INCH-POUND
WP-PD-11-001
21 March 2017

PURCHASE DESCRIPTION
PARKA, BLACK, CADET

This purchase description is approved for use by the United States Military Academy (USMA).

1. SCOPE

1.1 Scope. This purchase description covers the requirements for a Parka constructed with a shell melton cloth with the contents 90% Wool and 10% Nylon (+/- 3%). The Parka covered by this Purchase Description is intended to be worn by the Corps of Cadets at United States Military Academy at West Point.

1.2 Classification. The Parka shall be made in the following lengths and sizes:

Schedule of Sizes

Chest	Length					
	X-Short	**Short**	**Regular**	**Long**	**X-Long**	**XX-Long**
32	X	X	X	--	--	---
34	X	X	X	X	--	--
36	X	X	X	X	X	--
38	X	X	X	X	X	X
40	X	X	X	X	X	X
42	X	X	X	X	X	X
44	X	X	X	X	X	X
46	X	X	X	X	X	X
48	X	X	X	X	X	X
50	X	X	X	X	X	X
52	--	X	X	X	X	X
54	--	--	X	X	X	X
56	--	--	--	X	X	X

2. **Salient Characteristics**

2.1 Description. The parka shall be unlined and conform to the patterns provided. It shall have a hood with zipper closure, front zipper closure, two front slant-pockets with double welts, and knit sleeve cuffs. All materials will be provided by the government.

2.2 Stitching. All stitching shall be 8 to 9 stitches per inch. Seams shall be sewn with a $^{3}/_{8}$" seam allowance (+/- $^{1}/_{16}$") with exceptions as noted herein this description.

2.3 All seams shall be secured with either a back tack stitch at the beginning and end, or in the case of seams which end at the point where they were started, these seams shall be secured by sewing over the starting stitches by 3-6 stitched.

2.4 All thread tails shall be trimmed to within 1/8" of the surface of the material in which the seam was sewn.

2.4 **Material**

2.4.1 Basic Material. The material for the parka outer shell, facing, and hood linings shall be Cloth, Melton, Wool, Type II, weighing 18-20.5 ounces per square yard, composed of 90% reprocessed wool and 10% nylon (+/-3.0%), 58-60" wide excluding selvage, and the color, USMA Local Stock Number C0255 dated 29 Oct 2010). Fabric will be provided by the government as Government Furnished Material (GFM) in rolls. Some of the fabric may have slight shade variation.

2.4.2 Pocket Welt Material. The material for the pocket welt will be 100 percent Merino Wool flannel cloth Class 2, Eight (8) ounces per square yard (+0.25/-0), Color Black, as specified in Purchase Description GL/PD-09-09 dated 1 July 2009 and will be provided by the government as Government Furnished Material (GFM).

2.4.3 Knit Sleeve Cuffs. Sleeve cuffs will be provided by the government as Government Furnished Material (GFM). Knitted sleeve cuffs will be in two sizes, regular and large where large knit sleeve cuffs will be used in sleeves of Parkas with chest size 46 and greater. Cuff should follow the size of the sleeve width.

2.4.4. Zippers. Salient features: Black tape with matte black zipper finish, gauge size: 8, 8mm chain width, Average 7 teeth per inch, teeth should be vision or equal in strength, Crosswise pull breaking strength between 95 and 100 P.S.I., Tape of 100% Polyester with heat sealed ends, must be able to withstand commercial cleaning. Zippers will be provided by the government as Government Furnished Material (GFM).

2.4.5. Front Zippers.

Parka Front Zipper Table

Parka Length	**Front Zipper Length**
XS	20"
S	21"
R	22"
L	23"
XL	24"
XXL	25"

2.4.6. Hood Zippers.

Parka Hood Zipper Table

Parka Chest Size	**Hood Zipper Length**

32	9”
34	9”
36	9.5”
38	9.5”
40	10“
42	10”
44	10.5”
46	10.5”
48	11”
50	11”
52	11”
54	11”
56	11”

2.4.7. Thread. The thread for all seaming and stitching shall be TEX 40 Soft, core-spun, cotton/polyester, color black.

2.5 **Labels**.

2.5.1 Manufacturer Combination label. Each parka shall have a white, commercial type combination identification/instruction/personal label which shall not exceed two and a half (2.5) inches in height by three (3) inches in width. The label shall be sewn to jacket, centered approximately 2 inches below the center back hood seam. The inscription shall show “good” colorfastness to laundering and shall contain the following information:

NAME OF MANUFACTURER
PARKA, BLACK
100% MELTON WOOL
DRY CLEAN ONLY
NAME:_____

2.5.2 Size/Barcode Label. Each parka shall have a white, commercial type size/barcode label centered below the manufacturer’s combination label. Size/Barcode label will be provided by the government as Government Furnished Material (GFM). See manufacturing instructions below for label positioning, paragraph VII.

2.5.3. Sample. The Government will provide the contractor with a USMA Standard Sample parka in the base size, 40 Regular as a reference for manufacturing construction. The Contractor shall return the USMA Standard Sample parka upon or prior to shipping the completed contract order. The USMA Standard Sample shall be shipped to:

The United States Military Academy
Building 687 Warehouse
687 Rogers Place,
West Point, NY 10996.

2.6 **Parka cutting**

2.6.1 Parka patterns. Parka patterns can be provided by the Government in Gerber AccuMark version 9.0 files. The Government will provide Gerber AccuMark Storage area including all pieces, Model, Size Code, Rule Table, Alteration Table, Notch Table (WP NOTCH), P-CUTTER, Block Buffer, Lay Limits (single ply), P-Piece-Plot, and P-USER Environment W-Find Imperial.

2.6.2 Pattern conversion to other CAD software. Contractor shall convert if need be Government Gerber files to a CAD system of their choice without modifying dimensions of pattern pieces.

2.6.3 Gerber Storage Area Gerber AccuMark Storage Area includes the following Parka pattern piece files:

1. Front (FRT): fabric code S (shell)
2. Back (BCK): fabric code S
3. Facing (FAC): fabric code S
4. Hood (HOOD): fabric code S
5. Pocket Lining (PCKT): fabric code S
6. Pocket Lining Small (PKCT SM): fabric code S
7. Sleeves (SLV): fabric code S
8. Pocket Marker (POCKET MARKER): fabric code Z, only for printing pocket position markers.

2.6.4 Gerber AccuMark Model PARKA In the Gerber AccuMark Model "PARKA" Orders to Marker Making are programmed to provide two of every piece except the back. For those pieces which are provided with two in marker making, the ordered pieces are programmed to flip one and not the second piece to provide a left and a right piece in markers for single ply lays of contractor. Orders of Backs to Marker Making will bring only one piece as it is a one-piece back.

2.6.5 Gerber AccuMark Ordering and Pocket Linings. When creating Orders of the Gerber Model PARKA, the order will automatically provide the proper sized pocket lining for the corresponding Parka size. Pocket linings come in two sizes. Parkas with chest size 32 and 34 will automatically have Pocket Linings SMALL (PCKT SM) brought up in the order for marker making. Parkas size 32 and 34 shall be made using small pocket linings which are shorter than the full sized Pocket Linings (PCKT). All other sizes of parkas shall be produced using the full sized Pocket Linings (PCKT) which is automatically provided in the order for marker making of those sizes.

2.6.6 Cloth Spreading Parkas cloth is spread face down single ply in accordance with Gerber Lay Limits in multiples of 7 plies.

2.6.7 Order Quantities by size. Parkas will be ordered in multiples of seven (7) allowing for boxes of seven parkas per box.

2.7 Parka manufacturing. Contractor does not need to follow the operational sequence below however it is a guide to the design's construction. Any alternative construction shall provide a parka with the same appearance as the USMA Standard Sample.

I) Make and close hoods.

a) Hood zipper lengths shall be determined by the parka chest size in accordance with the Hood Zipper Table.
b) With the hood zipper closed, position closed end of hood zipper ¼" to $^{1}/_{8}$" past with the $^{3}/_{8}$" deep slit-notch at the center of the zipper-edge of the hood shell piece.
c) Sew a seam ¼" in from the zipper's fasteners on the zipper tape starting at the point even with the bottom of the zipper closure, to the end of the zipper tape which may in some cases extend beyond the end of the zipper-edge of the hood.
d) Attach the other side of zipper in same manner to the other half of the hood shell piece.
e) Position zipper-edge of the hood lining piece with the zipper edge of the hood shell and set zipper to hood lining by sewing seams on top of seams on zippers to hood shell.
f) Close left and right front edges of the hood and hood linings leaving neck-edge open.
g) Open hood zipper.

II) Mark Pocket opening positions.
a) Slanted Pocket opening positions are marked on parka fronts using a CAD-Pattern "Pocket Marker" corresponding with the Parka Chest size and Length.
b) One Pocket Marker may be used for all lengths of a single/particular chest size. There are five (5) notches at the top corner at the intersection of the Front-edge and the neck opening on the Pocket Marker. The top corner of the front edge of the Pocket Marker is the top alignment point for Extra-Extra Long (XXL) fronts. The notch immediately below that corner is the top alignment point for Extra Long (XL) fronts, the next notch below that is for Long (L) fronts, then Regular (R), Short (S) and finally the bottom notch is the top alignment point for Extra-Short (XS) fronts.
c) Pocket markers are aligned on parka fronts by first aligning the notch which corresponds to the length of the Parka (XXL, XL, L, R, S and XS) with the corner at top front-edge of the front; then aligning the bottom front-edge corner of the pocket marker with the front edge of the parka front.

III) Cut and join pocket welts.
a) Cut opening shall be 6¼ inches in length with two 6mm long "V" notches at each end of the pocket opening. "V" notches shall be 6mm or such length to cleanly turn the pocket welts in a manner which allows them to fold flat forming an evenly shaped and matching top and bottom welt.
b) Pocket welt material shall be lighter weight Black Wool Melton pieces supplied by the Government.
   i) Pocket Welt pieces provided are cut on a slant suited for the angle of slant on front pockets/markers and measure 2¾ x 8½ inches.
c) Overall welt opening shall be ½" (+/- $^{1}/_{16}^{th}$).
d) Pocket welt pieces shall be centered on the 6¼ opening.
e) Top and bottom welts shall be rectangular in appearance, ¼" tall (+/- $^{1}/_{32}$) and the entire length of the cut opening.

IV) Topstitch pocket welts.

NOTE: Pocket welts are machine sewn.

a) Sew a $^{1}/_{16}$th inch parallelogram shaped topstitch seam around the slanted outside of pocket welt opening (+/- $^{1}/_{32}$).
b) Stitching over the end of the seam above to tack or reinforce the end of the pocket opening, sew a $^{3}/_{8}$" topstitch seam parallel to the pocket opening to secure the lower pocket welt edge on the inside of the pocket opening.

V) <u>Close pockets.</u>
a) Position the top slanted-edge of the pocket lining 1" (+ 0 / - $^{1}/_{8}$") above and parallel to the upper pocket welt seam. Pocket lining shall be centered left to right on the pocket opening.
b) Sew $^{3}/_{8}$" seam from the top-edge of the top welt piece across the top of the pocket lining, turning and sewing a $^{3}/_{8}$" seam attaching a side of the pocket lining to the front and also attaching the pocket lining to the end of the welt. This seam continues down and fairly parallel to front edge and a minimum of ½" in from the edge of the pocket lining; turning at the bottom of the pocket lining following the curvature of the lower pocket lining corner to ½ to $^{3}/_{8}$ from the bottom-edge of the pocket lining, across the bottom of the pocket lining; then curving back up the other side of the pocket lining once again catching the pocket welt's other ends. This seam shall end by sewing 6-7 stitches over the starting stitches of the seam and several back-tack stitches to secure the seam threads.

VI) <u>Join front-zipper and facing to fronts.</u>
a) Front zipper lengths shall be determined by the parka length (XS, S, R, L, XL, XXL) in accordance with the <u>Front Zipper Table</u>.
b) Position the top of the zipper fasteners face-down and ¾" (+$^{1}/_{8}$ – 0) below from the top corner of the front-edge and the neck-edge of the right front; and align the zipper tape edge even with the front edge of the parka front.
c) Fold the tape extension 45^{0} and attach the zipper to the front with a seam ¼" from the zipper's fasteners from the top of the zipper tape extension to the bottom of the zipper tape; tacking both ends of the seam securely.
d) Mark the position for the bottom of the zipper for the left front the same distance from the bottom-edge to bottom of zipper on the right front.
e) Set the left zipper in a similar manner finishing the seam at the top of the left front-edge at a point even with the start of the zipper on the right front sewn in a manner that allows the left and right front to align evenly at the neck when the zipper is closed.
f) Position the front-edge of the facing with the front-edge of the front and set the facing with a $^{3}/_{32}$nd" zipper foot seam as close as possible to the zippers fasteners. Repeat in opposite direction of the other facing.

VII) <u>Label sewing.</u>
a) The manufacturer's combination label shall be positioned 2" below and centered on the notch on the neck opening of the parka back.
b) Size/Barcode labels shall be placed below the manufacturer's combination label and centered.

c) The Contractor shall label parkas to identify the manufacturer of the parka. Contractors shall provide Manufacturer Label
d) Sew rectangular seams $^{1}/_{8}$" (+0 / -$^{1}/_{16}$th") around all edges of the manufacturer's combination label.

VIII) Join shoulders. Join shoulders with $^{3}/_{8}$" seams.

IX) Top-stitch shoulder seams. Sew a $^{1}/_{8}$" topstitch seam (+0 / -$^{1}/_{16}$th") on both sides of each shoulder seam, front and back.

X) Join hood.
a) Turn hood right side out.
b) Position the front-edge of the hood $^{3}/_{8}$" past the front edge of front. Tack the corner of hood on neck-edge to the top of the facings. Repeat for opposition front edge of hood.
c) Position the hood shell neck-edge with the neck-edge of fronts and back. Sew a $^{3}/_{8}$" seam attaching hood shell to front and back along the neck opening.
d) Position the hood lining neck-edge even with the neck-edge of the facing and sew $^{3}/_{8}$" seam from the tack in b above to the end of the neck-edge of the facing.

XI) Press hood.
a) Press open the hood lining-to-facing seams.
b) Press to compress the thick hood-to-front-edge seams at that intersecting point.

XII) Topstitch parka.
a) Starting at the bottom of the right front-edge, sew a $^{3}/_{8}$" topstitch seam up the front-edge, continuing up to the left hood front-edge, turning and following along the left hood zipper-edge to a point 1½" (+/- $^{1}/_{8}$") before the end of the hood zipper. At this point sew 1½" (+/- $^{1}/_{8}$") semi-circular top stitch seam around the zipper end to the point $^{3}/_{8}$" away from the right hood zipper-edge and continue sewing $^{3}/_{8}$" top stitch seam along the right hood zipper-edge, turn to follow the right hood front-edge and right front-edge of the front to bottom of the right front.
b) Position the shoulder-edge of facing even with the shoulder-edge of the back and attach the facing sewing a seam $^{3}/_{8}$" from the shoulder-edge of the facing following the shoulder seam.

XIII) Set Sleeves.
a) Align the armhole edge of the sleeve $^{3}/_{8}$" beyond the armhole of the front at the side-seam.
b) Sew a ¼" seam from the edge of the front and back armholes for both sleeves.
c) Sew a ¼" top stitch seam along the armhole on the parka body, front and back.

XIV) Close side seams and sleeves.
a) Align the corner of the front side-edge at the armhole with the corner on the back at the armhole so the set-sleeve seams match at the front and the back.
b) Sew $^{3}/_{8}$" seam from the armhole to the bottom edge of the front.
c) Align the sleeve under-edges and sew a $^{3}/_{8}$" seam from armhole to sleeve-cuff along the under sleeve finishing with the sleeve cuff edges matching evenly.

XV) Hem Parka.

a) Fold bottom-edge up 1¼" (+$^3/_8$ / -0) to the inside and sew a $^3/_8$" seam from the cut bottom-edge (not the fold).
b) Starting from the left front-edge sew along the bottom edge to the right front-edge opening the side seams as the seam is sewn. Finish the seam on the right so that the resulting length of the right and left front match (+/- ¼") with the front zipper closed.

XVI) Set Sleeve knit cuffs.

a) With the sleeve turned inside out, insert the knit cuff inside the sleeve and align the edges of the sleeve knit-cuff with the cuff edge of the sleeve.
b) Sew around the circumference of the sleeve cuff using an over-edging 5-thread safety stitch (516 stitch) with a 4.8mm needle gauge, and 6.4mm (both +/-0.4mm) over-edging width; overlapping the start of the seam by an inch (+-/ ¼"). Sleeve edges at sleeve under-seam shall be opened when sewing the cuff seam across the sleeve under-seam.

XVII) Close front zipper and fold.

a) Zip front zipper completely closed.
b) With the parka front down, fold each side of the parka body front with the sleeve to back with the fold in a straight line from the shoulder at the hood seam to the bottom edge.
c) Fold the open hood back and on top of the sleeves.
d) Fold parka in half top to bottom.
e) Box the folded parka.

XVIII) Package parkas.

a) Folded parkas are packaged in boxes which when full will contain seven (7) parka's. Parkas will be folded as such: Sleeves folded to the back with the hood zipped and folded down on the back of the jacket then the jacket is folded over once horizontally.
b) Boxes will be provided by the government, as Government Furnished Property.
c) Boxes shall be securely close and identified with box labels supplied by the government, as Government Furnished Property.
d) Box label shall correctly indicate the size and quantity of parkas contained in a box.

2.8 **Finished Measurements.** The finished Parka shall conform to the measurements in Table III. All measurements are indicated in inches; the parka shall be measured lying flat and smooth, with the front zipper completely open.

2.9 **Circumference Table.** Front-edge to side-seam shall be measured $^3/_8$" to ½" under armhole seam and perpendicular to front edge. Across Back shall be measured from side-seam to side-seam $^3/_8$" to ½" under armhole seam and parallel to bottom edge

Chest size	Front-edge to side-seam	Across Back, side-seam to side-seam

32	9.5	20.75
34	10	21.75
36	10.5	22.75
38	11	23.75
40	11.5	24.75
42	12	2575
44	12.5	26.75
46	13	27.75
48	13.5	28.75
50	14	29.75
52	14.5	30.75
54	15	31.75
56	15.5	32.75
	+/- ½"	*+/- ½"*

2.10 **Back Length Table.** Back lengths shall be measured on the center of the back from the hood seam to the bottom edge perpendicular to the bottom edge.

Chest Size	X-Short	Short	Regular	Long	X-Long	XX-Long
32	26.75	28	29.25	30.5	31.75	33
34	27	28.25	29.5	30.75	32	33.25
36	27.25	28.5	29.75	31	32.25	33.5
38	27.5	28.75	30	31.25	32.5	33.75
40	27.75	29	30.25	31.5	32.75	34
42	28	29.25	30.5	31.75	33	34.25
44	28.25	29.5	30.75	32	33.25	34.5
46	28.5	29.75	31	32.25	33.5	34.75
48	28.75	30	31.25	32.5	33.75	35
50	29	30.25	31.5	32.75	34	35.25
52	29.25	30.5	31.75	33	34.25	35.5
54	29.5	30.75	32	33.25	34.5	35.75
56	29.75	31	32.25	33.5	34.75	36
	+/- 5/8"	*+/- 5/8"*	*+/- 5/8"*	*+/- 5/8"*	*+/- 5/8"*	*+/- 5/8"*

2.11 **Sleeve Length Table.** Sleeve lengths shall be measured along the under-sleeve seam from the armhole seam to the knit-cuff seam.

Size	XS	S	R	L	XL	XXL
32	14.5	15.75	17	18.25	19.5	20.75

34	14.5	15.75	17	18.25	19.5	20.75
36	14.5	15.75	17	18.25	19.5	20.75
38	14.5	15.75	17	18.25	19.5	20.75
40	14.5	15.75	17	18.25	19.5	20.75
42	14.5	15.75	17	18.25	19.5	20.75
44	14.5	15.75	17	18.25	19.5	20.75
46	14.5	15.75	17	18.25	19.5	20.75
48	14.5	15.75	17	18.25	19.5	20.75
50	14.5	15.75	17	18.25	19.5	20.75
52	14.5	15.75	17	18.25	19.5	20.75
54	14.5	15.75	17	18.25	19.5	20.75
56	14.5	15.75	17	18.25	19.5	20.75
	+/- 1/2"	*+/- 1/2"*	*+/- 1/2"*	*+/- 1/2"*	*+/- 1/2"*	*+/- 1/2"*

3. Quality Assurance Provisions.

3.1 Certification. The contractor shall certify and maintain substantiating evidence that the product offered meet the salient characteristics of this commercial item description and that the product conforms to the producer's patterns, specifications, standards and quality assurance practices. The government reserves the right to require proof of conformance prior to first delivery by requesting a sample of the finished parka.

3.1 Workmanship. The finished Parka, basic material and components shall conform to the quality and grade established by the purchase description. The Parka shall be free of all defects which would affect its serviceability, appearance and uniformity.

3.2 Evaluation. The Government reserves the right to perform inspections when deemed necessary to assure supplies and services conform to prescribed requirements.

Examination	Defect

Material and workmanship	Component part omitted, not cut as specified, distorted, full, tight or twisted; any part of parka caught in any unrelated row of stitching. Hole, cut, tear, smash, burn, drill hole, run, thin place, dye streak, color not as specified, mis-weave, knot or slubs. Any finished measurement not as specified. Seam: puckered, distorted, pleated, wavy, twisted, irregular or open, loose or tight stitch tension, broken of missing thread or stitch, needle chew, visible mend, edge or raised stitching sewn too close to edge, resulting in damage to cloth seam allowance not as specified, raw edge. Length of fronts at closure uneven at neck or bottom edge by ¼ inch or more. Permanent fold, pleat, or crease Front pockets: not uniform in size or shape, out of horizontal alignment by more than ¼ inch. Zippers do not mesh properly, zipper binds, catches, sticks or disengages from fastener, fastener not the type, style, or size specified, zipper tape not completely caught in stitching, tape set on too loose or too tight, causing bulge, twist or fullness on outside when fastener is closed.
Shade	Shade variation within a part or between parts, shades of cuffs and waistband not as specified.
Cleanness	Spot, stain, thread ends not trimmed or removed. Rancid order
Labels	Omitted, incorrect, illegible, misplaced, not attached as specified, or stitched through printing; human readable interpretation (HRI) omitted or illegible; bar code not visible on folded, packaged item.

4. Packaging

4.1 Packaging and Packing. Packaging and packing of the item shall be in accordance with good commercial practice. The finished parkas shall be packaged seven (7) to a box.

4.2 Samples. For access to sample of the end item, address the contracting activity issuing the invitation for bids. Samples, when furnished, are solely for guidance and information to the supplier. Variation form this Purchase Description may appear in the sample, in which case this Purchase Description shall govern.

5. Pictures.