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Place du Portage, Phase III
Core 0B2 / Noyau 0B2
Gatineau, Québec K1A 0S5
Bid Fax: (819) 997-9776**

**SOLICITATION AMENDMENT
MODIFICATION DE L'INVITATION**

The referenced document is hereby revised; unless otherwise indicated, all other terms and conditions of the Solicitation remain the same.

Ce document est par la présente révisé; sauf indication contraire, les modalités de l'invitation demeurent les mêmes.

Comments - Commentaires

**Vendor/Firm Name and Address
Raison sociale et adresse du
fournisseur/de l'entrepreneur**

Issuing Office - Bureau de distribution

Clothing and Textiles Division / Division des vêtements
et des textiles
11 Laurier St./ 11, rue Laurier
6A2, Place du Portage
Gatineau, Québec K1A 0S5

Title - Sujet Flyers Coveralls/Combinaison	
Solicitation No. - N° de l'invitation W8486-184259/A	Amendment No. - N° modif. 002
Client Reference No. - N° de référence du client 6000410451	Date 2018-03-16
GETS Reference No. - N° de référence de SEAG PW-\$\$PR-735-74413	
File No. - N° de dossier pr735.W8486-184259	CCC No./N° CCC - FMS No./N° VME
Solicitation Closes - L'invitation prend fin at - à 02:00 PM on - le 2018-04-16	Time Zone Fuseau horaire Eastern Daylight Saving Time EDT
F.O.B. - F.A.B. Plant-Usine: <input type="checkbox"/> Destination: <input checked="" type="checkbox"/> Other-Autre: <input type="checkbox"/>	
Address Enquiries to: - Adresser toutes questions à: Swanson, Manon	Buyer Id - Id de l'acheteur pr735
Telephone No. - N° de téléphone (819) 420-2945 ()	FAX No. - N° de FAX (819) 956-5454
Destination - of Goods, Services, and Construction: Destination - des biens, services et construction:	

Instructions: See Herein

Instructions: Voir aux présentes

Delivery Required - Livraison exigée	Delivery Offered - Livraison proposée
Vendor/Firm Name and Address Raison sociale et adresse du fournisseur/de l'entrepreneur	
Telephone No. - N° de téléphone Facsimile No. - N° de télécopieur	
Name and title of person authorized to sign on behalf of Vendor/Firm (type or print) Nom et titre de la personne autorisée à signer au nom du fournisseur/ de l'entrepreneur (taper ou écrire en caractères d'imprimerie)	
Signature	Date

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W8486-184259

Amd. No. - N° de la modif.
002
File No. - N° du dossier
pr735. W8486-184259

Buyer ID - Id de l'acheteur
pr735
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This amendment is raised to provide the responses to the questions received from the industry and to provide the new revised Annex B

Question no 1:

Annex E Bid Technical Evaluation Plan, para. 2.3 Documentary evidence/Bid samples & Table I, it requires one pair coveralls, Flyer's Combat, Flame Resistant, size 7040, please advise which type of coveralls need to be submitted for PAS, Type I (AFG) or Type II (Tan)?

Answer no 1:

Either colour AFG or Tan for the Bid Sample Coverall is acceptable.

Question no 2

In Annex B, Manufacturing Data

Q: Para. 3.4.4 Slide Fastener, it requires all slide fasteners must have a Nomex pull matching the colour of the tape. If Shell material is Nomex fabric, please advise is it acceptable to use shell material for the pull.

Answer no 2: A pull made of nomex shell material is acceptable for the Bid Sample Coverall. Please include a note with the submission, explaining the substitution.

Question no 3

Para. 3.4.5 Piping cord, it requires the cord must be No.20 Polyester and the colour match the shell material, however, our suppliers advise that cord No. 20 Polyester only have white colour available. Please advise that the white colour can be acceptable, as the cord is inside the front closure and not visible.

Answer no 3:

Piping cord in colour white is acceptable. Please include a note with the submission, explaining the substitution.

Question no 4:

Para. 3.4.6 Hook and Loop fastener tape, item #5 for Upper left sleeve – round – Designator badge, the loop requires in width 3-3/4" (8.25 cm) dia. Refer to Figure VII, it indicates 3-1/4" width, please clarify the width.

Answer no 4

Please refer to Figure VII, width should be 3-1/4".

Question no 5:

Para. 3.7.6.1 Shoulder Straps, it requires a piece of hook must be centred on the underside of the strap 3/8" from the point. But refer to Figure II (B), it indicates 5/8" from the point, please confirm the correct distance should be 5/8".

Answer no 5

Please refer to Figure II, distance from finished point of strap should be 5/8"

Question no 6:

Para. 3.7.27.1 Flashlight pocket, it requires pocket opening with 5/8" hem, but refer to Figure III, it indicates 3/4" hem, please clarify.

Answer no 6:

Please refer to 3.7.27.1, finished hem should be 5/8".

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Question no 7:

Para. 3.7.28 Pencil Pocket, it requires the webbing with **2" wide** x 6" long, but refer to Figure IV (J), it indicates **2-1/8"** wide webbing, please confirm the correct webbing wide should be 2".

Answer no 7

Please refer to 3.7.28, webbing should be 2"wide.

Question no 8:

Slide fasteners Para. 3.4.4.

The moulded zipper FR only have in BLACK color from the supplier. The color for the production can be as the contract mentioned in green and tan

Class 3 Type 13 & 15 are BRIDGE STOP not available, they are only available in STRAIGHT STOP as TYPE 1. In the past the bridge was available because the zipper was in BRASS

Answer no 8:

See attached revised Annex B

Delete: Annex B: Para 3.4.4 Slides fasteners

Insert: revised Annex B: Para 3.4.4.1 – 3.4.4.9

Question no 9:

Para. 3.4.5 Piping cord. They asking the colour must match to shell fabric, it is NOT AVAILBLE in color, come only WHITE, the piping is INVISIBLE please let us know if the color is acceptable

Answer no 9:

Piping cord in colour white is acceptable. Please provide a note with your submission, explaining the substitution.

All others terms and conditions remain the same



NOTICE

This documentation has been reviewed by the technical authority and does not contain controlled goods. Disclosure notices and handling instructions originally received with the document shall continue to apply.

AVIS

Cette documentation a été révisée par l'autorité technique et ne contient pas de marchandises contrôlées. Les avis de divulgation et les instructions de manutention reçues originalement doivent continuer de s'appliquer.

Annex B
W8486-184259
DSSPM 2-6-87-3951
26 January 2017
Supersedes
DSSPM 2-6-87-3951
Dated 12 October, 2010
& DSSPM 2-6-87-1073,
All versions

Revision 16-03-2018:

Para 3.4.4 Slide fasteners: Remove Paragraph

Para 3.4.4 Slide Fasteners: Insert Paragraph 3.4.4.1-3.4.4.9

**MANUFACTURING DATA
FOR
COVERALLS, FLYERS', COMBAT, FLAME RESISTANT**

1. SCOPE

1.1 Scope. This Manufacturing Data covers the materials, design, construction and inspection for Coveralls, Flyers', Combat, FR. These coveralls supersede the Air Force Green (NSN 8415-21-921-1073 A/A) and Tan (NSN 8415-20-001-9525 A/A) coveralls made in accordance with DSSPM 2-6-87-1073.

1.2 Classification. The garment must be supplied in one of the following types as specified in the contract:

Type I Coverall, Flyers' Combat, Flame Resistant (FR), Air Force Green
NSN 8415-20-006-3673 A/A

Type II Coverall, Flyers' Combat, Flame Resistant (FR), Tan
NSN 8415-20-009-9950 A/A

2. RELATED DOCUMENTS

2.1 The following documents form part of this Manufacturing Data to the extent specified herein. Unless otherwise specified, the issue or amendment of documents effective for a particular contract must be those in effect on the invitation to tender or the contract.

2.2 Government documents.

OPI/BPR: DSSPM 2-6



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SPECIFICATIONS AND STANDARDS

D-80-001-055/SF-001 Label, Clothing and Equipment
D-80-001-101/SF-001 Webbing, Cotton, Types I and II, Water and Rot Resistant
D-83-001-005/SF-001 Fasteners, Slide, Interlocking
CFPTO-General Canadian Forces Transportation Packaging Order

DRAWINGS

391335 Map Clip

2.3 Other publications. The following documents form part of this manufacturing data to the extent specified herein. Effective date must be that in effect on the date of manufacture. Source is as shown:

Canadian General Standards Board (CGSB) Sales Unit
11 Laurier Street
Place du Portage, Phase III
Gatineau, Quebec K1A 1G6
Tel: (819) 956-0425
Alternate Tel: (800) 665-2472
Email: ncr.cgsb-ongc@pwgsc.gc.ca

CAN/CGSB-4.2-M Textile Test Methods
CAN/CGSB-54.1-M Stitches and Seams, Parts I and II
CAN/CGSB-86.1-2003 Care Labelling of Textiles
CAN/CGSB-155.1-2001 Fire Fighters Protective Clothing for Protection Against Heat and Flame

General Services Administration (FED-STD)
Federal Supply Service
FSS Product Acquisition Center
Supply Standards Division (FLAS)
Arlington, VA
22202 USA
Telephone: 703-605-2567
Email: jennifer.moffat@gsa.gov
Download Documents: <http://assist.daps.dla.mil/quicksearch/>

A-A-55217 Thread, Aramid, Spun Staple
A-A-55126A Commercial Item Description - Fastener Tapes, Hook and Loop, Synthetic

2.4 DSSPM Documents. The following documents form part of the Technical Data Package for Coveralls, Flyers', Combat, Flame Resistant:

This document does not contain controlled goods. / Cette documentation ne contient pas de marchandises contrôlées.

DSSPM 2-2-80-217 Specification for Cloth, Plain Weave, Flame Resistant, Aramid, 185 g/m²

2.5 Figures. The following Figures from part of this Manufacturing Data. Figures are not to scale.

Figure I	Front and Back View
Figure II	Garment Components
Figure III	Pocket Systems
Figure IV	Pocket Systems II
Figure V	Waist Suppression System
Figure VI	Care and Marking Label – Types I and II
Figure VII	Template for upper sleeve loop tape patches

2.6 Sealed patterns

DSSPM 103-12	Coverall, Flying, Combat, FR (For construction of Types I and II Coveralls)
DSSPM 253-04	Cloth, Plain Weave, Aramid, 185 g/m ² , Air Force Green
DSSPM 254-03	Cloth, Plain Weave, Aramid, 200 g/m ² , Tan (colour guidance only)

***Note:** Sealed Pattern DSSPM 103-12 has the following deviations:

1. All material and colour requirements must be that stated in Para 3.4;
2. There must be shoulder straps as specified in Para 3.7.6 Shoulder Straps
3. There must be loop tape attachments as specified in Para 3.4.6, Table II:
 - i. Loop tape fasteners for name and trade badge patches as specified in Para 3.7.3;
 - ii. Hook and loop closure for shoulder straps as specified in Para 3.7.6.4 & 3.7.6.6;
 - iii. Loop fastener tape for the attachment of the Canadian Flag as specified in Para 3.7.8;
 - iv. Loop fastener tapes for the attachment of the upper arm badges, as specified in Para 3.7.9.

2.7 Paper patterns. DND will provide the paper patterns for all sizes under Style Code **CFC30** to the contractor. Size 7040 (**REG/MED**) will be used for tendering purposes.

3 REQUIREMENTS

3.1 Sealed pattern. A sealed pattern, when available, will be supplied to the

Contractor. The sealed pattern will constitute the standard in regard to any properties not defined in the Manufacturing Data.

3.2 Design. The design for the coveralls must be in accordance with Sealed Pattern *DSSPM 103-12 and must have the following features:

- a. Rounded, stand up collar;
- b. Shoulder straps with hook and loop fastener tape;
- c. Slide fastener front closure with fly guard;
- d. Breast patch pockets with slide fastener closures;
- e. Patch pocket with slide fastener on the upper sleeve;
- f. Quarter top pockets on each front hip;
- g. Patch pockets with pencil pockets and slide fastener closures on the bottom front of each leg;
- h. Patch pocket with map clip holder on each thigh;
- i. Knife pocket on inner thigh of left leg;
- j. Two-piece set-in sleeves with cuffs using hook and loop fastener tape closure;
- k. Waistband with suppressions; and
- l. Loop fastener tape on chest and upper sleeves for adhesion of name tape, insignia and badges.

3.2.1 The garment components must be shaped, dimensioned and positioned in accordance with the Government supplied Paper Patterns, the applicable Figures, and Table I - Scale of Measurements.

3.3 Preproduction. Preproduction samples must be completely representative of the final product, being made from parts and materials as specified and by equipment and processes which will be used in quantity production.

3.4 MATERIALS

3.4.1 Shell material.

3.4.1.1 For Type I and II Coveralls. The shell material for Coveralls Type II and II must be in accordance with DSSPM 2-2-80-217. The colour used for Type I Coveralls must be Aviation Green in accordance with DSSPM 253-04. The colour used for Type II Coveralls must be Tan in accordance with DSSPM 254-03.

3.4.2 Map clip holders and pencil pockets. The material used must be webbing, Type I, Identification No. 8, 2 inches (5.0 cm) wide conforming to D-80-001-101/SF-001. The colour used for Coverall Type I and II must be a good match to the shell.

3.4.3 Map clips. The map clips must be in accordance with Drawing 391335. The colour must be black. Unless otherwise specified, these items will not be supplied by the Government. Suggested sources for the map clip are:

Integrated Plastic Inc.
170 Commander Blvd.
Agincourt, Ontario
M1S 3C8 or

Texfast Group Ltd.
88 Tycos Drive
Toronto, Ontario
M6B 1V9

3.4.4 Slide fasteners.

3.4.4.1The slide fasteners must have brass interlocking members with automatic locking sliders conforming to D-83-001-005/SF-001.

3.4.4.2Slide fasteners must be flame resistant in accordance with CAN/CGSB-155.1-2001, para 5.1.2.

3.4.4.3The metal components must have a dull or antique finish.

3.4.4.4 The tapes must be made with flame resistant fibres woven using a twill weave and must be a good match to the shell colour.

3.4.4.5 When tested in accordance with the applicable test methods, the slide fasteners must meet the requirements for colourfastness, strength and flame resistance.

3.4.4.6 The colour used for Type I Coverall must be Air Force Green as shown on Sealed Pattern DSSPM 253-04.

3.4.4.7 The colour used for Type II Shirts must be Tan as shown on Sealed Pattern DSSPM 254-03

3.4.4.8 All slide fasteners must have a Nomex pull matching the shell fabric.

3.4.4.9 The detailed requirements for the various types and lengths are in the Table I. (attached)

TABLE I: SLIDE FASTENER DETAILS

	LOCATION	CLASS	TYPE	LENGTH OF CHAIN (inches)
1	Front closure	3	13	As shown on the Table I - Scale of Measurements

This document does not contain controlled goods. / Cette documentation ne contient pas de marchandises contrôlées.

2	Breast pockets	3	15	6-1/2 inches (16.5 cm)
3	Left thigh, right thigh, and knife pocket	3	15	6-inches (15.2 cm)
4	Sleeve pockets	3	15	6 inches (15.2 cm)
5	Lower leg pockets	3	15	9 inches (22.9 cm)
6	Leg suppressions	3	1	11 inches (27.9 cm)

Note: YKK FR slide fastener products (3939 Thimens Blvd, Ville St-Laurent, QC H4R 1X3 Tel.: (514) 332-3356) have been found to meet these requirements.

3.4.5 Piping cord. The piping cord material to be used for reinforcing the front centre, covering the slide fastener must be No. 20 Polyester. Piping cord should be white, covered in shell material. See also 3.7.36 remove piping cord, add piping of shell material.

3.4.6 Hook and loop fastener tape. The hook and loop fastener tape must conform to Type II, Class 1 with a flame retardant finish in accordance with A-A-55126A. The colour must be a good match to the shell. The lengths and widths are defined in Table II.

TABLE II: HOOK AND LOOP FASTENER TAPE DETAILS

LOCATION		FASTENER TAPE - HOOK				FASTENER TAPE - LOOP			
		width		length		width		length	
		in	cm	in	cm	in	cm	in	cm
1	Waist suppression unit	1	2.5	2	5.0	1	2.5	5	12.7
2	Shoulder strap	1	2.5	1	2.5	1	2.5	1	2.5
3	Chest - name and trade badges	n/a				2	5.0	3-3/4	9.5
4	Upper left sleeve – Canada Flag badge	n/a				1	2.5	2	5.1
5	Upper left sleeve – round - Designator badge (Figure VIII)	n/a				3-3/4 in (8.25 cm) dia.			
6	Upper right sleeve – shape Heraldic badge (Figure VIII)	n/a				3-1/4	8.25	4-5/16	11
7	Cuff closure	1	2.5	1	2.5	1	2.5	2-1/2	6.4

3.4.7 Thread

This document does not contain controlled goods. / Cette documentation ne contient pas de marchandises contrôlées.

3.4.7.1 For seaming and stitching. The thread must be Thread, Aramid, Spun Staple, Tex 70, in accordance with Type II of A-A-55217. The colour used for Coveralls Type I and II must match the material being sewn.

3.4.7.2 For serging. The thread must be Thread, Aramid, Spun Staple, Tex 40, in accordance with Type I of A-A-55217. The colour must match the material being sewn.

3.4.7.3 Thread for sewing of hook and loop fastener tape. All hook and loop fastener tape must be sewn with Thread, Aramid, Spun Staple thread, Tex 27, in accordance with Type II of A-A-55217. The colour must match the components being sewn. See para 3.6.9 for detailed sewing instructions regarding the hook and loop fastener tape.

3.4.8 Elastic braid. The elastic braid used for the waist suppression must be cotton, rayon or polyester covered neoprene rubber, 1-inch (2.5 cm) wide with 100% stretch and having 54 meters per kilogram (1 kg). The colour must be black or natural.

3.4.9 Marking label. A marking label in accordance with D-80-001-055/SF-001 and a care label in accordance with CAN/CGSB-86.1-2003 must be stitched to the garment.

3.5 Cutting

3.5.1 Garments must be cut using Government supplied paper patterns. Patterns include seam allowance but do not include "make-up" allowance. Individual contractors will be responsible for any changes which may be required for "make-up" allowance to suit their production method. However, the design or grade must not be changed.

3.5.2 Each component must be cut in the direction of the warp unless otherwise indicated on the paper patterns.

3.5.3 The shell parts of each garment must be cut from the same dye lot of material.

3.6 Sewing

3.6.1 All seams and stitches must be in accordance with CAN/CGSB-54.1-M.

3.6.2 Unless otherwise specified, seams must be a minimum of 3/8-inch (9.5 mm) wide.

3.6.2.1 The inherent properties of some FR materials render them prone to fraying. Care must be taken to ensure that all seam allowances must be adhered to without compromise to the shape and finished dimensions outlined in the scale of measurements.

3.6.3 Where double lapped seams are specified, numerical designation 2.04.03 or 2.04.04 of CAN/CGSB-54.1-M must be used. They may be lock or lockstitched, with the needles set 1/4-inch (6.4 mm) apart. All other seams and stitches must be class 300 lock stitch series of CAN/CGSB-54.1-M.

3.6.4 The following seams must be double lapped seams: shoulder seam, sleeve seams, armhole seams, underarm seams, seat and crotch seams, inseams, and side seams.

3.6.5 There must be 8 to 10 stitches per inch (2.5 cm) in all seams and stitches.

3.6.6 The ends of lock stitched seams, stitches and breaks in thread must be securely backstitched.

3.6.7 Where seaming, turning and stitching are specified, the ends must be properly worked out before stitching.

3.6.8 The tension of the needle and bobbin thread must be adjusted to ensure correctly formed stitches.

3.6.9 Hook and loop fastener tape. Hook and loop fastener tape must be stitched around all edges 1/8-inch (3.2 mm) gauge. Care must be taken to ensure stitching is formed into the hook and loop portion of the tape.

3.6.9.1 When tapes wider than 1-inch (2.5 cm) are used, they must be stitched around all edges and through the center or have an 'X' enclosed in the box.

3.6.10 Bartacks. Bartacks must be 3/8-inch (9.5 mm) long and must have not less than 15 cover stitches. As an alternative, an automatic backstitch having 15 to 20 stitches may be used.

3.7 Construction

3.7.1 Upper portion – Front. A dart extending from the waistline to the chest must be sewn in each forepart. The darts must be pressed towards the centre front.

3.7.2 Breast pockets. One patch pocket with covered slide fastener closure across the top and shaped as per the drawing must be placed on each forepart.

3.7.2.1 The top edge of the pocket must be folded under 3/8-inch (9.5 mm), and stitched on folded edge at 1/8-inch (3.2 mm) gauge. Place folded edge over slide fastener covering half the fastener chain and double stitch in place. **Note: The slide fastener must be positioned that the pockets are closed to side seam.**

3.7.2.2 Zip cover. A piece of shell must be folded in three, as indicated on pattern drawing, and free edge stitched at 1/8-inch (3.2 mm) gauge. The cover must be positioned over the slide fastener covering half the chain and stitched in place.

3.7.2.3 With the pockets placed on their respective foreparts, the front edge and short side edge of each pocket and all three edges of zip cover must be turned under 3/8-inch (9.5 mm). All folded edges must be double needle stitched. The ends of the slide fastener tape must be included in this operation.

3.7.2.4 The finished width of the zip cover must be 3/4-inch (19.1 mm).

3.7.2.5 The remaining raw edges on the underarm, side and waist seams must be serged together.

3.7.3 Loop fastener tape for name and trade badge patches. A piece of loop fastener tape as listed in Table III, must be placed on each front, as indicated on paper patterns, and stitched around all edges.

3.7.4 Upper portion - Back. The action back consists of two vertical pleats positioned 7-1/2-inches (19 cm) from the centre back. Each pleat must be 2-inch (5 cm) deep and pressed towards the centre back. Each pleat must be stitched at 1/16 inch (1.6 mm) gauge (wrong side) and 1/4-inch (6.3 mm) gauge (right side).

3.7.5 Yoke / joining shoulders. The outer yoke piece must be seamed to the pleated back portion. The front portions must be sandwiched within the yoke, seamed together at the shoulders and finished with a double stitch topstitch. The back inner yoke piece must be turned under and finished using double stitch topstitch.

3.7.6 Shoulder straps. The shoulder straps must be finished with a double stitch topstitch at 1/16 inch (1.6 mm) and 1/4-inch (6.3 mm) gauge along the sides and around the pointed end.

3.7.6.1 A piece of hook portion of fastener tape as listed in Table III, must be centred on the underside of the strap 3/8-inch (9.5 mm) from the point and stitched around all edges.

3.7.6.2 The shoulder strap must be centred across their respective shoulder seam and stitched in place.

3.7.6.3 A piece of loop portion of fastener tape as listed in Table III, must be positioned on the shoulder seam to align with the hook portion on the strap and stitched around all edges. The strap must lie flat when fastened.

3.7.7 Sleeves. The sleeves must be two piece set-in type. A bellows type patch pocket with an inside pencil pocket made from shell material with a covered slide fastener closure along the front edge must be positioned on the upper portion of both sleeves. The pockets must be made of shell material and raw edges must be serged.

3.7.7.1 The front edge of the pocket must be turned under 5/8-inch (15.9 mm) and stitched at 1/8-inch (3.2 mm) gauge. Place folded edge over the slide fastener covering half the fastener chain and double stitch in place.

3.7.7.2 Zipper Cover. A piece of shell must be folded in three, as per indicated on pattern drawing, and free edge stitched at 1/8-inch (3.2 mm) gauge. The cover must be positioned over the slide fastener covering half the chain and stitched in place.

3.7.7.3 The two bellows cuts at the bottom corners must be serged.

3.7.7.4 The pocket edges must be folded under and stitched at 1/16-inch (1.6 mm) gauge. The zip cover edges must be folded under and double needle stitched. The

ends of the slide fastener tape must be included in this operation.

3.7.7.5 The finished width of the zip cover must be 3/4-inch (19 mm).

3.7.8 Loop fastener tape for Canadian flag. The left sleeve must have a piece of loop fastener tape as listed in Table III for the attachment of a Canadian flag. The loop fastener tape must be centred with the shoulder seam, 1/2-inch (12.7 mm) below the sleeve head, and stitched around all edges.

3.7.9 Loop fastener tapes for upper arm badges. A circular loop fastener tape as listed in Table III and Figure VIII, must positioned 1/4-inch (6.4mm) below the shoulder flag loop fastener tape on the left sleeve and the heraldic shaped fastener tape as illustrated in Figure VIII positioned 1/2 inch (12.7 mm) below the shoulder seam on the right sleeve.

3.7.10 The upper and under sleeves must be joined along the elbow seam with the upper sleeve overlapping the under sleeve on the outside.

3.7.10.1 The sleeves must be joined to their respective armholes with a double lapped seam. The body must overlap the sleeve on the outside.

3.7.10.2 The shoulder strap must be included in this operation.

3.7.11 Underarm joining. The front, back and underarm must be seamed together with a double lapped seam along the side and underarm seam in a continuous operation. The lap must be towards the back on the outside.

3.7.12 Sleeve pleats. Two pleats must be placed at the bottom of each sleeve.

3.7.12.1 One pleat must be placed in the under-sleeve portion 7/8-inch (22.2 mm) from the underarm seam and the other in the upper-sleeve portion 4-1/2 inches (11.4 cm) from the elbow seam.

3.7.12.2 The pleats must be folded toward the elbow seam and stitched across at the bottom of the sleeve.

3.7.13 Sleeve cuffs. Each cuff must be made from one piece of material.

3.7.13.1 The cuff must be folded in half face to face and seamed across the ends.

3.7.13.2 With the pointed end of the cuff towards the elbow seam, the cuff must be stitched to the lower edge of the sleeve from the inside. The seam must be turned towards the cuff. The pointed end must form an extension of 2-1/2 inches (6.3 cm).

3.7.13.3 The cuff must be turned to the outside, the top edge folded under 3/8-inch (9.5 mm) and double needle stitched or stitched at 1/16-inch (1.6 mm) and 1/4-inch (6.3 mm) gauge all around.

3.7.13.4 The straight end of the cuff must be stitched to the cuff extension 2-1/2

inches (6.3 cm) from the point.

3.7.13.5 The finished width must be 2-1/4 inches (5.7 cm).

3.7.14 Cuff closures. A piece of hook portion of fastener tape as listed in Table III, must be centred on the inner ply of each cuff 3/8-inch (9.5 mm) behind the pointed end of the cuff and stitched all around.

3.7.14.1 A piece of loop portion of fastener tape as listed in Table III, must be centred on the outer ply of the cuff 2-1/2 inches (6.3 cm) from the straight edge of the cuff and stitched all around.

3.7.15 Lower portion. Each back portion must have a dart, which is folded towards the centre back.

3.7.16 Side front pockets. Quarter top pockets with pocket bags of shell material must be sewn on each front hip.

3.7.16.1 The top ply of the pocket bag must be seamed along the edge of the pocket opening, turned and stitched at 1/4-inch (6.3 mm) gauge.

3.7.16.2 With the outsides together, the pocket bags must be seamed together, turned and stitched 1/4-inch (6.3 mm) gauge.

3.7.16.3 The side edges of the pocket bag and side seam may be stitched together.

3.7.16.4 A bartack must be placed at the bottom of each side pocket opening on the angle at the bottom corner.

3.7.16.5 The length of the finished opening must be 7 inches (17.8 cm).

3.7.17 Knife pocket. The knife pocket must be a double-jetted patch pocket with a slide fastener closure with a sewn down flap and inside fabric loop. The slide fastener must close towards the top. It is located on the inner thigh of the front left leg.

3.7.17.1 The two jetting must be formed from one single piece of shell, which must be folded in four, as indicated on the pattern drawing.

3.7.17.2 The folded jetting must be placed face down and centred with the pocket opening. The bottom must be stitched across for a distance of 5/8-inch (15.9 mm). The pocket opening must be cut open, separating the jettings, turned and stitched along the fold at 1/16-inch (1.6 mm) gauge.

3.7.17.3 The bottom layer of the jettings must be laid flat and centred over the slide fastener.

3.7.17.4 The top layer of the jettings must be folded under 5/8-inch (15.9 mm) catching the raw edge of the pocket opening and stitched at 1/16-inch (1.6 mm) gauge. The slide fastener tape must be caught in this operation.

3.7.17.5 There must be a second row of stitching at 1/4-inch (6.3 mm) gauge, on each side of the jettings and bottom fold.

3.7.17.6 Knife thong. A loop must be constructed by folding a piece of shell material in half along its length, turning the raw edges in and stitching 1/16-inch (1.6 mm) gauge along each edge.

3.7.17.6.1 The loop must be folded in half across its width, placed inside the pocket 1-inch (2.5 cm) from the slide fastener opening and stitched to the top edge of the pocket. The finished length of the loop must be 2-1/4 inches (5.7 cm).

3.7.17.7 A tuck 1/4-inch (6.3 mm) deep must be folded in the lower edge of the pocket 1-inch (2.5 cm) from the slide fastener opening. The fold must be away from the slide fastener.

3.7.17.8 The knife pocket flap must be folded right sides together along its length and stitched across the ends, turned and stitched 1/16-inch (1.6 mm) gauge along the folded edge.

3.7.17.9 With the pocket and flap placed in position on the left leg, the raw edges must be folded under and double needle stitched or stitched at 1/16-inch (1.6 mm) and 1/4-inch (6.3 mm) gauge all around.

3.7.18 Map clip assembly. The cut ends of the webbing must be turned under 1/4-inch (6.3 mm) and stitched at 1/8-inch (3.2 mm) gauge.

3.7.18.1 The bottom of the webbing must be folded back upon itself for 3-1/4 inches (8.2 cm) and stitched along the edges at 1/2-inch (12.7 mm) gauge. The map clip must be inserted, the top folded over the top end of the map clip and stitched at 1/2-inch (12.7 mm) gauge. The finished length must be 4-3/4 inches (12.1 cm).

3.7.18.2 An assembly must be positioned on each, the left and the right, thigh pocket pieces and stitched in place 1/16-inch (1.6 mm) gauge twice around all edges. There must be a reinforcement piece at the bottom of each map clip assembly.

3.7.19 Left thigh pocket with map clip holder. The thigh pocket must be a patch pocket with a covered slide fastener closure, closing to the top, with a map clip in holder and is located on the left front thigh.

3.7.19.1 The front edge of the pocket must be turned under 5/8-inch (15.9 mm) and stitched on folded edge at 1/8-inch (3.2 mm) gauge. The folded edge must be placed over the slide fastener covering half the fastener chain and double stitched in place.

3.7.20 Zip cover. A piece of shell must be folded in three, as per indicated on pattern drawing, and free edge stitched at 1/8-inch (3.2 mm) gauge. The cover must be positioned over the slide fastener covering half the chain and stitched in place.

3.7.20.1 The pocket assembly must be positioned on the left leg, raw edges turned under 3/8-inch (9.5 mm) and double needle stitched all around. The ends of the slide

fastener tape must be included in this operation.

3.7.20.2 The finished width of the slide fastener cover must be 3/4-inch (19 mm).

3.7.21 Right thigh pocket and map clip holder. The pocket must be a patch pocket with a covered slide fastener closure, closing to the side, with a map clip in holder and is located on the right front thigh.

3.7.22 Zip cover. A piece of shell must be folded in three, as per indicated on pattern drawing, and free edge stitched at 1/8-inch (3.2 mm) gauge. The cover must be positioned over the slide fastener covering half the chain and stitched in place.

3.7.22.1 The pocket assembly with map clip holder must be positioned on the right front leg, the edges turned under and double needle stitched or stitched at 1/16-inch (1.6 mm) and 1/4-inch (6.3 mm) gauge along all sides.

3.7.23 Bottom leg reinforcement. The top edge of the leg reinforcement must be serged.

3.7.23.1 The reinforcement pieces must be placed on the inside of the respective leg pieces with the bottom edge being placed 2-inches (5.1 cm) above the bottom edge of the leg. The top edge must be folded under and double needle stitched or stitched at 1/16-inch (1.6 mm) and 1/4-inch (6.3 mm) gauge.

3.7.23.2 The reinforcement pieces may be serged or basted to inseam and outseam.

3.7.24 Joining the outseams. The outseams of the lower portion must be sewn with a double lapped seam having the lap towards the back. The back edges of the front hip pockets, left thigh pockets and right reinforcement patch must be included in these seams.

3.7.25 Lower leg pockets. A patch pocket with a covered slide fastener closure across the top, closing to the side, and pencil pocket on the outside must be located on the bottom of each leg. A flashlight pocket must be placed on the inside of the each pocket.

3.7.26 Leg reinforcement pieces. The reinforcement pieces must be positioned on the lower leg, the raw edges turned under and double needle stitched or stitched at 1/16-inch (1.6 mm) and 1/4-inch (6.3 mm) gauge around all edges.

3.7.27 Flashlight pocket. The pockets must be a bellows type patch pocket positioned on the inside of each leg pocket.

3.7.27.1 The top edge of each pocket must be turned under, the raw edge turned in and stitched at 1/8-inch (3.2 mm) gauge to form a hem of 5/8-inch (15.9 mm) wide. The remaining edges must be serged. The pockets must be positioned on the inside of the leg pocket, with serged edges turned under and stitched at 1/16-inch (1.6 mm) gauge.

3.7.28 Pencil pockets. Each pencil pocket must be constructed from 2-inch (5.1 cm)

wide webbing 6-inches (15.2 cm) long.

3.7.28.1 Each end of the webbing must be folded under 1-1/2 inches (3.8 cm) and stitched 1/8-inch (3.2 mm) along the edges. The bottom end must be folded up 5-inches (12.7 cm) and stitched along both edges 1/8-inch (3.2 mm) gauge and down the centre to form two pencil slots.

3.7.28.2 The pencil pocket assembly must be positioned on each respective pocket and stitched to the outer layer at 1/8-inch (3.2 mm) gauge all around.

3.7.28.3 There must be two rows of vertical stitching at the centre. The entry points of the pocket shall be secured by backstitching.

3.7.29 Outer pocket. The top edge of the outer pocket must be turned under 5/8-inch (15.9 mm) and stitched at 1/8-inch (3.2 mm) gauge. The slider, when in the closed position, must be away from the inseam. Place folded edge over slide fastener covering half the fastener chain and stitch in place.

3.7.29.1 With the right sides together and the top of the inside ply aligned with the upper edge of the slide fastener tape, seam the two layers together along each side and turn right side out. Double needle stitches must be placed along the edge of the leg restraint channel openings.

3.7.30 Zip cover. A piece of shell must be folded in three, as per indicated on pattern drawing, and free edge stitched at 1/8-inch (3.2 mm) gauge. The cover must be positioned over the slide fastener covering half the chain and stitched in place.

3.7.30.1 Position the pocket assemblies on their respective leg and turn under the raw edges 3/8-inch (9.5 mm). Double needle stitch along the zip cover and down each from the top of the pocket for 4-1/4 inches (10.8 cm). Leaving an opening of no less than 3-inches (7.6 cm), double stitch the bottom portion of each side in place.

3.7.30.2 A row of machine basting must be placed through all layers across the leg restraint channel openings and centred between the two rows of topstitching.

3.7.31 Back crotch seam. The back leg portions must be joined at the back crotch seams with a double lapped seam. The seam must lap towards the left.

3.7.32 Joining the top and bottom. With the wrong sides together, the top and bottom must be joined along the waistline. The seam must be pressed open.

3.7.33 Waist suppression unit (Figure V).

3.7.33.1 Waistband reinforcement. There must be a waistband made from three pieces of shell material. There must be two front pieces with a loop tape as listed in Table III. The third piece must form the back channel for the elastic portion of the waist suppression system.

3.7.33.1.1 The back channel portion of the waistband must be turned and stitched at

both ends at 1/4-inch (6.3 mm). It must be positioned to overlap the front and finish at the side seams.

3.7.33.1.2 The waist reinforcement must be placed face up, centred over the waist seam. The edges must be folded under and stitched 1/16-inch (1.6 mm) gauge. The finished width of the waistband must be 1-3/4 inches (4.4 cm).

3.7.33.1.3 A piece of loop fastener tape as listed in Table III, must be stitched to the front waist reinforcement. This assembly must be positioned and sewn on the waist reinforcement as shown on the sealed pattern.

3.7.33.1.4 The waist suppression unit must consist of a 12-inch (30.4 cm) length of elastic braid, with a fabric tab measuring 1-inch (2.5 cm) by 8-inches (20.3 cm) stitched to each end. A piece of hook fastener tape as listed in Table III, must be stitched to each fabric tab. This assembly must be centred and threaded through the back channel and extend from the side seam towards the front.

3.7.34 Bartacks. A horizontal bartack must be placed 1/16-inch (1.6 mm) above the bottom edge of the waistband at the top of each side pocket.

3.7.35 Front crotch seam. The front crotch seam must be seamed and pressed open.

3.7.36 Front closure. The front closure consists of a covered slide fastener, piping cord, and fly placket.

3.7.36.1 Placket. The placket must be one piece of shell material. With the right sides together, the placket must be folded in half and seamed across the top, turned to the outside, top stitched at 1/4-inch (6.3 mm) gauge and serged along the remaining raw edges.

3.7.36.1.1 The slide fastener tape must be stitched to the serged edge of the placket with the top of the chain finishing 3/8-inch (9.5 mm) from the collar seam.

3.7.36.1.2 The front edges must be turned under 5/8-inch (15.9 mm) insert the cord in the fold and stitch close to the cord with a single row of stitching, as per sealed pattern. The folded edges must be placed over the slide fastener (and placket assembly for the right side) covering half the slider and stitched in place.

3.7.37 Joining inseams. The legs must be joined along the inseams using double lapped seams with the lap towards the back. The bottom of the placket must be included in this seam.

3.7.37.1 Each side of the front crotch must be topstitched at 1/4-inch (3.2 mm) gauge, through all plies.

3.7.38 Leg bottoms. The bottom of each leg must be turned up 2-inches (5.0 cm), the raw edge turned under 3/4-inch (19 mm) and double needle stitched.

3.7.39 Zip cover for leg suppression. A piece of shell material must be folded in three and the free edge stitched at 1/8-inch (3.2 mm) gauge. The cover must be positioned over the slide fastener covering half the chain and stitched in place.

3.7.39.1 Each zip cover must be placed over the slide fastener covering half the slider chain and stitched in place. When open, the slider stopper must be at the top.

3.7.40 Leg suppression. The zip cover and slide fastener assembly must be opened and positioned at the bottom of each leg to form an inverted "V". The raw edges must be turned under 5/8-inch (15.9 mm) and double needle stitched. The ends of the slide fastener tapes must be included in this operation.

3.7.41 Collar. The collar must be made from three pieces of shell material.

3.7.41.1 Two layers must be stitched together diagonally across the width of the collar to form the under collar.

3.7.41.2 The under and upper collar pieces must be stitched together along the ends and fall edge, turned and properly worked out.

3.7.41.3 The under collar must be seamed to the neck edge and the seam pressed towards the collar.

3.7.41.4 The neck edge of the upper collar must be turned under and stitched to the coverall neck seam at 1/16-inch (1.6 mm) gauge. The ends of the front slide fastener must be included in this operation.

3.7.41.5 The collar ends and fall edge must be double needle stitched or stitched 1/16-inch (1.6 mm) and 1/4-inch (6.3 mm) gauge through all layers.

3.8 Measurements. Measurements must be as shown on the applicable Figures and Table I: Scale of Measurements.

3.9 Pressing. The Coveralls must be properly pressed in accordance with good commercial practice and to the satisfaction of the Quality Assurance Authority.

3.10 Marking label. A marking label in accordance with D-80-001-055/SF-001 must be sewn by the supplier/contractor on the inside on the Coverall under the right breast pocket location, on the inside of the upper front. Refer to the applicable figure for a sample of the marking and care label. The marking must be printed in black on a green label for Coverall Type I and a tan label for Coverall Type II. The label must give the following information printed in characters not less than 1/8-inch (3.2 mm) nor more than 1/4-inch (6.3 mm) in height, with the exception of the size identification which must be twice the height:

- a. Abbreviated Nomenclature (Coveralls Flyers' FR / Combinaison vol ignifuge)
- b. NATO Stock Number (see Table IV or V);
- c. Size by height and chest (see Scale of Measurements – Table I);

- d. NATO size designation (see Scale of Measurements – Table I);
- e. Contract Number;
- f. Contractor Name. No initials, logos or trademarks shall be used;
- g. Date of Manufacture;
- h. Fibre content; (aramid, aramid/PFR viscose or 50% aramid / 50% FR viscose);
- i. Care symbols (see para 3.11) in black ink; and
- j. The following care instructions:

COVERALLS, FLYERS', COMBAT, FLAME RESISTANT

- 1. WASH NEW GARMENTS BEFORE WEARING.
- 2. A SECOND, CLEAN WATER RINSE IS RECOMMENDED. DO NOT USE LIQUID FABRIC SOFTENER.

COMBINAISONS, VOL, COMBAT, IGNIFUGE

- 1. LAVER LE VÊTEMENT NEUF AVANT DE LE PORTER.
- 2. DEUX RINCAGES SONT RECOMMANDÉS. NE PAS UTILISER D'ASSOUPLISSANT LIQUIDE.

3.11 Care labelling. Care symbols must be included on the marking label. The following care symbols, as defined in CAN/CGSB-86.1-2003 must be used.

3.11.1 Type I and II Coveralls:

- a. Table 1 – Washing – symbol 8;
- b. Table 2 – Bleaching – symbol 2;
- c. Table 3 – Drying – symbol 4;
- d. Table 4 – Ironing/Pressing – symbol 2; and
- e. Table 5 – Professional Textile Care – symbol 1.

3.12 Finishing. Coveralls must be cleaned, smoothed, and folded. Garments must be individually packaged in accordance with **CFTPO-GENERAL**. The abbreviated nomenclature for the label on the bags should read:

Type I Coveralls: Coveralls, Flying, Combat, FR
Combinaisons, vol, combat, ignifuge

Type II Coveralls: Coveralls, Flying, Combat, FR
Combinaisons, vol, combat, ignifuge

**TABLE III: NSN'S FOR COVERALLS, FLYERS',
COMBAT, FR, AIR FORCE GREEN (Type I Coverall)**

Size	NSN
A/A	8415-20-006-3673
6434	8415-20-006-3674
6436	8415-20-006-3675
6438	8415-20-006-3676
6440	8415-20-006-3677
6734	8415-20-006-3678
6736	8415-20-006-3679
6738	8415-20-006-3680
6740	8415-20-006-3681
6742	8415-20-006-3682
6744	8415-20-006-3683
6746	8415-20-006-3684
7034	8415-20-006-3685
7036	8415-20-006-3686
7038	8415-20-006-3687
7040	8415-20-006-3688
7042	8415-20-006-3689
7044	8415-20-006-3690
7046	8415-20-006-3691
7048	8415-20-006-3692
7050	8415-20-006-3693
7052	8415-20-006-3694
7336	8415-20-006-3695
7338	8415-20-006-3696
7340	8415-20-006-3697
7342	8415-20-006-3698
7344	8415-20-006-3699
7346	8415-20-006-3700
7348	8415-20-006-3701
7350	8415-20-006-3702
7352	8415-20-006-3703
7638	8415-20-006-3704
7640	8415-20-006-3705
7642	8415-20-006-3706
7644	8415-20-006-3707
7646	8415-20-006-3708
7648	8415-20-006-3709
7650	8415-20-006-3710
7652	8415-20-006-3711
7940	8415-20-006-3713
7942	8415-20-006-3714
7944	8415-20-006-3715

Size	NSN
7946	8415-20-006-3716
Special	8415-20-006-3717

**TABLE IV: NSN'S FOR COVERALLS, FLYERS',
COMBAT, FR, TAN (TYPE II Coverall)**

Size	NSN
A/A	8415-20-009-9950
6434	8415-20-009-9951
6436	8415-20-009-9952
6438	8415-20-009-9953
6440	8415-20-009-9954
6734	8415-20-009-9955
6736	8415-20-009-9956
6738	8415-20-009-9957
6740	8415-20-009-9958
6742	8415-20-009-9959
6744	8415-20-009-9960
6746	8415-20-009-9961
7034	8415-20-009-9962
7036	8415-20-009-9963
7038	8415-20-009-9964
7040	8415-20-009-9965
7042	8415-20-009-9966
7044	8415-20-009-9967
7046	8415-20-009-9968
7048	8415-20-009-9969
7050	8415-20-009-9970
7052	8415-20-009-9971
7336	8415-20-009-9972
7338	8415-20-009-9973
7340	8415-20-009-9974
7342	8415-20-009-9975
7344	8415-20-009-9976
7346	8415-20-009-9977
7348	8415-20-009-9978
7350	8415-20-009-9979
7352	8415-20-009-9980
7638	8415-20-009-9981
7640	8415-20-009-9982
7642	8415-20-009-9983
7644	8415-20-009-9984
7646	8415-20-009-9985

Size	NSN
7648	8415-20-009-9986
7650	8415-20-009-9987
7652	8415-20-009-9988
7940	8415-20-009-9989
7942	8415-20-009-9990
7944	8415-20-009-9991
7946	8415-20-009-9992
Special	8415-20-009-9993

TABLE I - SCALE OF MEASUREMENTS FOR
COVERALL FLYERS' COMBAT

MEASUREMENTS OF BODY				MEASUREMENTS OF GARMENT											
SIZES BY HEIGHT AND CHEST	NATO SIZE	HEIGHT WITHOUT SHOES	CHEST OVER SHIRT	GIRTH MEASUREMENTS WITH GARMENT CLOSED		BACK LENGTH FROM COLLAR SEAM TO CENTRE OF WAIST BAND		FRONT LENGTH FROM COLLAR TO CENTRE OF WAIST BAND		LEGS		SLEEVE		LENGTH OF COLLAR AT ZIPPER NECK SEAM	FRONT ZIPPER LENGTH
				CHEST WAIST ABOVE CROTCH	SEAT 6" ABOVE CROTCH	CENTRE OF WAIST BAND	CROTCH SEAM	INSEAM	KNEE CIRC.	BOTTOM CIRC.	UNDER-ARM TO END OF CUFF	ELBOW CIRC.	CUFF CIRCUM-FERENCE AT SEAM		
6434	5060-8590	5'1"	33-34	44	33 1/2	41	17 1/2	20 3/4	17 3/4	20 3/4	17 3/4	15 3/8	10 1/2	15 1/2	25
6436	5060-9095	to	35-36	46	35 1/2	43	18	21 1/4	18	21 1/4	18	16	10 3/4	16	
6438	5060-9500	5'3 1/2"	37-38	48	37 1/2	45	18 1/2	21 3/4	18 1/4	21 3/4	18 1/4	16 3/8	11	16 1/2	
6440	5060-0005		39-40	50	39 1/2	47	19	22 1/4	18 1/2	22 1/4	18 1/2	17 1/8	11 1/4	17	
6734	6070-8590		33-34	44	33 1/2	41	17 1/2	20 3/4	17 3/4	20 3/4	17 3/4	15 5/8	10 1/2	15 1/2	26 1/2
6736	6070-9095		35-36	46	35 1/2	43	18	21 1/4	18	21 1/4	18	16	10 3/4	16	
6738	6070-9500	5'4"	37-38	48	37 1/2	45	18 1/2	21 3/4	18 1/4	21 3/4	18 1/4	16 3/8	11	16 1/2	
6740	6070-0005	to	39-40	50	39 1/2	47	19	22 1/4	18 1/2	22 1/4	18 1/2	17 1/8	11 1/4	17	
6742	6070-0510	5'6 1/2"	41-42	52	41 1/2	49	19 1/2	23 1/4	19	23 1/4	19	17 3/8	11 1/2	17 1/2	28
6744	6070-1015		43-44	54	43 1/2	51	20	23 3/4	18 3/4	23 3/4	18 3/4	17 3/4	11 3/4	18	
6746	6070-1520		45-46	56	45 1/2	53	20 1/2	24 1/4	19 1/4	24 1/4	19 1/4	18 1/8	12	18 1/2	
7034	7080-8590		47-48	58	47 1/2	55	21	25 1/4	19 1/2	25 1/4	19 1/2	18 1/8	12 1/4	19	
7036	7080-9095		49-50	60	49 1/2	57	21 1/2	26 3/4	19 3/4	26 3/4	19 3/4	18 7/8	12 1/2	19 1/2	29 1/2
7038	7080-9500		51-52	62	51 1/2	59	22	27 1/4	20	27 1/4	20	19 1/4	12 3/4	20	
7040	7080-0005	5'7"	35-36	46	35 1/2	43	18	21 1/4	18	21 1/4	18	16 1/4	10 3/4	16	
7042	7080-0510	to	37-38	48	37 1/2	45	18 1/2	22 1/4	18 1/4	22 1/4	18 1/4	16 5/8	11	16 1/2	
7044	7080-1015	5'9 1/2"	39-40	50	39 1/2	47	19	23 1/4	19	23 1/4	19	17	11 1/4	17	31
7046	7080-1520		41-42	52	41 1/2	49	19 1/2	24 1/4	19 1/2	24 1/4	19 1/2	17 3/8	11 1/2	17 1/2	
7048	7080-2025		43-44	54	43 1/2	51	20	25 1/4	19 1/4	25 1/4	19 1/4	18 1/8	12	18 1/2	
7050	7080-2530		45-46	56	45 1/2	53	20 1/2	26 3/4	19 3/4	26 3/4	19 3/4	18 7/8	12 1/2	19 1/2	
7352	8090-3035		47-48	58	47 1/2	55	21	27 1/4	20	27 1/4	20	19 1/4	12 3/4	20	32 1/2
7336	8090-9095		51-52	62	51 1/2	59	22	28 1/4	20	28 1/4	20	19 1/4	12 3/4	20	
7338	8090-9500		35-36	46	35 1/2	43	18	21 1/4	18	21 1/4	18	16 1/4	10 3/4	16	
7340	8090-0005	5'10"	37-38	48	37 1/2	45	18 1/2	22 1/4	18 1/4	22 1/4	18 1/4	16 5/8	11	16 1/2	
7342	8090-0510	to	39-40	50	39 1/2	47	19	23 1/4	19	23 1/4	19	17	11 1/4	17	29
7344	8090-1015	6'1/2"	41-42	52	41 1/2	49	19 1/2	24 1/4	19 1/2	24 1/4	19 1/2	17 3/8	11 1/2	17 1/2	
7346	8090-1520		43-44	54	43 1/2	51	20	25 1/4	19 1/4	25 1/4	19 1/4	18 1/8	12	18 1/2	
7348	8090-2025		45-46	56	45 1/2	53	20 1/2	26 3/4	19 3/4	26 3/4	19 3/4	18 7/8	12 1/2	19 1/2	
7638	9000-9500		47-48	58	47 1/2	55	21	27 1/4	20	27 1/4	20	19 1/4	12 3/4	20	31
7640	9000-0005		49-50	60	49 1/2	57	21 1/2	28 1/4	20	28 1/4	20	19 1/4	12 3/4	20	
7642	9000-0510	6'1"	51-52	62	51 1/2	59	22	29 1/4	20	29 1/4	20	19 1/4	12 3/4	20	
7644	9000-1015	to	37-38	48	37 1/2	45	18 1/2	21 1/4	18 1/4	21 1/4	18 1/4	16 1/4	10 3/4	16	
7646	9000-1520	6'3 1/2"	39-40	50	39 1/2	47	19	22 1/4	18 1/2	22 1/4	18 1/2	16 5/8	11	16 1/2	31
7648	9000-2025		41-42	52	41 1/2	49	19 1/2	23 1/4	19	23 1/4	19	17 3/8	11 1/2	17 1/2	
7650	9000-2530		43-44	54	43 1/2	51	20	24 1/4	19 1/2	24 1/4	19 1/2	18 3/4	12 1/4	19	
7652	9000-3035		45-46	56	45 1/2	53	20 1/2	25 1/4	19 3/4	25 1/4	19 3/4	18 7/8	12 1/2	19 1/2	
7942	0010-0005	6'4"	51-52	62	51 1/2	59	22	26 3/4	20	26 3/4	20	19 1/4	12 3/4	20	32 1/2
7944	0010-0510	to	39-40	50	39 1/2	47	19	23 1/4	19 1/2	23 1/4	19 1/2	18 3/4	12 1/2	19 1/2	
7946	0010-1015	6'7"	40-41	52	41 1/2	49	19 1/2	24 1/4	19 1/2	24 1/4	19 1/2	19 3/8	12 1/2	19 1/2	
7948	0010-1520		42-43	54	43 1/2	51	20	25 1/4	19 1/4	25 1/4	19 1/4	19 3/8	12 1/2	19 1/2	
TOLERANCE PLUS OR MINUS				1"	1"	1"	1/4	3/4	1/4	1/2	1/2	1/2	1/4	1/4	1/4

FIGURE I - FRONT AND BACK VIEW

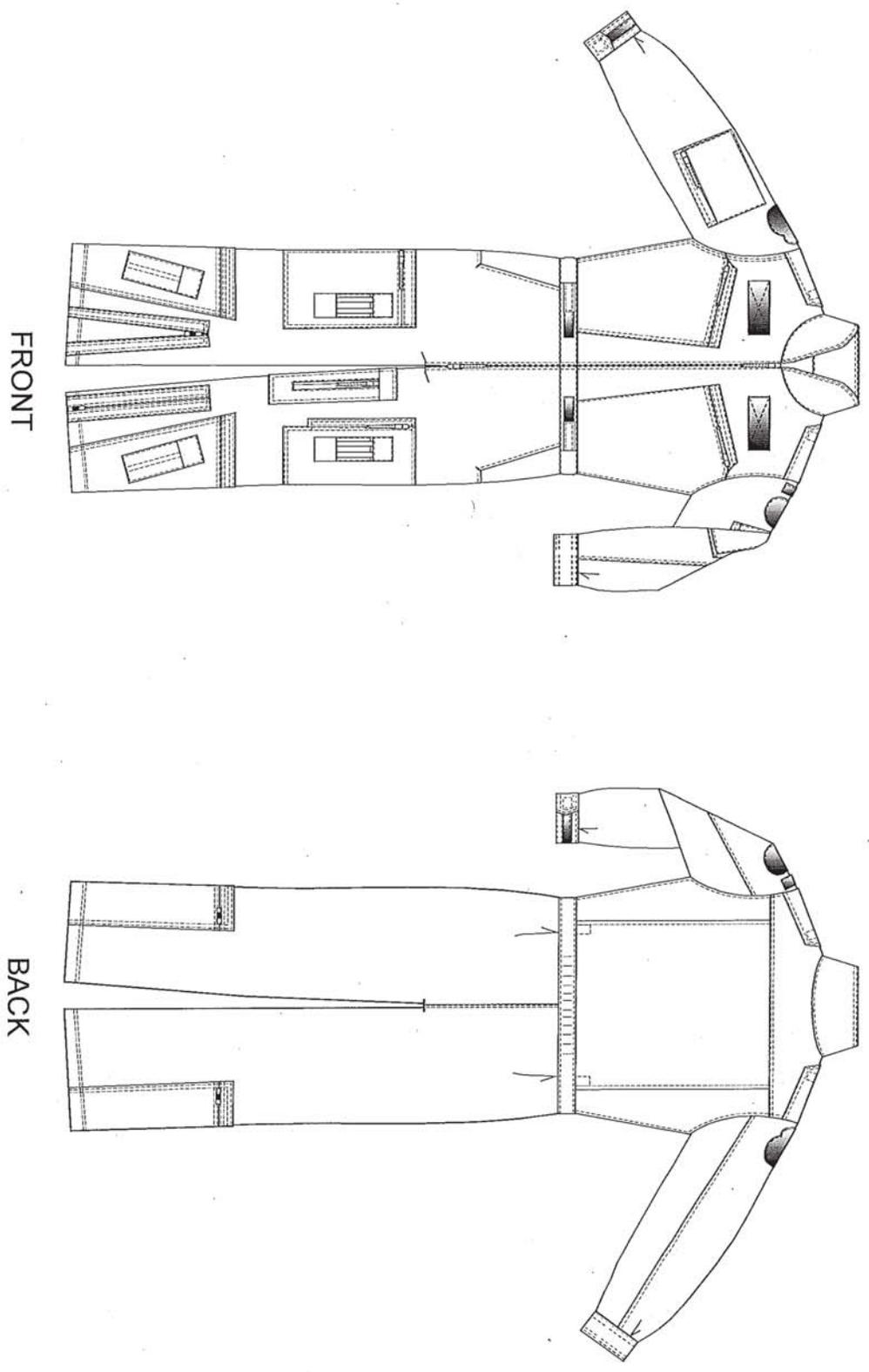


FIGURE II - GARMENT COMPONENTS

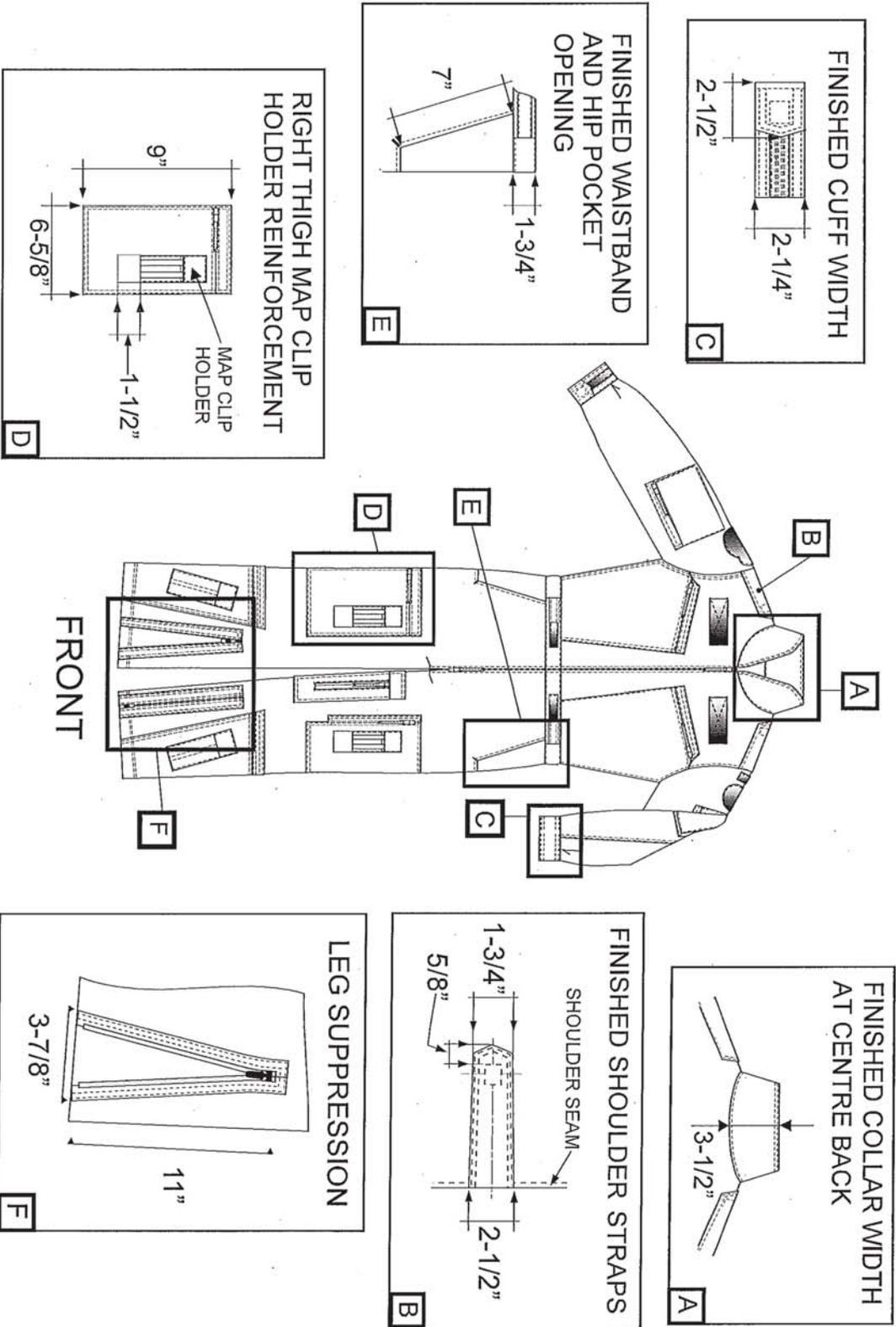


FIGURE III - POCKET SYSTEMS

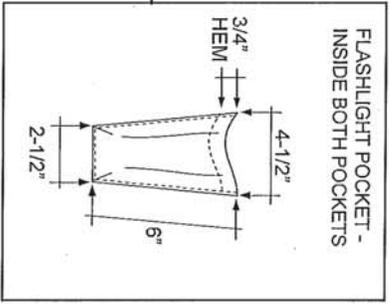
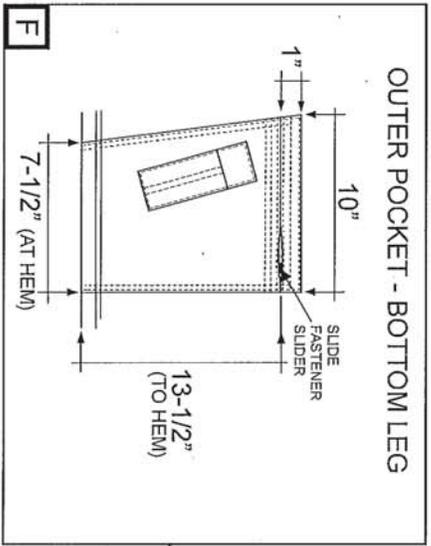
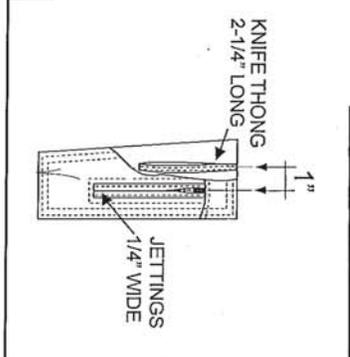
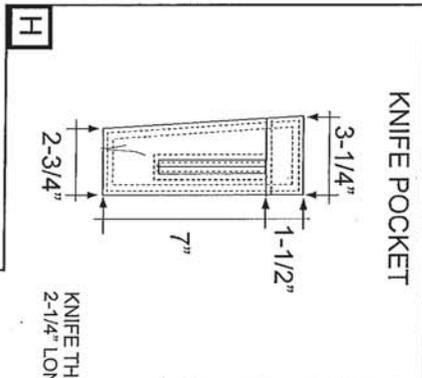
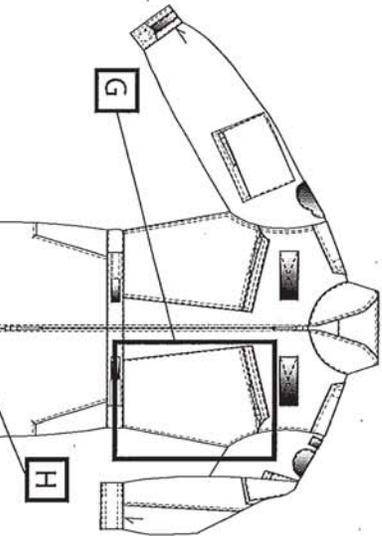
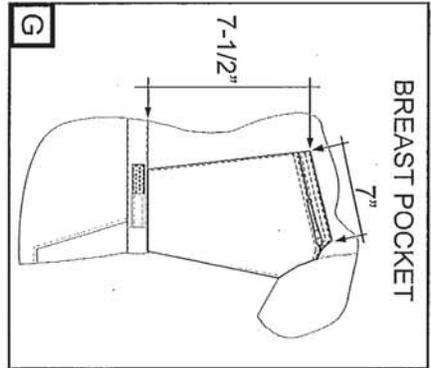


FIGURE IV - POCKET SYSTEMS II

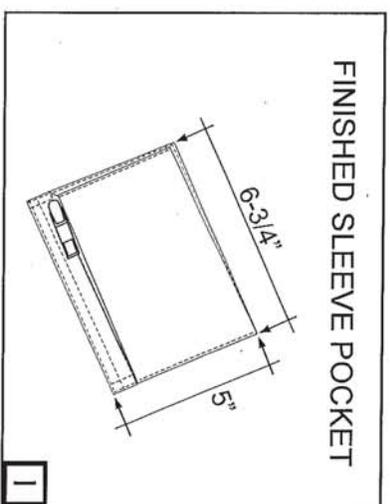
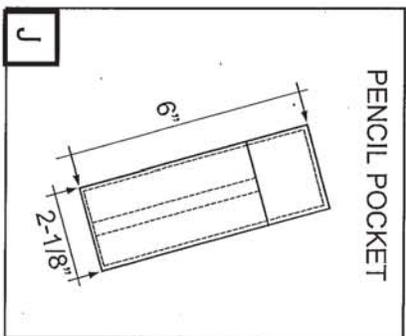
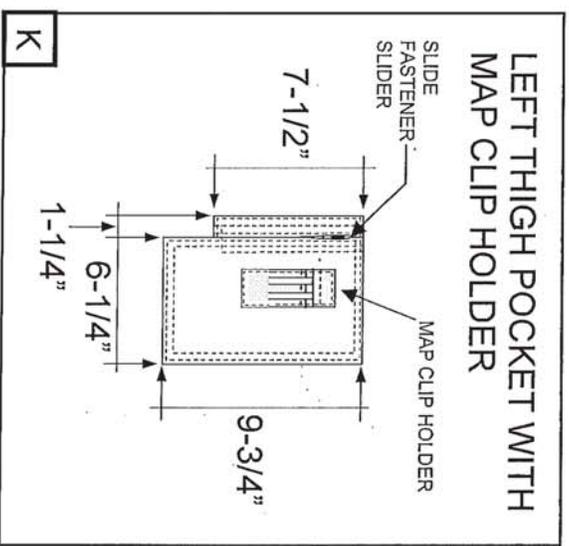
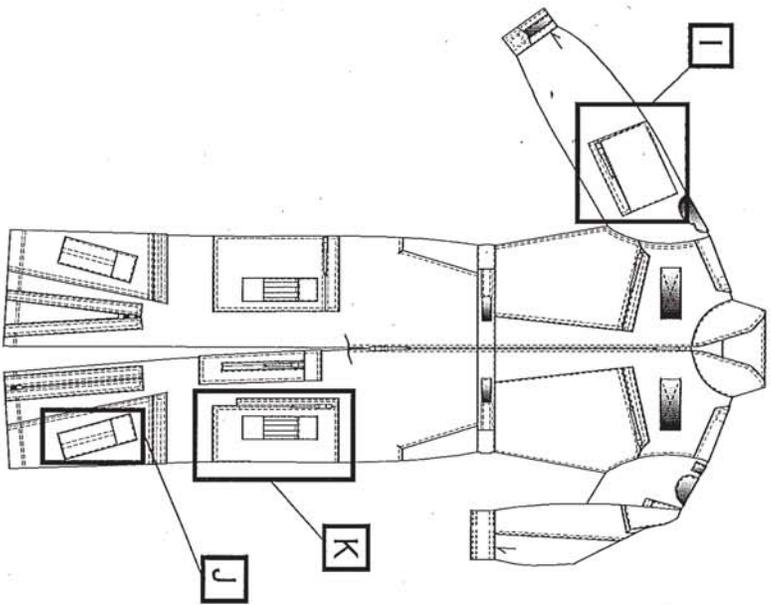
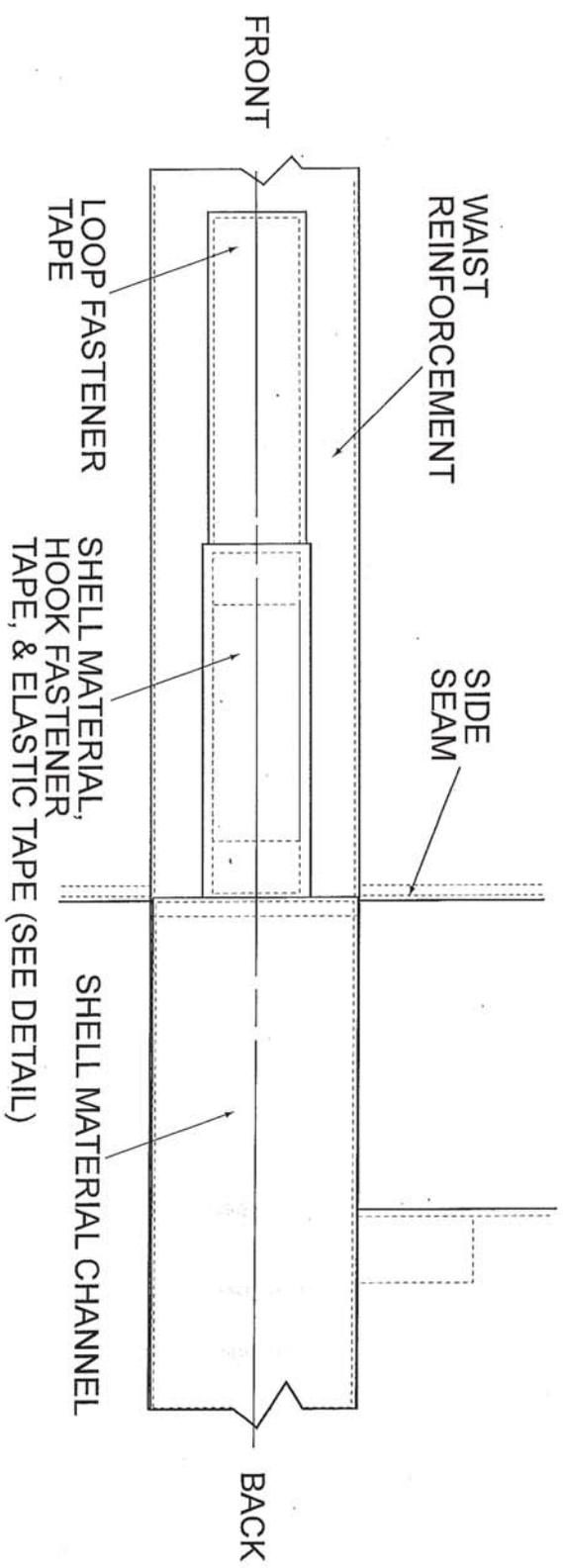


FIGURE V - WAIST SUPPRESSION (RIGHT SIDE SEAM SHOWN)



WAIST SUPPRESSION DETAIL

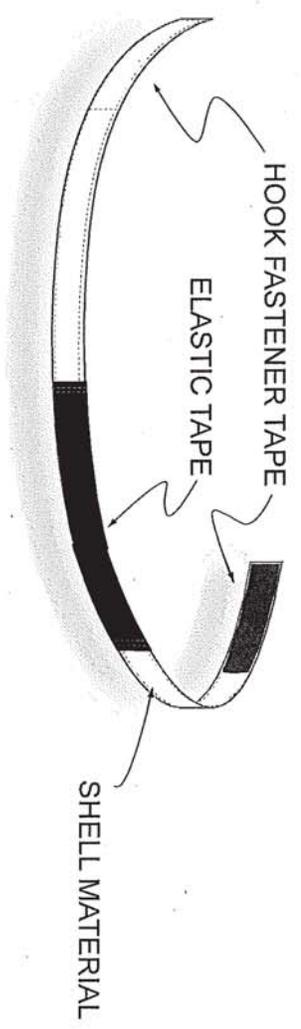


FIGURE VI - CARE AND MARKING LABEL FOR TYPE I & II COVERALLS

USER ID	CARE INSTRUCTIONS	CARE SYMBOLS	ITEM & CONTRACT INFO
ID DE L'UTILISATEUR	CONSIGNES D'ENTRETIEN	SYMBOLES D'ENTRETIEN	ARTICLE ET INFO SUR LE CONTRAT
<p>ID _____</p>	<p>1. WASH GARMENTS BEFORE WEARING. 2. A SECOND, CLEAN WATER RINSE IS RECOMMENDED. DO NOT USE LIQUID FABRIC SOFTENER.</p> <p>1. LAVER LE VÊTEMENT NEUF AVANT DE LE PORTER. 2. DEUX REINÇAGES SONT RECOMMANDÉS. NE PAS UTILISER D'ASSOUPLISSANT LIQUIDE.</p>	<p>50°C  Permanent press medium heat / Pressage permanent / moyenne température.  Iron at medium temperature. / Repasser à moyenne température.  Non-chlorine bleach as needed / Blanchissant non-chlorine si nécessaire.  Dry clean w/solvents other than Trichloroethylene / Nettoyage à sec avec des solvants autre que trichloroéthylène.</p>	<p>COVERALLS, FLYERS, COMBAT, FR COMBINAISON DE VOL DE COMBAT, IGNIFUGE NSN/NNO: 8415-20-XXX-XXXX SIZE/TAILLE : 7040 NATO SIZE / TAILLE OTAN : XXXX-XXX CONTRACT NO. / NO. DE CONTRAT: WXXXX-XXXXX CONTRACTOR NAME/NOM D'ENTREPRENEUR: Jones & Company DATE OF / DE MANUFACTURE: MM/YY FIBRE CONTENT / TENEUR DE FIBRES: XXXXXXXXXXXXXXX</p>

FIGURE VII - TEMPLATE FOR UPPER SLEEVE LOOP TAPE PATCHES

