specified  | 1                  |
| XXIII. <u>LEG(S)</u>  |                    |
| a. Bottom leg closure (MIL-C-27845 only):   |                    |
| 1. Ends uneven in length by 1/4 inch or more when closed  | 1                  |
| 2. Badly puckered or twisted when closed  | 1                  |
| 3. Top edge of closure not stitched across facing thru all plies  | 1                  |
| XXIV. <u>WAIST</u>  |                    |
| a. General:   |                    |
| 1. Waistband set on crookedly or irregular in width by 1/4 inch or more on more than 1/2 the length of waistband                                      | 1                  |
| b. Belt loop(s):  |                    |
| 1. Omitted  | 3                  |
| 2. Not positioned as specified  | 1                  |
| 3. Insecure or not constructed as specified   | 1                  |
| 4. Loop opening less than specified   | 1                  |

## MIL-STD-1668B

Table II - Classification of Defects (Cont'd)

|  | <u>Point Value</u> |
|--|--------------------|
| <b>XXV. <u>DRAWCORD</u></b>  |                    |
| a. Omitted or misplaced, not serving intended purpose  | 3                  |
| b. Ends not resin dipped or insecurely knotted   | 1                  |
| c. Knot omitted  | 1                  |
| d. Free length of loop at neck less than specified   | 1                  |
| e. Drawcord channel not specified width  | 2                  |
| <b>XXVI. <u>BACK AND YOKE</u></b>  |                    |
| a. MIL-C-21850 only:   |                    |
| 1. Yoke noticeably puckered or pleated at joining to front or back   | 1                  |
| 2. Back improperly shirred causing excessive puckering on top or waist edge                                | 1                  |
| b. MIL-C-2202 only:  |                    |
| 1. One or more pleats omitted or misplaced   | 1                  |
| 2. Space between pleats on each side uneven by 1/2 inch or more  | 1                  |
| 3. Outside pleat on each side spaced unevenly from side seam by 3/4 inch or more                           | 1                  |
| 4. Length of stitching on pleats not as specified  | 1                  |
| 5. Coveralls not buttoned as specified   | 1                  |
| <b>*XXVII. <u>TEMPLATE(S)</u></b>  |                    |
| Any pattern part varying by a total of 1/4 inch but not more than 1/8 inch on any one side of the template | 2                  |

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