

SPECIFICATIONS
Gatlinburg PD
8650 4 POCKET TROUSER
COLOR:Dk Navy
DATE:Oct 2017

GENERAL:

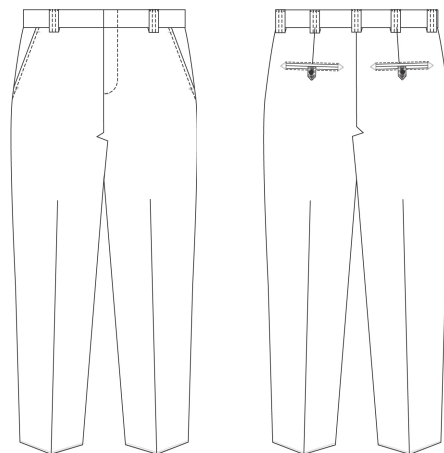
All garment details not specifically described herein; tailoring, styling, construction, materials, and components must match the standard reference sample on file with the agency. Written specifications attempt to describe key requirements of a 3D garment and cannot do so adequately and therefore silence of the specifications does not absolve bidders from matching with precision the standard reference sample.

Pre-bid samples will be required at the time of the bid opening. Samples may be subjected to laboratory testing at the discretion of the contracting officer. Bidders are responsible for all testing costs of their sample garments.

Bidders must enclose evidence (dated manufacturers catalogs or similar) that this item is currently a commercial in-stock style. The successful bidder will provide a full size run of try-on garments within 10 days for agency approval.

Garments must be manufactured to ISO 9001 quality assurance standard. A copy of the certificate registration will be required with the bid.

Specification based on Size 34, Regular length.



FABRIC:

Content – 100% Polyester, 2X1 twill with wicking nano finish. Machine washable and dry cleanable polyester provides user comfort, uniform appearance, durability, and easy care.
Weight – 6.65 oz. per square yard

Physical Properties:

- Warp Yarn – 2/150
- Filling Yarn – 2/150
- Picks/inch – 59
- Ends/inch – 69
- Warp Stretch – 7-11%
- Filling Stretch – 5-9%

INTERNAL CONSTRUCTION FABRIC:

Pockets, waistband and fly lining shall be:
Blend: 65% Dacron Polyester, 35% cotton
Weave: Twill
Weight: 5.2 oz/yd.
Color: Dark Grey
Finish: Pre-cure permanent press

GENERAL DESIGN:

Class A uniform pants in durable & rugged blended fabrics with soil release finish and stretch for increased range of motion. Features include stretch waistband with shirt gripper, extra strength seat seams, self-healing zipper, and silicone creasing for professional appearance.

WAISTBAND:

The inside waistband is assembled from stretch webbing 2-1/2" wide and 1/4" extension, and is reinforced internally with a 1" wide stretch knit polyester stiffener to prevent rolling. The outside waistband is a full 2" wide. The inner circumference of the waistband is permanently (2) continuous 1/8" beads of silicone. The beads are spaced 1/4" apart and located respectively 1/2" and 3/4" down from the top of the waistband to enhance neat appearance by preventing shirt pullout at the waist. Grown on waistlines are not acceptable in lieu of trouser waistband as they add no strength or shape to the garment. Waistbands, which do not allow extra fabric, cannot be "let out" by alteration, also are unacceptable.

BELT LOOPS:

There are seven (7) belt loops on all size trousers up to and including waist 42" and 9 loops on waist sizes 44" and over. Each loop shall be fully 2-1/4" long and 5/8" wide, double needle stitched and interlined with fusible. They shall be set into the waistband at the bottom and tacked at the top, except the rear center loop which shall be tacked top and bottom. They shall be vertical and the edges even with the top of the waistband.

DARTS:

There are two darts to shape the trouser. They shall be placed at the left and right back extending down from the waistband to the center of each hip pocket.

WAIST CLOSURE:

Primary waist closure is a double hook and eye construction mounted on the waistband using rustproof nickel plated steel hardware as follows: Size 85 Eye and Eye internal reinforcement plate. Size 8 hook and hook internal reinforcement plate. Metal snaps which may become

burred or crushed and cannot be replaced are unacceptable, as is single hook and eye construction.

In addition to Hook and Eye plates, the construction includes the additional internal reinforcement of 7/8" tape mounted between the plates and the body fabric to insure construction integrity for extended wear life.

Waist closure appearance is further guaranteed by mounting a #22 ligne black four-hole button/buttonhole closure 1" below the waistband on the left and right fly construction.

SIDE FASTENER:

Slide fastener (fly zipper) consists of locking type Delrin coil (self-healing) hardware mounted on colorfast black blend of nylon and cotton, 7/16" tape, size #5.

FLY CONSTRUCTION:

The right inside fly is reinforced with internal construction fabric and 1/8" gauge top stitched along the entire exposed edge to insure shape retention for extended wear life. The left, outside fly is fully lined internally for shape retention. Right and left fly are joined together at the base of the fly. The joined fly form a reinforcing tailpiece construction fully extending along the crotch seam to its intersection with leg inseams.

CROTCH AND SEAT ASSEMBLY:

The crotch is formed below the fly at the intersection of the four body panels of the trousers. Left front, right front, left rear and right rear. The trouser is assembled to form this crotch by first sewing the left front to the left rear thus making the left side of the trouser, and the right front to the right rear to form the right side. The left side of the trouser thus formed is then joined together to the right side by means of the seat seam. The trouser is not assembled by the alternate whole front to whole back method due to the unreliability of that method during extended wear life.

SEAT CONSTRUCTION:

To insure absolute seat seam integrity, the seat seam, which joins the left and right sides of the trousers, is double sewn by means of two needles each, sewing stitch type 401, double locked stitch. The two needles sew in tandem to form closely adjacent alternating stitches totaling not less than 16 per inch. Seams, which expose thread to external abrasion, are unacceptable.

Extra fabric is allowed such that seat girth and waistband diameter may be expanded or decreased by the wearer during the trousers extended wear life. Flat felled seams do not allow for alteration and are unacceptable.

CROTCH REINFORCEMENT:

The crotch intersection, which is the core of the trouser, shall be reinforced with 2 layer quarter linings to absorb extreme stress over an extended wear life by the internal mounting of a reinforcement gusset formed by an extension of the tail of the fly.

LEG CONSTRUCTION:

The legs are fully cut for ease of movement and assembled using stitch 515, four-thread safety stitch and also lock stitching creating a split seam construction allowing tapering of the inseam.

There shall also be left and right let outs of approximately 1" for 7" at the inner thigh for alteration in which the waist fits correctly but the thigh is too tight for the wearer. Front and back legs shall have resin creases starting from bottom of front pocket to bottom hem.

POCKETS:

There are four (4) pockets assembled from internal construction fabric as follows:

- I. Front: Left and right 6-1/2" quarter top style opening with 11-1/4" depth. Opening to be bar-tack reinforced at top inside waistband and at bottom across side seam. Construction includes a second reinforcing layer or "Heel" at the bottom of each pocket not less than 2" deep. Pockets, including reinforcement "Heels" are assembled using an overedge stitch, then turned and re-stitched by stitch 301 for absolute reliability for the life of the trouser.
- II. Rear: Left and right besom type hip pockets with bottom welt construction openings 5-3/4" wide and 6" deep. Openings triangle bar-tack reinforced at both ends. Both pocket openings include a tab and #22 Ligne black four hole buttonhole to close the pocket.

FINISHING:

Trousers are fully shaped on high temperature, high-pressure presses to eliminate wrinkles and form creases. Trousers meet the standard of the American Association of Textile Chemists and Colorists as follows:

- I. AATCC Test Method 124-1975 "Appearance of Durable Press Fabric After Repeated Home Launderings".
- II. AATCC Test Method 88B-1975 "Appearance of Seams in Wash and Wear Items After Home Launderings".
- III. AATCC Test method 88C-1975 "Appearance of Crease in Wash and Wear Items After Home Launderings".

THREAD:

All thread shall be polyester wrapped on monofilament polyester. Color to match.

STITCHING:

All stitching conforms to Federal Standard 751 specifications (FED-STD-751). All stitch types are sewn at stitch per inch (S.P.I.) rates individually set by operation at no less than 10 S.P.I. and not more than 12 S.P.I. to insure extended sewn wear life. Stitch type 401 Tandem is used at a combined S.P.I. of 16. All thread tension is evenly maintained to eliminate right or loose stitching. All seam allowances are to be maintained so that there are no raw edges, run offs, twist, pleats, puckers or open seams.

WORKMANSHIP:

All trousers are made in an ISO 9000 certified plant and are inspected during manufacturing, at final trimming and packing to insure consistent quality and adherence to this specification.

WARRANTY:

All trousers shall be warranted against defects in materials and workmanship for one year.

LABELING:

All trousers will bear all labels mandated by the Federal Trade Commission at the date of manufacture. All products must be cut and sewn in Mexico using US made components.

SIZING:

Trousers are fully graded such that all vital dimensions change according to waist size. The grade applies not only to seat, front rise, back rise, and thigh measurements but also to the knee and bottom measurements. Additionally, the trousers shall be manufactured and stocked in three (3) separate rises, regular, long and short rise, each with their own grade designed to fit regular, long and short torsos.

STANDARD SIZE RANGE:

Men's: Regular Length: even waist sizes 28 - 54; odd sizes 31 - 37

Women's: Regular Length: even dress sizes 6 – 24

MEASUREMENTS:

Men's: Regular Length: Waist Size 34:

- a. 1/2 Waist: 17.5 (plus 0.25 inch)
- b. Seat: 22.375 (plus 0.25 inch)
- c. 1/2 Knee: 10.625 (plus 0.25 inch)
- d. 1/2 Bottom Leg: 9 (plus 0.25 inch)
- e. Inseam: 37 (plus 0.50 inch)
- f. Front Rise: 10 (plus 0.25 inch)
- g. Back Rise: 15.5 (plus 0.25 inch)

Women's: Regular Length: Dress Size 12

- a. 1/2 Waist (Relaxed): 17.5 (plus 0.25 inches)
- b. 1/2 Waist (Stretched): 18.5 (plus 0.25 inches)
- c. Seat: 22.25 (plus or minus 0.25 inches)
- d. 1/2 Knee: 10.312 (plus or minus 0.25 inches)
- e. 1/2 Bottom Leg: 8.875 (plus or minus 0.25 inches)
- f. Inseam: 35.75 (plus or minus 0.50 inches)
- g. Front Rise: 9.125 (plus or minus 0.25 inches)
- h. Back Rise: 13.5 (plus or minus 0.25 inches)