ATTACHMENT II - INSPECTION UNIFORM SPECIFICATIONS

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION
#1992 -DCM-2, DCF-2

IMMIGRATION INSPECTOR'S DRESS COAT

FABRIC: **FABRIC-2 as stated.**

STYLE: Four button, single breasted, straight front, form fitting blouse with notch lapels and epaulets. Fully lined. Ladies = button right over left.

BUTTONS: There shall be sewn to the front of the blouse 4-36 ligne gilt regulation USINS buttons 4 inches apart and secured with black colored stay buttons. The pocket flaps and epaulets shall be secured with 24 ligne gilt regulation USINS buttons. Each sleeve shall have 2-24 ligne gilt regulation USINS buttons. All buttons are to be properly aligned as fastened to prevent button rotation.

COLLAR: The collar shall not be over 1-7/8 inches wide in the back when finished. The under collar is to be made of pre-padded under collar cloth, black in color.

SLEEVE STRIPE: There shall be a 1/2 inch black cloth stripe sewn at the bottom of the seam to be located 3" above the end of the sleeve. The stripe is to completely encircle the sleeve. The stripe shall be of the same material as the garment, but black in color.

EDGES AND SEAMS: Edges are to be double stitched 1/4 inch. Seams are to be plain and pressed open.

POCKETS: Four outside front packets are to be false with scalloped flaps and 24 ligne buttons and button holes on center. The upper flaps are to be approximately 5 1/8 inches wide and the lower flaps are to be approximately 7 1/2 inches wide, with both sets of flaps approximately 2-1/2 inches deep. Corners are to be sewn down. There shall be two inside breast pockets, one on each side, reinforced with self cloth, and approximately 6 inches wide and 8 inches deep. Flaps are to be double stitched 1/4 inch.

VENTS: There shall be two side vents, one on each side, approximately 9 inches long, that close to the back with a brass zipper on each vent. The zipper tape shall be black.

BADGE TAB: A separate badge tab made of the same material as the garment, approximately 1 inch wide and 2-1/4 inches long, with 2 coated metal eyelets, dark blue in color and spaced approximately 1-1/4 inches apart, shall be sewn to the outside left breast of the coat. The top eyelet shall be 2-1/2 inches on center from top of the left pocket flaps.

NAMEPLATE EYELETS: Nameplate sewn eyelets shall be 1-5/8 inches apart on center 5/8 inches above right pocket flaps.

BUTTON HOLES: All button holes, excepting shoulder strap button holes, shall be made to a full 1/2 inch from the edges of the seam and pocket flaps. The ends of the button holes shall be bartacked. All button holes to be cut after machine made button holes. All thread used in making button holes shall be black button hole thread, tailor's button twist, colorfast and guaranteed against fading.

SWEAT SHIELDS: A sweat shield of the same cloth as used in the body of the coat, piped with Rayon, is to be securely set under each arm over the lining.

(EPAULET) SHOULDER STRAP: To be sewn in the sleeve seam directly on top of the shoulder. The strap shall come under the collar and fasten with a 24 ligne regulation button at the edge of the collar. Cross stitch and double stitch edges 1/4 inch. The point of the epaulet shall be stitched under the collar and the button hole shall be properly finished.

OUTLETS: All body seams shall have outlets of net less than 3/4 inch. Turn up at sleeve cuffs to be no less than 2-1/2 inches(male), 2 inches(female).

EMBLEM: United States Immigration Inspector shoulder emblem sewn on the left sleeve approximately 1 inch down from the shoulder seam, and centered on the upper sleeve of the garment.

DIMENSIONS: Coat lengths=
Back from collar seam to bottom of coat. Male= 30 1/2 inches; Female= 27 inches.
Front from shoulder seam at collar to bottom of coat. Male= 31 1/2 inches; Female= 28 inches.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MT-2, MT-3, MT-1, MT-6

IMMIGRATION INSPECTOR'S MEN'S TROUSERS

FABRIC:

MT-2: FABRIC - 2, as stated.
MT-3: FABRIC - 3, as stated.
MT-1: FABRIC - 1, as stated.
MT-6: FABRIC - 6, as stated.

BASIC DESIGN: Trousers shall be manufactured from up-to-date patterns and designed so that there will be no "peg" at the hip or baggy seat. The front will be plain (no pleats) with two (2) vertical top pockets, and two (2) hip pockets. Left hip pocket shall have a tab to button. Front pockets to have a minimum opening of 6-1/2 and 6 inches deep from the bottom of the opening. They shall be stitched, turned and top stitched. The hip pockets shall have a opening of approximately 6 inches from bartack to bartack and be 6 inches deep. Hip pockets will be of the double welt method and finished in such a manner that there is no top stitching. The welts are to be interlined with pellon. All pockets must have a firm bartack for reenforcing strength. Front pockets shall open behind the stripe. The button color shall closely match the material color.

POCKETING: The pocketing shall be polyester/rayon or polyester/cotton blend. The color of the pocketing shall be black and contain a durable press finish. Minimum weight shall be 2.6 oz. per square yard.

WAISTBAND: 2 inches outside waistband of the same material as the trousers. Waistband curtain is to be of the same fabric and color as the pocketing and shall close with a crush proof hook and eye. The eye is to be stitched for added strength. The waistband curtain must be attached to the trousers with a zig-zag stitch. The waistband must contain Banrol to prevent roll over. The closed waistband outlet method is to be used and trousers must have three strand Snug-tex to prevent shirt from "hiking up."

FLY LINING: The right fly shall be same fabric and color as the waistband and pocketing. The right fly lining must be sewn to the left fly below the zipper with strong closure and clean appearance. There shall be a French fly closure on the inside of the right fly and the fabric for the French fly must be the same as the outer material of the slacks.

BELT LOOPS: There shall be 7 belt loops, 6 of which are to be Keystone style measuring 1-3/4 inches at the top and 1-1/4 inches at the bottom. The center back loop shall be straight and be 3/4 inch wide. All loops (except for the back center loop) must be sewn into the bottom of the waistband and the top of all loops shall be caught into the waistband curtain seam. The waistband shall measure approximately 2 inches wide when finished -- wide enough to comfortably accommodate a belt 1-5/8 inches wide. For waist sizes less than 30 inches there shall be 5 belt loops, 4 of which are to be Keystone style.

STRIPE: There shall be a 1 inch black cloth stripe sewn in the seam and sewn from the bottom of the waistband over the pocket to the bottom of the trouser leg. The stripe shall be of the same material as the garment, but black in color.

MISCELLANEOUS: Slacks must have a fly front with brass memory lock zipper, the type of which has permanent press finish, and there shall be a bartack at the bottom of the fly going through the zipper tape. The slacks must be seamed with matching thread and the seat seam must be stitched with a tandem needle machine (2 threads). All exposed inside edges must be serged.

PRESSING & FINISHING: Slacks must be professionally pressed on hothead presses and properly shaped. The outseam and inseam must be pressed open.

NOTE: Trousers made from Fabric #6 must have front and back "Lintrak" or equal crease treatment.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - LS-2, LS-3, LS-1, LS-6

IMMIGRATION INSPECTOR'S WOMEN'S TROUSERS

FABRIC:

LS-2: FABRIC - 2, as stated.
LS-3: FABRIC - 3, as stated.
LS-1: FABRIC - 1, as stated.
LS-6: FABRIC - 6, as stated.

BASIC DESIGN: Slacks shall be manufactured from up-to-date patterns and shall be designed so that there will be on "peg" or baggy seat. The front shall be plain with two vertical top pockets, and two hip pockets. The left hip pocket shall have a tab to button. The front pocket shall have a minimum opening of 5-1/2 inches and shall be 5-1/4 inches deep from the bottom of the opening. They shall be stitched, turned and top stitched. The hip pockets shall be 6 inches deep. Hip pockets will be of the double welt method and shall be finished in such a manner that there is no top stitching. The welts shall be interlined with pellon. All pockets must have a firm, straight bartack for reinforcing strength. Bottoms to be straight leg. Front pockets shall open behind the stripe.

POCKETING: The pocket shall be polyester/rayon or polyester/cotton blend. The color of the pocketing shall be black and contain a durable press finish. Minimum weight shall be 2.6 oz. per square yard.

WAISTBAND: Two (2) inch outside waistband of the same material as the slacks. Inside waistband curtain shall be closed at the waist outlet - that is the waistband lining shall be turned, right sides of cloth together, and stitched so as to make a closing seam at the waistband outlet. Waistband curtain to be of the same fabric as the pocketing and shall close with a hook and eye. The waistband curtain must be attached to the slacks with a zig-zag stitch. The waistband must have 3-strand rubberized stitch (Syntex) and contain Ban-rol to prevent roll over.

FLY LINING: The right fly shall be same fabric and color as the waistband and pocketing. The right fly lining must be sewn to the left fly below the zipper with strong closure and clean appearance. There shall be a French fly closure on the inside of the right fly and the fabric for the French fly must be the same as the outer material of the slacks.

BELT LOOPS: There shall be 7 belt loops, 6 of which are to be Keystone style measuring 1-3/4 inches at the top and 1-1/4 inches at the bottom. The center back loop shall be straight and be 3/4 inch wide. All loops (except for the back center loop) must be sewn into the bottom of the waistband and the top of all loops shall be caught into the waistband curtain seam. The waistband shall measure approximately 2 inches wide when finished -- wide enough to comfortably accommodate a belt 1-5/8 inches wide. For sizes 12 and down there shall be 5 belt loops, 4 of which are to be Keystone style.

STRIPE: There shall be a 1 inch black cloth stripe sewn on the seam and sewn from the bottom of the waistband to the bottom of the trouser leg. The stripe shall be of the same material as the garment, but black in color.

MISCELLANEOUS: Slacks must have a fly front with brass memory lock zipper, the type of which has permanent press finish, and there shall be a bartack at the bottom of the fly going through the zipper tape. The slacks must be seamed with matching thread and the seat seam must be stitched with a tandem needle machine (2 threads). All exposed inside edges must be serged.

PRESSING & FINISHING: Slacks must be professionally pressed on hothead presses and properly shaped. The outseam and inseam must be pressed open.

NOTE: Trousers made from Fabric #6 must have front and back "Lintrak" or equal crease treatment.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - WS-2, WS-3, WS-6

IMMIGRATION INSPECTOR'S WOMAN'S SKIRT

FABRIC:

WS-2: FABRIC - 2, as stated.
WS-3: FABRIC - 3, as stated.
WS-6: FABRIC - 6, as stated.

DESIGN:

The skirt shall be made using a three gore pattern; the front shall have four pleats, each back gore shall have one dart. The skirt shall have Keystone button loops, plain waistband, two straight side pockets, rear tab button closure with zipper and 1 inch seam in stripe.

POCKETS:

There shall be two straight side pockets with an approximate opening of 5-3/4 inches to 5 inches deep from the bottom of the opening. The top of the pocket opening shall be approximately 1 inch down from the bottom of the waistband. The pocket shall have inside and outside facings made from self goods. The outside of the pocket opening shall be inserted in the waistband for additional strength. The pockets shall be stitched turned and topstitched. There shall be bartacks at the top and bottom of the pocket opening. The pocket fabric shall be polyester/rayon or polyester/cotton and black in color. Pocket opening shall be behind the side stripe. Pockets on Fabric 3 and 3a shall be washable.

WAISTBAND AND BELT LOOPS:

The waistband shall be 2 inches wide and be of self goods. The band shall have a top stitched tab over pointed closure. The band shall be top stitched at the top and bottom. The top of the belt loops shall be caught in the top stitchline. The belt loops shall be keystone and stitched on the face side with a 2 needle machine. There shall be four belt loops on a size 12 and down. On sizes 14 and over there shall be 6 belt loops. The loops shall be dropped, tacked, folded over and pressed to be approximately 3/16 inch below the waistband. The bottom of the loops shall be inserted into the bottom of the waistband. The belt loops shall accommodate a 1-5/8 inch belt.

SKIRT LINING: The skirt shall be fully lined. The lining shall be the same material as the pockets. To assure a neat appearance, the lining shall also have darts. The back seam shall be pressed open. The skirt shall be lined with pocketing material.

PLEATS AND VENTS: There shall be four front pleats. The pleats shall be sewn into the waistband and pressed down approximately 4 inches in length. The pleat tuck at the waistband shall be 1/4 to 1/2 inch on the fold. The skirt shall have a rear vent. The vent shall start 16" from bottom of waistband on a size 12.

ZIPPER: The skirt shall be closed with a black nylon zipper with a memory lock slider. There shall be a bottom stop at the base of the zipper chain.

STRIPE: Each skirt shall have an in the seam stripe made from the same weight and blend as the skirt it shall be sewn to. The stripe shall be 1 inch side and go from the bottom of the skirt to the waistband. The stripe shall be black in color.

OUTLETS: There shall be a minimum of 2 inches of material at the hem turn up. All body seams shall have outlets of not less than 3/4 inch. Unfinished back length: 28-1/2 " from bottom of waistband.

UNITED STATED IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MJ-6

IMMIGRATION INSPECTOR'S MATERNITY JUMPER

FABRIC: 100% Polyester, Fabric #6, Navy .

STYLE: Basic princess-style maternity jumper, sleeveless with V-neck opening and 14" back zipper opening. Gathered front yoke with two side inseam pockets. All raw edges serged.

SIZES: S - L

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - LMAT-5

DESCRIPTION:	Maternity Long Sleeve Shirt
FABRIC:	**Fabric #5**
STYLE:	Full cut maternity shirt with two pockets and a center placket front.
REFERENCE SIZE:	All measurements are based on a size M.
COLLAR:	Rolled collar with stand. The collar points shall be 2-1/4 inches long. The collar shall be 2-inches wide at center back. The collar shall be interlined with polyester. The collar and under collar shall be stitched, turned, and topstitched 1/8 inch gage. The collar stand shall be 1-1/4 inches high at center back and shall be topstitched 1/16 gage at top and bottom.
FRONTS:	The center placket shall be 9 inches long and 1-1/2 inches wide. The top placket shall be on the right side and three vertical buttonholes shall be centered on the placket and equally placed from top to bottom. A fourth horizontal buttonhole shall be centered in the collar stand. A top placket shall be topstitched 1/16 inch on each side. The bottom placket shall be 9 inches long and 1-1/4 inches wide and shall be topstitched 1/16 inch gage. Buttons shall be sewn to the bottom placket in locations corresponding to the buttonholes. A 1-1/2 inch wide pleat shall start under the bottom of the placket and continue to the bottom edge of the front. The half chest width shall be 22 inches and the hip half width shall be 26-1/2 inches when measured at the top of side vents with pleat expanded. The center front length shall be 27 inches. There shall be 7-inch side vents where front and back panels are joined. The top of the vents shall be bartacked with a 3/8 inch bartack.

POCKETS: The two breast pockets shall be die cut and pressed to ensure uniformity. The pockets shall be 4-7/8 inches wide, 4-7/8 inches deep and shall have mitered corners 1-1/8 inches long. The pockets shall have 1-1/4 inches wide center pleats stitched to prevent spreading. The left pocket shall have a 1-1/4 inches pencil division. Pocket facing shall be top stitched 1/2 inch across the top corners for reinforcement.

FLAPS: Scalloped flaps shall be 5-1/4 inches wide, 2 inches deep at sides and 2-1/2 inches deep at the center. A vertical buttonhole shall be located 1/4 inch from bottom edge of flap. Button shall be located on pocket to correspond to buttonhole location. Flap shall have double stitching 1/8 inch gage entire width at top with a 1-1/4 inch pencil division on left flap, and shall be topstitched on bottom and side 1/8 inch gage.

SHOULDER STRAPS: Pointed shoulder straps shall be edge stitched 1/4 gage and shall be set on top of the yoke with bottom edge aligned with the shoulder seam. Straps shall measure 2 inches at sleeve and taper to 1-3/8 inches at the point with point edges 7/8 inch wide. Straps shall be cross stitched approximately 2 inches from sleeve seam.

BADGE REINFORCEMENT: A two-ply sling 1 inch wide shall be sewn under the front, centered over left pocket, and shall be stitched to shoulder seam and flap setting stitch. There shall be 2 buttonhole eyelets approximately 7/8 inch from top of pocket flap spaced 7/8 inch apart and centered on sling.

SLEEVES: Sleeves shall be one piece with placket vent. The top and bottom plackets shall be 1/2 inch wide, and shall have 2-3/4 inch opening. Plackets shall be topstitched 1/16 inch gage.

CUFFS:	Sleeve cuffs shall be 1-3/4 inches wide, topstitched 3/16 inch gage on the bottom and double stitched 3/8 gage with the upper row 1/16 inch from the top of cuff. A buttonhole shall be centered on the top of cuff 1/2 inch from the edge. A button on the bottom cuff shall be located to correspond to the button hole 1/2 inch from the opening edge.
BACK:	One piece back with two piece yoke. The yoke shall be 1-3/4 inches at center and 2-5/8 inches at sides. Top and bottom edges shall be topstitched 1/16 inch gage. The center back length shall be 28-1/2 inches long from the collar seam to the bottom edge. There shall be a 1-1/2 inches center pleat at the top center back starting under the yoke. Each side of the pleat shall be folded under 3/4 inch. The pleat shall be pressed to a point 7 inches down from the top.
PATCH:	The patch is to be sewn securely in the center of the left sleeve with the top edge 1-inch below the shoulder seam. The patch is to be sewn with inconspicuous stitching using thread closely matching the emblem background color.
BUTTONS:	All buttons shall be 18 ligne pearlescent polyester with 4 holes.
THREAD:	All thread shall be spun polyester.
STITCHING:	Sleeving and closing operations shall use 1/4 inch gage safety stitch. All other operations shall use stitch type 301.
CUTTING:	Collars, bands, pockets, and flaps shall be die cut to ensure uniformity.
PACKING:	Finished shirts shall be pressed, folded, pinned, with straight pins or jet clips and packaged in poly bags.
SIZES:	XS (4), S (6-8), M (10-12), L (14-16), and XL (18-10).
LABELS:	Identification, size and care labels shall be sewn on the inside centered under the collar seam.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - SMAT-5

DESCRIPTION: Maternity Short Sleeve Shirt

FABRIC: **Fabric #5**

NOTE: The short sleeve shirt model has the same specifications as the long sleeve model except the sleeves shall be 8-1/4" long with a 3/4" hem folded to the inside with the raw edge folded down and topstitched 1/16" gage. The bottom edge of the closing seam shall be bartacked with a 3/8" bartack, 1/8" from the bottom edge of the sleeve.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MS-6

DESCRIPTION:	Maternity Slacks
FABRIC:	Fabric #6
STYLE:	Basic one-piece front with two front quarter top style pockets and adjustable buttoned waistband which will expand for fit and comfort. The 1-1/4" fully elastic waistband is finished with self fabric. All raw edges serged.
FABRICS:	100% polyester, Tropical, Color used by agency.
SIZES:	S - L

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MSSS-4, FSSS-4

DESCRIPTION: **Short Sleeve Shirt**

FABRIC: Fabric #4, as stated.

STYLE: The style shall be known as a convertible collar, short sleeve shirt, with full length tail. The shirt is to have two (2) pleated outside breast pockets and scalloped flaps having one (1) button each. It also will have a full badge sling and shoulder straps. The back will have a Western yoke to match the style of the scalloped pocket flaps, with a high count Dacron Polyester/Cotton Poplin collar band and yoke trim.

COLLAR: The convertible style collar shall be one piece and is to measure 3-3/8 inches long at the points. The collar shall be made with permanent sewn-in mylar collar stays that are fused to 100% cotton collar lining. The collar height at the rear is 1-1/2 inches, top stitched 1/4 inches off the edge.

FRONT: The left front (right front for female shirt) shall have a center facing that is 1-1/2 inches wide that will accommodate zipper if so designated, extending from the collar joining seam to the bottom of the shirt. The center facing shall be made of the same fabric as the shirt with two (2) rows of stitching 7/8" apart. The center facing shall be fully lined to give body by sewing in a 100% cotton innerlining cut straight. The left front (right front for female shirt) shall have seven (7) for male, six (6) for female, buttonholes spaced 3-3/4" apart and set 3/4" from the edge. The second buttonhole is to be positioned 2-1/2" from the top button; balance of the buttons are to be spaced 3-3/4" apart. The buttons are to be strongly attached through two thicknesses of material forming the right front (left front for female shirt), and shall correspond to each buttonhole. Zipper fronts to be made available as an extra cost option.

SHOULDER STRAPS: Asymmetrical shape top stitched 1/4" off the edge to be set on the yoke with a leading top stitch conforming with the front joining seam. The straps are to measure 2 inches at sleeve, tapering to 1-3/8" and are to measure 2 inches at sleeve, tapering to 1-3/8" and set not more than 1-1/2 inches from the folded collar. Straps are not to be X-stitched.

BADGE REINFORCEMENT: Two-ply sling 1" wide centered over the left pocket, stitched to the shoulder seam and flap setting stitch. It is to have two (2) embroidered buttonhole eyelets approximately 1-1/4" from top of the pocket flap spaced 1-1/4" apart and centered on the sling.

POCKETS: Two (2) breast pockets with 1-1/2" stitched pleats for males, and 1-1/4" stitched pleats for females. The pockets are to measure 5-5/8" wide, 6" deep. The left breast pocket is to have a 1-1/2" pencil slot. Each pocket is to have a Velcro tape 3/4" long by 1/2" wide, positioned on both edges of the pocket to correspond with the outer scalloped flap points. The tape is to be the same color as the shirting material. They are to be sewn on all sides to ensure firm attachment. Each pocket shall have a button to accommodate the flap buttonhole.

FLAPS: To have two (2) scalloped flaps, top-stitched around the edges, to finish 5-7/8" wide, 2-3/4" at the center, and 2-1/4" in width at the sides for males, and 5-1/4" by 2-1/4" by 2" respectively for females. The flaps are to be secured to the front of the shirt approximately 1/4" above the pocket with two (2) rows of stitching 3/16" apart. The left flap is to have an invisible pencil opening of 1-1/4" to correspond precisely with the pencil slot of the pocket. The invisible pencil opening provides a uniform appearance to both pocket flaps. This feature must be incorporated in the construction of the shirt. Both flaps are to be interlined with 100% cotton. The flaps shall button down to the pocket material. The side

FLAPS - CONT.: points of the flaps are to be secured to the pockets by means of Velcro fasteners sewn onto the flaps and pocket; the hook portion being stitched to the pocket and the pile portion sewn to the underside of the flap. The pile piece sewn to the flap must be attached during the manufacturing process before the flap is assembled to prevent the stitching from showing on the front of the flap. The Velcro tape is to measure 3/4" long by 1/2" wide, is to be positioned on the outer points of both pocket flaps, and is to be sewn down on all sides, and is to be the same color as the shirting material. Bartacking is not acceptable.

SHORT SLEEVES: The sleeves are to be straight and whole, to have a 3/4" hem and to finish approximately 9" long from the shoulder seam.

BUTTONS: Will be first grade white 19 ligne pearlescent plastic to match the color of the shirt fabric.

THREAD: All sewing threads are to be color fast Polyester core cotton warp to match the color of the shirt fabric.

MILITARY CREASES: There shall be five (5) stitched in sharp military creases on all shirts. One (1) crease in each front extending from the hem to the shoulder seam. The crease is to run through the pocket and pocket flap. The front pockets and flaps are to be centered over the creases. Three (3) vertical creases in back with the middle crease on center of the back, side creases spaced equally from the center crease.

LINING: All collars, flaps, and top center bands are to be interlined with 100% cotton stabilized interlining with 550 weight.

YOKE: There shall be a center pointed western style yoke on the back matching the scalloped design of the pocket flaps. The depth of the yoke is to be 4-3/4" at the center point and 3-1/8" at the sides for males, and 4-1/2" at the center by 3-5/8" at the sides for females. The three stitched in military creases on the back of the shirt are to go under the yoke. The center crease is to go under the center point of the yoke and the other two creases are to be equidistant between the center point and side points of the yoke.

EMBLEM ATTACHMENT: The United States Immigration (pattern 307249) Inspector emblem will be attached 1/2" below the left shoulder seam, centered with Navy Blue color-fast Poly core thread matching the emblem. It is to be attached during the assembly of the shirt.

NAMEPLATE REINFORCEMENT: Two poly reinforcement 1/2" x 3" of self material sewn to the inside of the shirt and centered over the right pocket parallel to and 3/8" above the top of the right pocket flap. It shall have two (2) embroidered buttonholes. The eyelets, spaced 1-3/4" apart with each eyelet each 5/8" above the top of the flap, are to be attached in a horizontal direction.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

Uniform Program Specification

#1992 - MLSS-4, FLSS-4

DESCRIPTION: **Long Sleeve Shirt**

FABRIC: FABRIC #4 as stated.

STYLE: The style shall be known as a dress collar, long sleeve shirt, with full length tail. The shirt is to have two (2) pleated outside breast pockets and scalloped flaps having one (1) button each. It also will have a Western yoke to match the style of the scalloped pocket flaps, with a high count Dacron Polyester/Cotton Poplin collar band and yoke trim.

COLLAR & STAND: The collar points are to measure 3-3/8" (male) and 3" (female) long with permanent sewn-in Mylar collar stays that are fused to be 100% cotton collar lining. The collar height at the rear is 1-1/2", top stitched 1/4" off the edge. The collar stand measures 1-7/16" at rear and the band is to be die cut and interlined with stabilized 100% cotton. Female shirt to have pile attached under collar to accommodate the hooks of the velcro on the necktabs. Pile to be the same color and shade as the shirt. Pile shall be centered on collar band approximately 2 1/8" from center of neck bottom on left and right side when closed.

FRONT: The left front (right front for female shirt) shall have a center facing that is 1-1/2" wide, that will accommodate a zipper if so designated, extending from the collar joining seam to the bottom of the shirt. The center facing shall be made of the same fabric as the shirt with two (2) rows of stitching 7/8" apart. The center facing shall be fully lined to give body by sewing in a 100% cotton interlining, cut straight. The left front (right front for female shirt) shall have seven buttonholes (male) and six buttonholes (female) spaced 3-3/4" apart (male) and 3-1/2" apart (female). The buttons are to be strongly attached through two thicknesses of material forming the right front (left front for female shirt), and shall correspond to each buttonhole. Zipper fronts to be made available as an extra cost option.

SHOULDER STRAPS: Asymmetrical shape top stitched 1/4" off the edge to be set on the yoke with a leading top stitch conforming with the front joining seam. The straps are to measure 2" at sleeve, tapering to 1-1/2" and set not more than 1-1/2" from the folded collar. Straps are not be X-stitched.

BADGE REINFORCEMENT: Two-ply sling 1" wide centered over the left pocket, stitched to the shoulder seam and flap setting stitch. It is to have two (2) embroidered buttonhole eyelets approximately 1-1/4" from top of the pocket flap spaced 1-1/4" apart and centered on the sling.

POCKETS: Two (2) breast pockets with 1-1/2" (male) 1-1/4" (female) stitched pleats. The pockets are to measure 5-5/8" wide, 6" deep (male) and 5" wide, 5" deep (female). The left breast pocket is to have a 1-1/2" pencil slot. Each pocket is to have Velcro tape 3/4" long by 1/2" wide, positioned on both edges of the pocket to correspond with the outer scalloped flap points. The tape is to be the same color as the shirting material. They are to be sewn on all sides to ensure firm attachment. Each pocket shall have a button to accommodate the flap buttonhole.

FLAPS: To have two (2) scalloped flaps, top-stitched around the edges, to finish 5-7/8" in width, 2-3/4" wide at the center, and 2-1/2" at the sides. The flaps are to be secured to the front of the shirt approximately 1/4" above the pocket with two (2) rows of stitching 3/16" apart. The left flap is to have an invisible pencil opening of 1-1/4" to correspond precisely with the pencil slot of the pocket. The invisible pencil opening provides a uniform appearance to both pocket flaps. This feature must be incorporated in the construction of the shirt. Both flaps are to be interlined with 100% cotton. The flaps shall button down to the pocket material. The side points of the flaps are to be secured to the pockets by means of Velcro fasteners sewn onto the flaps and pockets; the hook portion being stitched to the pocket and the pile portion sewn to the underside of the flap.

FLAPS-CONT: The pile piece sewn to the flap must be attached during the manufacturing process before the flap is assembled to prevent the stitching from showing on the front of the flap. The Velcro tape is to measure 3/4" long by 1/2" wide, is to be positioned on the outer points of both pocket flaps, and is to be sewn down on all sides, and is to be the same color as the shirting material. Bartacking is not acceptable.

SLEEVES & CUFFS: To have long sleeves, cut straight and whole, with 4" sleeve vent (male) and 3-1/2" (female). The sleeve shall have a one-piece band elbow reinforcement and vent facing. Band elbow reinforcement corners must be rounded and shall extend into the sleeve closing seam. Lower facing shall measure approximately 1/2" width. The cuffs are to measure 2-7/8" (male) and 2-1/2" (female) with rounded corners. There shall be two (2) buttons with corresponding buttonholes on each cuff with one (1) button and buttonhole in the sleeve facing. Female not to have button in buttonhole or facing. Female to have two buttons and one buttonhole for adjustment purposes. Both cuffs are to be interlined with 100% stabilized cotton.

BUTTONS: Will be first grade white 19 ligne pearlescent plastic to match the color of the shirt fabric.

STITCHING: Single needle throughout. All top stitched 1/4" off the edge. The sleeve inserting and side close felling will be safety stitched.

THREAD: All sewing threads are to be color fast Polyester core cotton warp to match the color of the shirt fabric.

MILITARY CREASES: There shall be five (5) stitched-in sharp military creases on all shirts. One (1) crease in each front extending from the hem to the shoulder seam. The crease is to run through the pocket and pocket flap. The front pockets and flaps are to be centered over the creases. Three (3) vertical creases in back with the middle crease on center of the back, side creases spaced equally from the center crease.

LINING: All collars, flaps, and top center bands are to be interlined with 100% cotton stabilized interlining with 500 weight.

YOKE: There shall be a center pointed Western style yoke on the back matching the scalloped design of the pocket flaps. The depth of the yoke is to be 4-3/4" (male) and 4-1/2" (female) at the center point and 3-1/8" (male) and 3-5/8" (female) at the sides. The three stitched in military creases on the back of the shirt are to go under the yoke. The center crease is to go under the center point of the yoke and the other two creases are to be equidistant between the center point and side points of the yoke.

EMBLEM ATTACHMENT: The United States Immigration (pattern 307249) Inspector emblem will be attached 1/2" below the the left shoulder seam, centered with Navy Blue color fast Poly core thread matching the emblem. It is to be attached during the assembly of the shirt.

NAMEPLATE REINFORCEMENT: Two-ply reinforcement 1/2" x 3" of self material sewn to the inside of the shirt and centered over the right pocket parallel to and 3/8" above the top of the right pocket flap. It shall have two (2) embroidered buttonhole eyelets, spaced 1-3/4" apart with each eyelet 5/8" above the top of the flap, to be attached in a horizontal direction.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - TIE (M)-2, XLT (M) -2

IMMIGRATION INSPECTOR'S TIE (MALE)

FABRIC: Fabric #2, AS STATED.

DESCRIPTION: Pre-tied four-in-hand knot with french cuff ends. Pre-tied onto large all metal bend-over style clip. Visible clasp to be zinc bichromate with black finish. Width at widest point not to exceed 3 inches. Small end of tie shall incorporate button down feature with three threadless button holes 5/8 inch long and spaced 3/8 inch apart along small end of tie. Tie shall be constructed with a label loop for holding large end of tie when button down features is utilized. Finished length from top of knot to tip of tie is to be available in lengths to accommodate men 5 feet tall to 6 feet 6 inches tall. i.e. Will be furnished in regular long lengths. Long to be approximately 2-1/2" longer than regular.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - NT (F)-2

IMMIGRATION INSPECTOR'S FEMALE NECKTAB

FABRIC:	Fabric 2, as stated.
DESCRIPTION:	Comply with MIL SPEC MIL-N-44106 Type I ("short sleeve" with exception of color and fabric.
COLOR:	Navy

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -JS-3

INS JUMPSUIT SPECIFICATIONS

STYLE: Set-in - short sleeves with French cuffs. Half belt with buckle, self collar with snap fly covering, two way front zipper. Elastic inserts at back waist and sewn in leg creases.

POCKETS: Two chest bellows style, two swing pant and two rear hip pockets, onto button.

FABRIC: Dark Navy 100% Texturized Dacron Polyester knit with Soil Release (Visa) finish.

CHEST SIZE: Short 38 to 44, regular 38 to 54, tall 38 to 52.

Walls #50019NA or equivalent.

EMBLEMS:

1. An INS Inspectors Emblem shall be sewn on the left sleeve 1/2 inch down from the shoulder seam.

2. An INS Inspectors Badge Patch Emblem shall be sewn or heat sealed to the left chest. The bottom of the emblem shall be 1 inch above the top of the pocket.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - CS

INSPECTOR'S COMMANDO SWEATER

YARN: Type: 100% pure new virgin wool (worsted, spun, long fiber) Content: not less than 95% based on dry weight of sweater. Quality: 56/58 microns (diameter). Count: worsted 2 ply/11 1/4 times 2 ends. Colorfastness: Good. Drycleaning: Good. Crocking: Good. Color: Dyed to match Fabric designated Immigration Inspectors.

RE-ENFORCEMENT PATCH FABRIC: Fabric designated to Immigration Inspectors.

TAPE RE-ENFORCEMENT: Type: cotton woven tape, 5/8 inches wide conforming to Type II of DDD-T-86. Color: Approximately same as sweater.

THREAD: Type: cotton. Colorfastness: good.

INTERLINING (EPAULETS): Cloth-Type: 50% polyester, 50% nylon fusible cloth. Weight: 1.7 oz. to 2.2 oz. per square yard. Breaking strength: machine direction, 3 lbs. per inch, across machine 2 lbs. per inch. Maximum shrinkage - warp: less than 1%, fill: less than 1% Color: oxford grey.

GENERAL DESIGN: Shall be of pullover style, wool, 2 x 2 rib throughout, v-neck, with a straight body and set in sleeves. The number of counted ribs from side seam to side seam across the chest and bottom welt shall be equal to the chest size in inches. Extra long body length with knitted welt and turnback cuff design for adjusting sleeve length. Durable cloth patches shall re-enforce shoulders and elbows. The body and sleeve welts shall be knit with a non-ravelling edge. Badge and name tab shall be sewn on the inside so as not to show and epaulets shall be attached with a button.

KNITTING: The garment is to be knitted from 2 x 2 construction throughout, using .54 inches of yarn per stitch, except the bottom welt which is to be .46 inches of yarn per stitch, commencing with a knitted welt. The body 6 inches below the armpit when stretched by hand is to extend without damage to a total width of at least 38 inches(large).

SEAM CONSTRUCTION: All sweater seams shall be stitched using an overlock machine, except for the shoulder and sleeve cuff seams which shall also be over sewn with a seam cover using a wool cover thread for neat appearance and comfort. All seams shall be straight and neat with thread ends trimmed.

TAPE REINFORCEMENT: The shoulders and underarms shall be reinforced with 5/8 inch cotton tape, to prevent underarm seam from coming apart under stress. The tape shall measure approximately 4 inches in length under the arm and the entire length of the shoulder seam, and shall match (approximately) the color of the sweater.

PATCHES: The sweater is to have re-enforcing patches on each shoulder and sleeve. When the sweater is laid flat, the bottom of each shoulder patch shall meet when a straight line is drawn from patch to patch, insuring a uniform appearance. The patches shall match the color of the sweater. The patches, with raw edges turned in, are to be secured by a double needle locked stitch, except for the edge incorporated into the sleeve seam. There shall be no puckering, gathering or distortion, where the patches are sewn to the sweater. No glue may be used to fold patches before stitching. The shoulder patch shall measure approximately 9 inches by 5 inches (size med). The sleeve patch shall be contoured to fit the arm, measuring approximately 10 inches by 4 inches (size large).

BADGE PATCH: There shall be a badge patch on the inside left breast measuring approximately 1" by 3-3/4", attached to the sweater using a lock stitch. The eyelets shall be spaced 1-1/4" apart. Eyelets are to be sewn (not metal).

NAME PLATE PATCH: There shall be a name plate patch on the inside right breast measuring approximately 1 inch by 4 inches, attached to the sweater using a lock stitch. The eyelets shall be spaced 1-5/8 inches apart. Eyelets are to be sewn (not metal).

EPAULETS: The epaulets shall have three points: shall be smooth and flat, and uniform in construction and placement. They shall be made from two plies of re-enforcement fabric and one ply of fusible interlining (for added shape retention). The plies shall be stitched, turned inside out and top stitched. Each epaulet shall be set to the shoulder, turned back on itself. It shall finish 2" wide at the shoulder seam, tapering to 1-7/8" wide at the pointed end. The epaulets shall be attached to the shoulder patch using a button. The epaulets shall be x-stitched.

BUTTONS: Color shall match the basic wool fabric.

EMBLEMS: Specified emblem Immigration Inspector shall be sewn to the left sleeves 1 inch below the shoulder seam. Thread shall be poly core to match the emblem.

FINISHING: The sweater and patches shall be pressed for a second time before shipping, insuring a neat, un-wrinkled appearance when issued. All patches and epaulets shall be stitched with two rows of stitching 1/4 inches apart. All loose threads shall be trimmed properly. The sweater must contain care labels and an official U.S. Inspections uniform item designation label.

MEASUREMENTS: The length of a size large sweater from shoulder seam at the armhole bottom welt shall be approximately 27 inches (+ or - 3/4 inch). The width shall be measured by counting the number of ribs from side to side seam -- the number of ribs equaling the chest size of the sweater in inches. The width of the v-neck opening shall be 5 inches. (+ or - 1/2 inch).

SIZES: Size availability will XS (32-34), S (36-38), M (40-42), L (44-46), XL (52-54), XXXL (56-58) to fit men and women.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - LWS

DESCRIPTION: Lightweight Commando Sweater

REQUIREMENTS FOR THE YARN

Content:	80% Piltrol, 20% Wool Jersey Knit
Quality:	14 oz. per sweater, jersey stitch body, 1X1 rib on cuff and skirt
Count:	2/24- Black
Colorfastness:	Good
Dry Cleaning:	Good
Crocking:	Good
Color:	Dyed to match Fabric designated Immigration Inspectors=BLACK

REQUIREMENTS FOR THE RE-ENFORCEMENT PATCH FABRIC

100% Tactel or Supplex Nylon, Color: Black

REQUIREMENTS FOR THE TAPE RE-ENFORCEMENT

Type:	Cotton woven tape, 5/8 inches wide conforming to Type II of DDD-T-86
Color:	Approximately same as sweater

REQUIREMENTS FOR THE THREAD

Type:	Cotton, conforming to Type IA3, ticket no. 40 and 50 of V-T-276
Colorfastness:	Good

GENERAL DESIGN

Shall be pullover style, 80/20 Piltrol/Wool, Jersey Knit throughout, v-neck, with a straight body and set in sleeves. There shall be knitted welt and turn back cuff design for adjusting sleeve length. Durable cloth patches shall re-enforce shoulders and elbows. The body and the sleeve welts shall be knit with a non-raveling edge. Name tab shall be sewn on the inside so as not to show and epaulets shall be attached with a button.

KNITTING

The garment is to be knitted form jersey construction throughout, using .42 inches of yarn per stitch, except the bottom welt which is to be .75 inches of yarn per stitch, commencing with a knitted welt. The body 6 inches below the armpit when stretched by hand is to extend without damage to a total width of at least 30 inches (large size).

SEAM CONSTRUCTION

All sweater seams shall be stitched using an overlock machine, except for the shoulder and sleeve cuff seams which shall also be over sewn with a seam cover using a wool cover thread for neat appearance and comfort. All seams shall be straight and neat with thread ends trimmed.

TAPE RE-ENFORCEMENT

The shoulder and underarms shall be re-enforced with 5/8 inch cotton tape, to prevent underarm seam from coming apart under stress. The tape shall measure approx. 4 inches in length under the arm and the entire length of the shoulder seam, and shall match (approx) the color of the sweater.

PATCHES

The sweater is to have re-enforcing patches on each shoulder and sleeve. When the sweater is laid flat, the bottom of each shoulder patch shall meet when a straight line is drawn from patch to patch, insuring a uniform appearance. The patches shall match the color of the sweater. The patches with raw edges turned in, are to be secured by a double needle lock stitch, except for the edge incorporated into the sleeve seam. There shall be no gathering or distortion where the patches are sewn to the sweater. No glue may be used to fold patches before stitching. The shoulder patch shall measure approx. 9 inches by 5 inches (size medium). The sleeve patch shall be contoured to fit the arm, measuring approx. 9-1/2 inches by 4-1/2 inches (size large).

BADGE PATCH

The authorized Immigration Inspector Badge Patch shall be affixed, using a heat sealing process, to the sweater over the left breast approximately 4 inches below the center of the left shoulder seam. The affixed Badge Patch is to be manufactured according to specifications for II Badge Patch (#1992-IBP) with an additional manufacturing process using 4 - 5 mils thick sheeting of polyurethane after the embroidery process is completed (pre-coat stage) and then coated again with 4 - 5 mils thick polyurethane (post coat stage). The pre and post coating is to be accomplished with specific heat (temperature) range, and dwell (timing) and pressure (PSI) so that emblem adherence withstands all laundering formulas, i.e., home, commercial, and industrial for 52 home launderings, dry cleanings, commercial, industrial laundering and/or a combination of all, while maintaining the appearance, adherence, shape, and integrity of the coating without seepage of the polyurethane into the uniform item fabric nor visible seepage through the badge itself and without fade, shrnkage, distortion, delamination or show of signs of deterioration.

NAME PLATE PATCH

There shall be a name plate patch on the inside right breast measuring approx. 1" by 4", attached to the sweater using a lock stitch. The eyelets shall be spaced 1-5/8 inches apart. Eyelets are to be sewn (not metal).

EPAULETS

The epaulets shall have three points; shall be smooth and flat, and uniform in construction and placement. They shall be made from two plies of Supplex fabric. The plies shall be stitched, turned inside out and top stitched. Each epaulet shall be set to the shoulder, turned back on itself. It shall finish 2" wide at the shoulder seam, tapering to 1-7/8 inch wide at the pointed end. The epaulets shall be attached to the shoulder patch using a button. Epaulets to be X-stitched but not sewn to shoulder patch.

BUTTONS

Color shall match the basic Supplex fabric.

EMBLEMS

Specified emblem Immigration Inspector Emblem shall be sewn to the left sleeves 1" below the shoulder seam. Thread shall be poly core to match the emblem.

FINISHING

The sweater and patches shall be pressed for a second time before shipping, insuring a neat, unwrinkled appearance when issued. All patches and epaulets shall be stitched with two rows of stitching 1/4" apart. All loose threads shall be trimmed properly. The sweater must contain care labels and an official Inspectors uniform item designation label.

MEASUREMENTS

The length of a size Large sweater from the back of the neck to the bottom welt shall be approx. 26 1/2" (+ or - 3/4"). The width shall be measured from the side seam to side seam -one inch below the armhole and on size large shall be approx. 22" (+ or - 3/4"). The width of the V-neck opening shall be 5" (+ or - 1/2").

SIZES

Size availability will be: (to fit men and women)

XS:	32-34
S:	36-38
M:	40-42
L:	44-46
XL:	48-50
XXL:	52-54
XXXL:	56-58

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - CH

IMMIGRATION INSPECTOR'S CAMPAIGN HAT

MATERIAL: 100% Fur Feit - 3 x Beaver

COLOR: Dark Navy

STYLE: 4 dent style crown (pre shaped) with a 3 inch wide completely flat brim. Coated black metal badge eyelet centered in front approximately 2-58 inch above the brim. Accompanying 31 inch long 3/8 inch wide black leather adjustable head strap with coated black metal buckle.

Regulation USINS black leather brim band, 1" wide, untooled, Colonial gilt buckle on left.

Stratton F-40 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -SCM-2

IMMIGRATION INSPECTORS STANDARD CAP -MALE

STYLE: Shall be deluxe Military Style cap with Stationary Cover.

DIMENSIONS: The dimensions of a Size 7-1/2 cap shall be as follows: Front to rear of crown - 10-3/4 inches; side to side of crown - 9-3/4 inches; Height of cap in front - 4 inches. All other sizes shall be in proportion.

COVERS: The material shall be Fabric #2, as stated. The covers shall have a dry-cleanable bonding of not less than .093 gauge Gold Polyurethane Foam throughout the entire top, sides and front, and a Full Crown lining of Black 100% acetate taffeta. A sweat protector, of .004 gauge clear polyethylene film shall cover the lining. After joining the crown and sides, the crown seam shall be double-stitched with a 3/8 inches bias folded tape. As a final operation, all caps should be blocked on a 5-piece block in live steam and thoroughly dried.

EYELETS: Each cap cover should be provided with a total of 5 metal eyelets; 1 eyelet shall be attached at the front center for proper placement of a 1-post badge; 2 eyelets will be provided on each side for ventilation. All eyelets will be dark navy blue in color.

FRAME BAND: The innerband shall be a 2-inches black plastic uni-cane. This innerband shall then be covered with a high-quality black velvet band.

FRONT SUPPORT: The front support shall consist of two pieces; The stayer and the holder. The stayer, or top part, shall be molded on black linear polyethylene of a shape to approximate the contour of the cap cover. It shall have appropriate openings for the badge post, and shaped with a slide at the bottom to enter the slots of the holder. The holder is formed by cutting dual slots in a piece of black linear.

GROMMENT: A 3/4 inches Foam Rubber Gromment, measured and closed to exact size, shall be inserted within the crown of the cap cover.

VISOR: To be made of 2 pieces; The upper portion to consist of black felt. The upper portion of the supervisors cap is to have gold leaf embroidery. The bottom piece is to be .095 leather with an Embossed Hatters black base. The 2 pieces will be firmly cemented together. Visors will not bubble, crack, or blister. The visors shall be bound on the outer edge with a 3/4 inches black .012 patent binding. The visors shall be Shape #88, set into the Frame at an angle of 45 degrees and finish 2-1/8 inches long. All visors shall be blocked to shape in heated forms.

FRONT STRAP: The front strap shall be Style #GIL-40, adjustable, of Gold Wire Lace. The Strap shall be held at either end with a Regulation U.S. Immigration Service Button in a gold finish.

SWEAT BAND: The Sweatband shall be Genuine Roan Leather, 1-1/4 inches wide and perforated throughout. The Sweatband shall be hand sewn into the cap.

NOTE: All caps shall contain a size label, and workmanship shall be first class in all respects.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -SWCF-2

IMMIGRATION INSPECTORS STANDARD WAVE CAP -FEMALE

STYLE: Shall be Navy wave.

CONSTRUCTION: Cap crown shall be hot roll laminate consisting of three layers. The outside layer shall be serge material, the middle layer buckrum interlining, and the inside layer crown rayon taffeta lining.

The brim of the cap shall be composed of .050 inch thick rubber composition texon stiffener, covered with serge material. Self material binding and band. The sweatband shall be a combination taffeta foam and mesh. All inside seams are to be taped and bound. There shall be a size label permanently affixed to the rear of the cap on the inside band.

FABRIC: Fabric #2, as stated.

The upper portion of the front brim (when requested) shall have Gold heat sealed embroidery.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - SP

IMMIGRATION INSPECTOR'S SNORKEL PARKA

FABRIC:	Antrol Nylon and High Wet Modulus Strength Rayon (Titan Cloth).
COLOR:	Navy.
LINING:	100% Nylon.
INSULATION:	10 ounce hollowfil
LENGTH:	34 inches
POCKETS:	Two hand warmer pockets with double snaps. Two lower flap pockets with snap closure and leather triangle reinforcement. Cigarette/pencil pocket on left upper sleeve.
HOOD:	Coyote-fur trimmed and insulated with winter weight Hollowfil II.
BUTTONS:	4 button front closure over reinforced zipper. Draw-string waist and neck.
	Spiewak Golden Fleece style 9471, N-38 type or equivalent.
EMBLEM:	United States Immigration Inspector shoulder emblem sewn on left sleeve approximately 5 inches down from the hood and side seams, centered on the upper sleeve of the garment.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MSC, FSC

DESCRIPTION: **Storm Coat - Hip Length**

FABRIC: 50% Antron or Tri-lobal nylon, 50% rayon. Urethane treated on the back. Material is to be spark and snag resistant and constructed using a nylon/viscose twill treated for water and stain repellency.

PERMANENT LINER: To be first quality nylon taffeta, 70 denier bright, semi-bright or semi-dull. Continuous filament yards with 34 filaments and twisted to meet requirements. The fibers should have a minimum melting point of 450 degrees F., and weight shall be 108 x 71. The tear strength shall be 3 lbs. minimum in the warp and 3.5 minimum in the filling. It shall be color-fast and perspiration proof.

ZIP-OUT QUILTED LINER: Shall be 70 denier nylon taffeta, or 88 count tricot, quilted to 1/4" polyurethane foam. The nylon or tricot shall be on the face and the back will have polyurethane quilted between two layers of nylon or tricot. There shall be a patch pocket on this liner, and the liner shall have knit wristlets, so constructed that there are buttonholes at the end of the sleeves with permanent bone buttons attached to the permanent nylon sleeve lining. The zip-out liner shall be buttoned to the permanent lining in order to ensure that the quilted liner does not pull out. The liner is to have swing action sleeves.

ZIP-OUT STORM LINER: This liner shall be constructed on Nylon with special coating compound of nitrile butadiene rubber, 2.5 oz., per square yard and chemically bonded to the basic fabric for maximum adhesion. The coating shall be an oil resistant compound and color fast.

INNER CONSTRUCTION: The inner lining is to be of first quality haroflex or non-woven pellon, utilized in all principal parts of the garment to ensure first quality tailoring and neat appearance.

COLLAR: Removable collar of Borg 1/2" (26 oz.) Orlon pile. There shall be a storm collar tab on the underside of the collar on the left side. The tab shall button back and shall have a buttonhole so that it may be used for buttoning the collar in a stand-up position during extreme cold temperatures.

SLEEVES: There shall be coat style sleeves. The bottom of the sleeves shall be interlined with non-woven fabric and shall be piped with vinyl 1/8" to show. Each sleeve shall have a button to secure the liner sleeve.

POCKETS: There shall be two box pleated patch pockets finished approximately 6-1/2" x 7" (male) and 4-7/8" x 5-3/4" (female) with scalloped flaps. The flaps shall have a firm interlining. Pockets shall have a firm interlining covered with polyester cotton fabric. The patch pockets shall be stitched to the garments and the left breast pocket is to have a pencil compartment with an opening at the top of the flap. There shall be an inside pocket on the left breast of the permanent lining.

There shall be an inside patch pocket on the zip-out liner. The flaps on the outside patch pockets shall be bartacked at both ends.

BADGE TAB: An INS Inspectors badge patch should be sewn centered 5/8" above the top of the left patch pocket flap.

ZIPPER: The zipper shall be a heavy duty aluminum storm zipper with a #19 or equal automatic lock feature. The zipper shall open from both the top and bottom.

SHOULDER STRAPS: Shall be permanently affixed to the garment. They shall be 2-1/2" (male) and 1-3/4" (female) wide at the shoulder, coming to a point underneath the collar. The length of each point shall be approximately 1-3/4" (male) and 1-1/4" (female). The shoulder strap shall have a buttonhole and button to a 24 ligne regulation USINS button affixed to the jacket. Removable type shoulder straps are unacceptable.

WRISTLETS: The zip-out quilted removable liner shall have knit wristlets at the end of each sleeve and the sleeves shall have buttonholes above the wristlets so that they may button to the jacket. A permanently sewn bone button shall be sewn to the permanent sleeve lining for this purpose.

BASIC DESIGN: Single breasted mid-length jacket (approximately 30 inches long for a size 44 regular; 27 inches long for a size medium(female), with a two-way front zipper that opens from top or bottom. Two (2) breast flap pockets to close with metal buttons and two (2) lower slash pockets with vinyl trim. Jacket shall have removable pile collar of 100% Orlon with 1/2" nap. There shall be two (2) zippered side vents, one on each side. At the bottom of the zippered side vents there shall be a snap so that the front and back may be held together when the zipper is in the full upward position, permitting easy access to the weapon. There shall be vinyl trim, 1/8" to show, on each sleeve cuff. The badge patch shall be above the left breast pocket. Shoulder straps shall be constructed of the same material as the outer shell and attached with metal buttons.

EMBLEM: United States Immigration Inspector shoulder emblem sewn on the left sleeve approximately 1 inch down from the shoulder seam, and centered on the upper sleeve of the garment. Attached with thread matching the color of the emblem.

COLOR: Navy, Raeford 8107 shade.

NAME PLATE HOLDER: Shall be sewn eyelets 3/8" above the right pocket flap. They shall be 1-5/8" on center.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MSCW, FSCW

DESCRIPTION:	**Storm Coat - Waist Length**
FABRIC:	50% Antron or Tri-lobal Nylon, 50% Rayon, Urethane treated on the back. Material is to be spark and snag resistant and constructed using a Nylon/Viscose twill treated for water and stain repellency.
PERMANENT LINER:	Same as MSC/FSC specification.
ZIPOUT QUILTED LINER:	Same as MSC/FSC specification.
INNER CONSTRUCTION;	Same as MSC/FSC specification.
COLLAR:	Same as MSC/FSC specification.
SLEEVES:	Same as MSC/FSC specification.
POCKETS:	There shall be two box pleated patch pockets finished approximately 6-1/2" x 7"(male), and 6" x 6-3/4"(female) with scalloped flaps. The flaps shall have a firm interlining. Pockets shall have a firm interlining covered with polyester cotton fabric to create a hand warmer pocket with an opening of approximately 5-3/4" for males, and 5" for females on each side. The patch pockets shall be stitched to the garments and the left breast pocket is to have a pencil compartment with an opening at the top of the flap. There shall be an inside pocket on the left breast of the permanent lining. There shall be an inside patch pocket on the zip-out liner. The flaps on the outside patch pockets shall be bartacked at both ends.
BADGE TAB:	An INS Inspectors badge patch shall be sewn top centered 2" (male) 5/8" (female) above the top of the left patch pocket flap.
ZIPPER:	The zipper shall be a #19 or equivalent aluminum storm zipper with an automatic lock.

SHOULDER STRAPS:	Same as MSC/FSC specification.
WRISTLETS:	Same as MSC/FSC specification.
WAISTBANDS:	The bottom of the jacket shall contain a waistband approximately 2-3/4" (male) 2-1/2" (female) wide finished and shall be shirred all the way around except for approximately 8" in the front when the garment is buttoned. The waistband shall have two heavy duty snap fasteners equally spaced in order that the waistband may be snapped closed.
BUTTONS:	The front shall have 5-36 ligne metal regulation USINS buttons attached. The pocket buttons shall be 34" ligne metal regulation USINS buttons.
BASIC DESIGN:	Single breasted waist length jacket with a one way front zipper closure. Two patch pocket design with pocket flaps and badge tab. The pockets shall close with a single regulation button. The jacket is to have a removable black pile collar with 1/2" nap. The style shall utilize shoulder straps of the same material as the body of the coat and the straps shall be permanently attached to the garment. The design shall include a zipout quilted liner as specified and shall incorporate a shirred waistband and a bi-swing back. All linings shall be of a compatible matching color. There shall be attached to the liner an interlining zipper, double shrunk and center marked. The zipper shall be of sufficient length to be satisfactorily attached to the facing of the jacket.
EMBLEM:	United States Immigration Inspector shoulder emblem sewn on the left sleeve approximately 1 inch down from the shoulder seam, and centered on the upper sleeve of the garment. Attached with thread matching the color of the emblem.
COLOR:	Navy, Raeford 8107 shade.
NAME PLATE HOLDER:	Shall be sewn eyelets 7/8" above the right pocket flap. They shall be 1-5/8" on center.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - RC(M)

DESCRIPTION:	**Rain Coat (male)**
FABRIC:	Shell and Yoke Lining - 65% Dacron Polyester 35% combed cotton. Sleeve lining - 100% nylon. Zip-out warmer - 100% acrylic pile. Warmer sleeve and yoke - napped satin. Outer fabric to be treated with Dupont Zepel for a water repellent finish.
COLOR:	London Fog Navy #62530 or equivalent.
STYLE:	Styling and construction of the garment shall be identical to London Fog Douglas model with the exception of 36 ligne USINS regulation buttons on the front of the garment, and 24 ligne USINS regulation buttons on the epaulets and sleeve cuffs. The cuff adjustment bands shall be joined with two brass colored D-ring closures matching the color and finish of the regulation buttons. Color of the linings and warmer shall be the same as the Douglas model.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - RC(F)

DESCRIPTION: Rain Coat (female)

FABRIC: Shell - 65% Fortel Polyester/35% combed Cotton.

Body lining - 100% Nylon.

Sleeve lining - 100% Nylon.

Zip-out Warmer - Napped Satin.

Outer fabric to be treated with Dupont Zepel application for water repellent finish.

COLOR: London Fog Navy #62124 or equivalent.

STYLE: Styling and construction of the garment shall be identical to London Fog Lissette model with the exception of 36 ligne USINS regulation buttons on the front of the garment, and 24 ligne USINS regulation buttons on the epaulets and sleeve cuffs. Color of the linings and warmer shall be the same as the Lissette model.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MWB, FWB

IMMIGRATION INSPECTOR'S WIND BREAKER

FABRIC: Color - Dark Navy Blue matching uniform fabric shade #8107.

Outer shell shall be 100% Nylon, 2 ply coated back with approximate weight of 3 ounces per square yard or 5 ounces per linear yard.

Sleeves shall utilize #70 denier Nylon Taffeta.

BASIC DESIGN: Jacket shall be zipout windbreaker style with a zipper front closure to the neck. The zipper shall be a #5 brass style zipper with automatic lock and pre-shrunk tape. The zipper tape shall be compatible with outer fabric color. Jacket shall have a shirred elastic waistband starting approximately 7 inches(male), 6-1/2"(female) back from each front edge and must go completely around the back to eliminate wind chill. Jacket shall have a plain back. Patch pockets, flaps, shoulder straps and collar shall be interlined with a non-woven fabric. The jacket shall also have two lower slash style pockets. Sleeves are to be two piece coat style with separate cuffs. The body shall be fully lined to present a clean appearance when liner is not utilized.

POCKETS & CUFFS: Two (2) breast pleated patch pockets, 5-1/4 x 6"(male), and 5-1/4 x 5"(female) with pointed flaps to button. Two outside slash pockets on slant directly below patch pockets. Pocket openings approximately 5-1/2 inches and bartacked for strength. Cuffs are to be pointed with two (2) bone buttons for cuff adjustment. Buttons are to be a navy color matching the body color.

The collar shall be fully inner-lined and top stitched. Collar points shall be 3-1/4" in length, and have a separate collar stand.

BADGE TAB: Badge patch to be a fixed 5/8", centered above the top of the left patch pocket flap.

NAMEPLATE GROMMETS: Constructed of black metal. To be positioned on right patch pocket flap on center 3/8" below top of flap spaced 1-5/8" apart.

SHOULDER STRAPS: Pointed shoulder straps of same material as jacket, sewn into shoulder seam. The end of the shoulder strap to come to edge of collar when closed and fasten with button and buttonhole.

BUTTONS: 24 Ligne buttons on shoulder straps and pocket flaps. Regulation USINS 24 Ligne buttons unless otherwise specified.

LINER: Long sleeve jacket liner of full cut design to properly fit Wind Breaker with shirt style sleeves properly bound and safety stitched with wristlets and at the end of each sleeve. There shall be two inside patch pockets, one on each side. There shall be a metal zipper all around the outside of the liner so that the entire lining can be easily removed and replaced as required. 70 denier nylon Taffeta or 88 count Tricot quilted to 1/4" polyurethane foam. Nylon or Tricot shall be on the face, the back will have polyurethane quilted between two layers of Nylon or Tricot.

EMBLEM: United States Immigration Inspector Shoulder emblem sewn on left sleeve approximately 1" inch down from the shoulder seam, and centered on the upper sleeve of the garment.

FINISHING & PRESSING: Entire jacket must be made in a first class manner. Work clothing type jacket will not be acceptable. Jacket must be pressed with proper pressing equipment and must be properly shaped.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MIJ-2, FIJ-2, MIJ-6, FIJ-6

DESCRIPTION: DRESS UNIFORM JACKET - "IKE" JACKET

FABRIC:

MIJ-2: FABRIC #2, as stated.
FIJ-2: FABRIC #2, as stated.
MIJ-6: FABRIC #6, as stated.
FIJ-6: FABRIC #6, as stated.

STYLE: The style of the garment is to be single-breasted, waist length, with a peak lapel collar and by-swing back. It shall be a four-button body with a hidden band button closure and shall have cross-stitched epaulets and two breast pockets. The style has come to be known as an Eisenhower jacket.

BODY: The body shall be a four-button front with four 24 ligne buttons equally spaced and aligned for proper closure.

It shall incorporate a lastex strip placed between the outer fabric and the lining, attached to the concealed end of each pleat and anchored at the center back seam, for the purpose of bringing the pleats back into the proper position after the wearer of the dress jacket has raised or used their arms. The design shall incorporate sweat shields with piping. The bottom of the dress jacket shall be finished with a band approximately 2-3/8" wide, made to close snugly with one 24 ligne bone button, dark blue in color. The bottom button and buttonhole must be concealed. The band is to have a 3" outlet (1-1/2" concealed) at the center of the back to accommodate waist alterations. The jacket is to be constructed in all required sizes and made to be worn to a length approximately 2" above the openings of the individual's trousers hip pockets.

The top button is to be placed approximately 1-1/4" above a horizontal line between the armpits of the dress jacket.

COLLAR: The collar is to be made approximately 15-1/2" long for a size 36 chest measurement and is to be measured along the outside edge. Other collar lengths will be proportionate to the chest measurement. The ends of the collar are to be cut back slightly and the collar shall not be wider than 1-5/8" at the back seam, nor wider than 2-7/8" at the point of junction with the lapel. The top line of the lapel is to be horizontal and the peak is to extend to the collar line (prolonged). The open notch between the collar and the lapel is not to exceed 1/2" nor is to be narrower than 1/4". The length of the collar side of the notch shall be approximately 1-1/4". The crossing of the lapels is to be approximately 1-3/4" above the top front button of the jacket body. The collar shall be properly lined and the undercollar properly shaped.

POCKETS: There shall be two outside breast pockets covered with scalloped flaps incorporating a center button and snaps at the corners of the flaps. The upper edges of the pockets shall be aligned horizontally. The pockets are to be patch pockets, slightly rounded at the lower corners, with a box pleat approximately 1-1/2" in width on the vertical center line. The outside pockets are to be fully lined with dark blue rayon satin. The scalloped flaps shall have three points. The pockets will be sized according to the size of the jacket but in no case will they exceed an inside depth of 6-1/2" or a width of 5-3/4". There shall be two inside breast pockets, reinforced with self material and fully lined with the same type and color of lining as utilized in the body, pocketing and sleeves. The dimensions of the inside pockets shall be approximately 7" deep and 5-3/4" wide. There shall be two circular embroidered eyelets, 1-5/8" apart and centered over the right breast pocket 1/2" above the top of the pocket (see nameplate eyelets). The upper edge of each pocket shall have a snap. The outer edges of the pocket flaps shall incorporate male snaps placed on the inside surface of the flaps.

BADGE: The badge tab shall be incorporated 2-1/2" above the breast pocket flap. The badge tab shall consist of two circular embroidered eyelets sewn directly into the jacket and spaced approximately 1-1/4" apart on the center. The size of the eyelets shall be approximately 1/4" in diameter and they shall be 2-1/2" above the center point of the left breast pocket flap. The embroidered eyelets shall utilize matching color thread.

NAMEPLATE EYELETS: There shall be two horizontal name plate eyelets sewn directly into the dress jacket front 1/2" above the right breast pocket flap and placed 1-5/8" apart on center. The eyelets shall be embroidered eyelets.

INNER CONSTRUCTION: Inner lining material shall consist of high quality Hymo or equivalent for added garment stiffness.

The body and sleeves of the dress jacket are to be fully lined with high quality rayon satin or nylon taffeta. The color of the lining shall be dark blue and compatible with the color of the outer material of the dress jacket. All dress jacket liners will be consistent in color and appearance. The lining must be colorfast and perspiration resistant.

UNDERCOLLAR LINING: The undercollar lining is to be made of pre-padded undercollar cloth, dark blue and compatible with the color of the outer material of the garment. The material utilized shall be 50% wool and 50% rayon with an approximate weight of 12 ounces per square yard. All dress jacket undercollar liners will be consistent in color and appearance.

SLEEVE TRIM: The sleeve trim shall consist of a cuff cloth placed on the outside of the sleeves, extending from seam to seam, with the edges sewn into the seams. The bottom edge of the cuff cloth shall be turned under and placed on top of and even with the bottom edge of the dress jacket sleeve. Roll-over attachment of the cuff cloth will not be acceptable. The cuff cloth will measure 4" along the seam edges and 6" at a point equidistant from each seam edge. The center point and seam edges shall be joined

by inverted arc cut. Straight line cuts will not be acceptable. The cuff cloth shall be of the same material as the dress jacket, except for color variation, black.

SHOULDER STRAP: Both shoulders of the dress jacket shall have a shoulder strap of the same material utilized for the sleeve trim of the dress jacket. The straps shall be let in at the sleeve head seam, reaching to approximately 3/4" beneath the collar. The straps shall button at the collar edge with a 24 ligne button. The buttons shall be positioned to appear near the edge of the collar flap, but not under the collar flap. The straps shall measure approximately 2-1/2" in width at the shoulder end and taper approximately 1-1/2" in width at the collar edge. The collar edge shall be cut at an angle to match the collar fold and shall be sewn to the dress jacket at a point underneath the collar flap. The shoulder end of the shoulder strap shall be cross-stitched down to the shoulder of the dress jacket for approximately 2" from the edge of the shoulder.

STITCHING: All pockets, flaps and edges are to be double stitched, 3/8" apart. All seams are to be plain. All sewing will be done with first quality thread, silk or polyester, with thread closely matching the color of the material. All buttonholes will be made utilizing pure silk thread and gimp.

EMBLEM: The official U.S. Immigration Inspector's emblem is to be sewn on the left sleeve of the dress jacket, on center and 1/2" below the shoulder seam.

BUTTONS: All insignia buttons are to be gilt finish, 24 ligne, regulation U.S. Inspections buttons. Buttons utilized for dress jacket closure will be secured with clear backing buttons. All insignia buttons are to be properly aligned and fastened to prevent button rotation.

FINISHING: After the dress jacket has been sewn, it will be properly pressed open. All loose threads must be removed and properly trimmed. The dress jacket shall contain size and care labels and an official U.S. Immigration Inspector's uniform item designation label. All labels shall be sewn in and properly attached. Label

location will be consistent. There shall be a 1" outlet in body length and the turn up at the sleeve cuffs shall be a minimum of 1-1/2". There shall be a hanger loop sewn into the inside back of the jacket.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - IBP

Embroidered Emblem Specifications
II BADGE PATCH

It is the intention of the Immigration and Naturalization Service to establish the grade of embroidered emblems suitable for its needs. The grade, rendition, and quality of embroidered emblems specified herein may not be deviated from in any way.

In the event of an inconsistencies in the solicitation the specifications shall take precedence.

This section consists of the embroidery specification, plus various pages of ADDENDI.

DIMENSIONS

See attached photocopy for overall sizes, shape, color and layout. Emblems must measure B* (see ADDENDUM) at the widest part by C* (see ADDENDUM) at the highest part. For uniformity, all embroidery detail must be the same height, composition, and weight as indicated on the design; stiehle borders must be the same thickness all the way around the elements they enclose; design features must be the same height and thickness; design features must be clearly delineated; and all materials, elements and colors of the emblems must be of the same construction, size, thicknesses, depths, shades and radiance as those of the established emblem design standard(s). Samples are available for review at the Immigration and Naturalization Service.

BACKGROUND MATERIAL

The background material must be of factory first quality manufacture. The material must be vat dyed 6-3/4 to 7 1/2 oz/yd, 65/35 polyester/cotton, 2/1 or 3/1 construction, cured and preshrunk (resin impregnated and oven cured). Tensile strength must be in the 170/120 range, with an absolute minimum of 150/110 and or 100% emblem polyester,.

Seconds will not be acceptable. Embroiderer must indicate here, or on the back, the names of the background material and the manufacturer.

There can be no exceptions to the material used as indicated in the above descriptions.

The color of the background material (see ADDENDUM).

FABRIC AND THREAD

All materials must be tested for weight of material, tensile strength, material count and washability by the International Fabricare Institute, or similar industry testing agency, and must have been approved by them prior to use. Industry standard test methods "AATCC" and "ASTM" must be followed for the physical testing of all base material. Test reports must be kept on file by the manufacturer, available for inspection, for one year after the materials are used.

EMBROIDERY

Prior to embroidery, a four mil polyurethane film sheet must be applied to the back side of the material. This is done to stabilize the material in the loom.

Emblems must be machine embroidered on swiss embroidery looms with automats and may not be produced on multihead equipment.

Thread color and names and numbers are the applicable standard samples for shade and obtainable from Robison-Anton (R/A below), 175 Bergen Blvd., Fairview, NJ 07022.

Thread colors and deniers, along with the necessary number of color changes are identified as follows and must be equal to Robison-Anton (R/A) color shades.

COLOR R/A	DENIER
See ADDENDUM	

The embroidery thread shall be rayon, of the finest quality Schiffli yarn in the deniers specified.

Each emblem must contain not less than P* (see ADDENDUM) stitches, Q* (see ADDENDUM) revolutions. Besides the customary and usual understanding of an embroidery stitch to mean that length of thread between two needle entry points on an embroidered emblem, one stitch is further identified as that space on a Schiffli embroidery program roll between two transport holes. One meter equalling one hundred stitches. Manufacturer must indicate here the number of stitches (and revolutions) in his/her versions of the hidden emblems.

Stitch scale must be of sufficient density as to preclude the "bleeding" (or see through) of the background material, and uneven matting (register) of color elements. There must be sufficient underlay stitching to give a full three-dimensional, high-relief appearance to these emblems, and must have the exact appearance as the standard. No stitch may be greater than ten millimeters in length.

Double thread or any thread of different deniers or plys or composition will not be permitted in any part of these emblems. Single thread stitching in the deniers and plys above must be used throughout.

FINISHING

A four mil polyurethane film sheet must be bonded to the back side of the emblems before die cutting. Sufficient heat must be applied to cause the film to melt and bond to the fabric and bobbin threads. The film must be capable of withstanding home, commercial, and industrial laundering formulas. The film must not stiffen nor crack in any of the previously mentioned wash formulas.

The film must be applied in such a manner as to preclude the crushing, flattening, or depressing of the three-dimensionality or high-relief or the embroidery, caused by the application of pressure during the bonding process; nor may there be jump stitch indentations on the fronts of loomed emblems, prior to die cutting, in the manufacturer's own facilities under constant supervisor. This process or any other may not be subcontracted.

The film backing must completely engulf all the raised elements on the reverse (back) side of the emblems, and fill all depressions.

All emblems must be die cut with forged steel dies to the exact shape and geometry of the approved design.

WORKMANSHIP

No distortion of the exterior shape of the emblem is allowable. Emblems to be template checked.

All emblems must show a clear cut execution, and must be clean, neatly made with full tension of all threads; they must be capable of laying completely flat on a smooth surface. Threads may not buckle or show underlay stitching when emblems are bent.

There must be no broken stitches in the emblems; nor may any stitches be out of proper alignment. No parts of the emblems may be mended. Each quality control inspection is to have a copy of the embroidery specifications along with an approved sample.

All emblems must conform to the quality standards of these specifications in all characteristics. No exemptions.

SAMPLES

The successful vendor will be required to submit twelve (12) each actual loom production samples of the embroidered emblem(s) to the Immigration and Naturalization Service for its approval prior to shipment. These samples must incorporate all the detail of the specifications provided.

INSPECTION AT THE MANUFACTURING FACILITY

Individual inspection of each and every embroidered emblem is required. Each emblem must be inspected against these specifications and a pass/fail determination must be made for each emblem. No random sampling inspection will be allowed. All emblems, which fail to pass this individual inspection, must be retained by the manufacturer for a period of three months after the delivery of the entire order, and must be available for inspection by the purchaser. The manufacturer must maintain records of the number and percentage of rejected emblems and provide this information promptly upon request.

PACKAGING

Emblems must be packaged in clear plastic bags, 25/30 per package depending on the size of the emblems. A packaging slip is inserted in each bag showing the manufacturer's name, the quantity and the inspector's number.

TESTING

The Immigration and Naturalization Service reserves the right to have any delivered finished product tested by any approved independent testing agency. This test will be for compliance to this specification. Failure to pass test shall result in return of all delivered products for full credit, including any products which may have been used in the intervening time, the vendor will also be responsible to pay for cost of testing. If the testing is satisfactory, the Immigration and Naturalization Service will pay the cost of testing.

LAUNDERING

Emblem must be able to withstand 52 home laundering, dry cleaning, commercial, industrial laundering and/or a combination of all. Emblems shall not fade, shrink, distort, delaminate or in any way show signs of deterioration.

U.S. MADE

The emblems are to be produced entirely in the United States of America. All materials used in the production of these emblems, material, thread, plastic coating and bobbins are to be U.S. made.

ADDENDUM
EMBROIDERED EMBLEMS

DESCRIPTION: U.S. Immigration Inspector

DIMENSIONS: 2 3/8" x 3 1/4" high

BACKGROUND MATERIAL/FABRIC:

COLOR: Midnight Navy Blue FABRIC: 100% Emblem Polyester and/or 65/35 poly/cotton

EMBROIDERY COLORS:

COLOR:	CABLE COLOR:	DENIER RAYON:
Luggage FD-57	Gold Brown HCT 67194	100/2
Kelly Green FD-32	Prophet Green HCM 67187	100/2
White FD-008	White HA 67101	100/2
Amberlite FDB-65	Buff HAK 67135	150/2
Gold Metallic 7282G	N/A	100/2
Midnight Navy Blue FDB-1	Midnight Blue HZ 67135	100/2
Red FD-17	Scarlet HL 67111	100/2
Royal FD-3	Yale Blue HCA 67176	100/2
Yellow FD-71	Yellow HH 67108	100/2

NUMBER OF SCHIFFLI EMBROIDERY STITCHES:

8,210 stitches - 16,420 Revolutions

IMMIGRATION
INSPECTOR

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

 # 1992 - RGJ

DESCRIPTION:	Rain Gear - Ultrex Parka
FABRIC:	Shell - Water proof 100% nylon supplex ultrex. Weight 3.4 oz. per square yard. Lining - Nylon taffeta - 104 x 68 pick.
FRONT:	Two piece front construction; lower front forming pocket with triangle shaped flap with concealed snap closure. Top and lower front joined by 3/16" gage single needle stitching. Flap with 2 row single stitching 1-1/8" apart. Left front has sewn on badge patch. Patch will be seam sealed around stitching.
FRONT FLY:	Double front storm fly. Left side of fly shall be interlined. Left side patched on with 5 evenly spaced snap tops with top snap being 3/4" down from top and 3/4" from edge. Right side of fly patched on with 5 matching male snap parts.
SLEEVE:	One piece raglan construction. Sleeve end has clean finished rolled hem. Sleeve has hook and loop tab take up. Left sleeve shall have Immigration patch sewn on and seam sealed around stitching.
BACK:	One piece construction - locker loop shall be sewn in center back neck seam.
COLLAR:	Shirt type collar with interfacing. Edge stitched 3/16". Collar has 4 male snap parts to match corresponding snap on hood.
HOOD:	Three piece hood construction. Snaps off with corresponding snap to match collar. Hook and loop closure on hood face piece. Hood has draw string take up with 2 metal eyelets. Has 1/8" top stitching all around. Hood has inside facing around hood face and chin piece.
ZIPPERS:	Front zipper shall be a #5 separating molded zipper. Side zipper shall be a coil, one way zipper 13" long. A self goods inside fly shall be attached to front side seam of jacket to finish 1-1/2" wide. A snap cap shall be in hem on back with corresponding snap on fly edge 1/2" from bottom.

LINING: Front, back and sleeve lining, shall each be of a 1 piece construction. Inside lower left front shall have a large cargo pocket. Pocket will be caught in lower hem and side seam zipper edge. Bottom hem shall be clean finished, rolled hem, single needle stitch.

SEAM: All exterior seams shall be seam sealed with 2 ply 7/8" seam seal tape.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - RGP

DESCRIPTION:	Rain Gear - Ultrex Pants
FABRIC:	Shell - Water proof 100% Nylon Supplex Ultrex. Weight 3.4 oz. per square yard. Lining - Nylon taffeta - 104 x 68 pick.
WAISTBAND:	One piece shirred waist band. 2" elastic encased in self goods with one single needle stitch around center of waistband. Pant has 4 belt loops, 2 center front, 2 center back. Loop finished 1" wide, has 1/8" single needle edge stitch. Belt loop attached to body of pant with snap assembly. Outside bottom of loop has snap cap for encasing belt. Inside waistband has draw cord take up. Cord exits for 2 metal eyelets inside front waistband. Waist draw cord has lace lock.
FRONT & BACK:	Is of single piece construction.
BOTTOM HEM:	Clean finish single rolled hem, 3/4" wide. Snap adjustment on out seam - 1 male, 1 female, 3" apart.
SEAM:	All exterior seams shall be seam sealed with 2 ply 7/8" seam seal tape.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - SCA-5

DESCRIPTION:	Summer Weight - Short Sleeve Non-Insulated Coverall
FABRIC:	Wrinkle-free permanent press poplin of 65% Dacron polyester, 35% cotton. 3M's Scotchguard soil release finish. 4.5 oz. per square yard. Navy Blue.
REFERENCE SIZE:	All dimensions are based on a 40 regular.
FRONT:	The covered waistband shall be folderset, 1-5/8 inches wide, one piece construction. Waistband shall be basic material and shall be topstitched with double stitching 3/16 inch gage at top and bottom of waistband. The front length shall be 30 inches from the crotch to the collar seam.
FRONT ZIPPER:	The front closure shall be two-way size 4.5 YKK coil zipper with single pull long tab sliders positioned mouth-to-mouth. There shall be one gripper snap 5 inches below neck line and 3/4 inches from front edge.
POCKETS:	There shall be two breast pockets with box pleats. Breast pleats shall be 5-1/4 inches deep. There shall be two swing front, side-entry pockets 11 inches deep. The pocketing shall be 70% polyester, 30% cotton, 2.85 oz. per square yard. The two back hip pockets shall be patch pockets 7 inches wide by 7 inches deep. Left hip pocket zipper closure. All stress points bar tacked.
COLLAR:	The self-collar shall be two piece construction. The collar shall be 3-1/2 inches high at center back and shall be stitched, turned and top-stitched 1/4 inch gauge. The collar shall be 15 inches wide with 3-1/2 inch collar points.
THREAD:	Threads USA 50 Oncore.
SLEEVES:	The sleeves shall be one-piece, set-in construction with french cuff. Sleeve is 9 inches long from shoulder crown with 16 inch opening.

STITCHING: Serge or safety stitch seam construction shall be used on all the major seams, with a minimum of 7 stitches per inch. Collar and lapel shall be single needle construction.

BACK: The back shall be 2-piece, bi-swing style with felled seam construction. Each side shall have 1 1-1/2 inch pleat at the shoulder seam, folded from inside to outside seam and top-stitched 1/4 inch gauge. The pleat shall taper to 3/8 inch at the waist.

SIZES AVAILABLE: Sizes shall be available in every even chest size as follows:

Short	36	38	40	42	46	48						
Regular	34	36	38	40	42	44	46	48	50	52	54	56
Tall	36	38	40	42	44	46	48	50	52	54	56	
X-Tall	38	40	42	44	46	48	50	52	54			

The contractor will not be required to stock X-Tall.

LABEL: Identification, size, and care label shall be sewn to the inside under the collar seam.

EMBLEMS:

1. An INS Inspectors Emblem shall be sewn on the left sleeve 1/2 inch down from the shoulder seam.

2. An INS Inspectors Badge Patch Emblem shall be sewn or heat sealed to the left chest. The bottom of the emblem shall be 1 inch above the top of the pocket.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

#1992 - LCA-5

DESCRIPTION: Coveralls - Long Sleeve Non-Insulated

FABRIC: The basic material shall be 100 percent cotton Graniteville Rugged Twill, 7-1/2 ounces/square yard minimum. Navy Blue

STYLE: The coveralls are designed to be worn as outer garments over regular clothing. The coveralls feature a self collar, two zippered chest pockets, pencil pockets, and two hip pockets (one zippered.)

REFERENCE SIZE: All dimensions are based on a 40 Regular.

FRONT: The covered waistband shall be folderset, 1-3/4 inches wide, one piece construction. Waistband shall be basic material and shall be top-stitched with double stitching 3/16 inch gauge at top and bottom of waistband. The front length shall be 31 inches from the crotch to the collar seam.

FRONT ZIPPER: The front closure shall be two-way size 5 YKK brass zipper with single pull long tab sliders positioned mouth-to-mouth. Zipper shall run from 5 inches above the crotch line to within 1-3/4 inch of the collar seam. There shall be one universal nickel plated snap 1 inch below neck line and 1 inch from front edge, and one universal nickel plated snap 2-1/2 inches below top of zipper. A 1-1/8 inch wide storm flap shall cover the zipper.

POCKETS: There shall be two breast patch pockets with size 4 YKK brass zipper closures which shall be 5-1/2 inches long. Breast pockets shall be 6-1/4 inches wide, 4-1/2 inches on front side and 5-1/2 inches on back side. Top portion of pocket shall be 2 inches high and 6-1/4 inches wide. There shall be two swing front, side-entry pockets 11 inches deep. The pocketing shall be 70% polyester, 30% cotton, 2.85 oz/sq yard. The two back hip pockets shall be patch pockets 7 inches wide by 7 inches deep and folderset attached with double stitching, 1/4 inch gauge. A quarter top plier/ruler pocket shall be located below the right pocket and shall have a 4 inch opening and shall be 5 inches deep from

bottom of opening.

COLLAR: The self-collar shall be convertible, one piece construction. The collar shall be 2-3/4 inches high at center back and shall be stitched, turned and top-stitched 1/8 inch gauge. The collar shall be 18 inches wide with 2-1/2 inch collar points.

THREAD: Threads USA 50 Oncore.

SLEEVES: The sleeves shall be two-piece, set-in construction with universal nickel plated snaps at cuff closure to keep garment from being caught in machinery or equipment. (Snap closures are also on leg cuffs). The cuff shall finish with a 5 inch opening from bottom of cuff. Left sleeve shall have a 2-1/2 inches wide by 5-1/4 inches deep pencil pocket with stitching in the center to form two pencil compartments. The pencil pocket shall be located 5 inches below the shoulder seam.

STITCHING: Serge or safety stitch seam construction shall be used on all the major seams, with a minimum of 6 stitches per inch. Collar and lapels shall be single needle construction.

BACK: The back shall be a 2-piece bi-swing style with felled seam construction. Each side shall have a 1-1/2 inch pleat at the shoulder seam, folded from inside to outside seam and top-stitched 1/4 inch gauge. The pleat shall taper to 3/8 inch at the waist.

SIZES AVAILABLE: Sizes shall be available in every even chest size as follows:

Short	36	38	40	42	46	48						
Regular	34	36	38	40	42	44	46	48	50	52	54	56
Tall	36	38	40	42	44	46	48	50	52	54	56	
X-Tall	38	40	42	44	46	48	50	52	54			

The contractor will not be required to stock X-Tall.

LABEL: Identification, size, and care label shall be sewn to the inside under the collar seam.

EMBLEMS:

1. An INS Inspectors Emblem shall be sewn on the left sleeve 1/2 inch down from the shoulder seam.

2. An INS Inspectors Badge Patch Emblem shall be sewn or heat sealed to the left chest. The bottom of the emblem shall be 1 inch above the top of the pocket.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MLSP-5, FLSP-5

DESCRIPTION: Long Sleeve Shirt, POPLIN

FABRIC: Poplin - 65/35 Polyester Combed Cotton, 4.25 oz. per square yard.

COLOR: **Lippman 101, White**

STYLE: The style shall be known as a banded collar, long sleeve shirt, with full length tail. The shirt is to have two (2) pleated outside breast pockets and scalloped flaps having one (1) button each. It also will have a full badge sling and shoulder straps. The back will have a Western style yoke to match the style of the scalloped pocket flaps.

COLLAR: To be die cut. The back of the stand is to measure 1-1/2". The points are to be approximately 2-7/8" in length and top stitched 1/4" from edge. The interlinings are to be 100% polyester, 250 Denier. Collar band to be lined with crease 'n' tack interlining. Permanent collar stays of proper length are to be sewn inside collar so that no stitches are made through the bottom leaf. The stand shall fasten with one button.

FRONT: The left front (right front for female shirt) shall have a center facing that is 1-1/2" wide that will accommodate a zipper if so designated, extending from the collar joining seam to the bottom of the shirt. The center facing shall be made of the same fabric as the shirt with two (2) rows of stitching 7/8" apart. The center facing shall be fully lined to give body by sewing in a 100% polyester interlining cut straight. The left front (right front for female shirt) shall have seven (7) buttonholes spaced 3-3/4" apart and set 3/4" from edge. The second buttonhole is to be positioned 2-1/2" from the top button; balance of the buttons are to be spaced 3-3/4" apart. The buttons are to be strongly attached through two thicknesses of material forming the right front (Left front for female shirt), and shall correspond to each buttonhole. Zipper fronts to be made available as an extra cost option.

SHOULDER STRAPS: Topstitched 1/16" off the edge to be set on the yoke with a leading topstitch overlapping the front joining seam. The straps are to measure 1-7/8" - 2" at sleeve, tapering to 1/4". Straps are not to be x-stitched.

BADGE REINFORCEMENT: Sling 1" wide centered over the left pocket, stitched to the shoulder seam and flap setting stitch. It is to have two (2) buttonhole eyelets approximately 5/8" from top of the pocket flap spaced 1-1/4" apart and centered on the sling.

POCKETS: Two (2) breast pockets with 1-1/2" stitched pleats. The pockets are to measure 5-3/8" wide, 5-3/4" deep. (4-1/2" x 5" for female shirt.) The left breast pocket to have a 1-3/8" pencil slot. Each pocket is to have a Velcro tape 1" long by 3/8" wide, positioned on both edges of the pocket to correspond with the outer scalloped flap points. The tape is to be the same color as the shirting material. Each pocket shall have a button to accommodate the flap buttonhole.

FLAPS: To have two (2) scalloped flaps, topstitched around the edges, to finish 5-1/2" in width, 2-3/4" deep width at center, and 2-3/8" in width at the sides. (Female: 4-3/8" x 2-1/2" x 2-3/16"). The flaps are to be secured to the front of the shirt above the pocket with two (2) rows of stitching 3/16" apart. The left flap is to have an invisible pencil opening of 1-1/4" to correspond precisely with the pencil slot of the pocket. Both flaps are to be interlined with 100% cotton. The flaps shall button down to the pocket material. The side points of the flaps are to be secured to the pockets by means of Velcro fasteners sewn onto the flaps and pockets; the hook portion being stitched to the pocket and the pile portion sewn to the underside of the flap. The Velcro tape is to measure 1" long by 3/8" wide, is to be positioned on the outer points of both pocket flaps, and is to be the same color as the shirting material.

SLEEVES AND CUFFS: The long sleeves will be cut straight and whole, with a 5" sleeve vent. The sleeve shall have a one-piece banjo elbow reinforcement and vent facing. Banjo elbow reinforcement corners must be rounded and shall extend into the sleeve closing seam at the bottom. The reinforcement shall measure approximately 11" long and shall be approximately 2" wide at the cuff. The sleeve cuffs shall be 3" wide and shall have rounded corners. There shall be two buttons with corresponding buttonholes on each cuff, with one button and buttonhole in the sleeve facing, approximately 2-1/2" from the top of the cuff. Both cuffs are to be interlined.

BUTTONS: Will be first grade white 19 ligne pearlescent plastic to match the color of the shirt fabric.

STITCHING: Single needle throughout. All top-stitching, except collar, is to be 1/16" off the edge. The sleeve inserting and side close felling will be safely stitched.

THREAD: All sewing threads are to be color fast Polyester core cotton wrap to match the color of the shirt fabric.

MILITARY CREASES: There shall be five (5) "Lintraked" military creases on all shirts. One (1) crease in each front extending from the hem to the shoulder seam. The crease is to run under the pocket and pocket flap. The front pockets and flaps are to be centered over the creases. Three (3) vertical creases in back, side creases spaced equally from the center crease.

LINING: All collar bands, flaps, and epaulets are to be interlined with Crease-n-Tack.

YOKE: There shall be a center pointed Western style yoke on the back matching the scalloped design of the pocket flaps. The depth of the yoke is to be 4" at the center point and 3" at the sides. The three military creases on the back of the shirt are to go under the yoke. The center crease is to go through the center point of the yoke and the other two creases are to be equidistant between the center point and side points of the yoke.

EMBLEM ATTACHMENT: The U.S. Immigration Inspector emblem will be attached 1/2" below the left shoulder seam, centered with colorfast Poly core thread matching the emblem. It is to be attached during the assembly of the shirt.

NAMEPLATE REINFORCEMENT: Two-ply reinforcement 3/8" x 2-5/8" of self material sewn to the inside of the shirt and centered over the right parallel to 5/8" above the top of the right pocket flap. It shall have two (2) embroidered eyelets. The eyelets, spaced 1-3/4" apart with each eyelet 5/8" above the top of the flap, are to be attached in a horizontal direction.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - MSSP-5, FSSP-5

DESCRIPTION: Short Sleeve Shirt, SUMMER POPLIN

FABRIC: Poplin - 65/35 Polyester Combed Cotton, 4.25 oz. per square yard.

COLOR: **Lippman 101, White**

STYLE: The style shall be known as a convertible collar, short sleeve shirt, with full length tail. The shirt is to have two (2) pleated outside breast pockets and scalloped flaps having one (1) button each. It also will have a full badge sling and shoulder straps. The back will have a Western style yoke to match the style of the scalloped pocket flaps.

COLLAR: The convertible style collar shall be one piece and is to measure 2-7/8" long at the points. The collar shall be made with permanent sewn-in mylar collar stays. The collar height at the rear is 1-1/2", top stitched 1/4" off the edge. The collar shall be interlined with 100% polyester taffeta.

FRONT: The left front (right front for female shirt) shall have a center facing that is 1-1/2" wide that will accommodate a zipper if so designated, extending from the collar joining seam to the bottom of the shirt. The center facing shall be made of the same fabric as the shirt with two (2) rows of stitching 7/8" apart. The center facing shall be fully lined to give body by sewing in a 100% polyester interlining cut straight. The left front (right front for female shirt) shall have seven (7) buttonholes spaced 3-3/4" apart and set 3/4" from edge. The second buttonhole is to be positioned 2-1/2" from the top button; balance of the buttons are to be spaced 3-3/4" apart. The buttons are to be strongly attached through two thicknesses of material forming the right front (Left front for female shirt), and shall correspond to each buttonhole. Zipper fronts to be made available as an extra cost option.

SHOULDER STRAPS: Topstitched 1/16" off the edge to be set on the yoke with a leading topstitch overlapping the front joining seam. The straps are to measure 1-7/8" - 2" at sleeve, tapering to 1/4". Straps are not to be x-stitched.

BADGE REINFORCEMENT: Sling 1" wide centered over the left pocket, stitched to the shoulder seam and flap setting stitch. It is to have two (2) buttonhole eyelets approximately 5/8" from top of the pocket flap spaced 1-1/4" apart and centered on the sling.

POCKETS: Two (2) breast pockets with 1-1/2" stitched pleats. The pockets are to measure 5-3/8" wide, 5-3/4" deep. (4-1/2" x 5" for female shirt.) The left breast pocket to have a 1-3/8" pencil slot. Each pocket is to have a Velcro tape 1" long by 3/8" wide, positioned on both edges of the pocket to correspond with the outer scalloped flap points. The tape is to be the same color as the shirting material. Each pocket shall have a button to accommodate the flap buttonhole.

FLAPS: To have two (2) scalloped flaps, topstitched around the edges, to finish 5-1/2" in width, 2-3/4" deep width at center, and 2-3/8" in width at the sides. (Female: 4-3/8" x 2-1/2" x 2-3/16"). The flaps are to be secured to the front of the shirt above the pocket with two (2) rows of stitching 3/16" apart. The left flap is to have an invisible pencil opening of 1-1/4" to correspond precisely with the pencil slot of the pocket. Both flaps are to be interlined with 100% cotton. The flaps shall button down to the pocket material. The side points of the flaps are to be secured to the pockets by means of Velcro fasteners sewn onto the flaps and pockets; the hook portion being stitched to the pocket and the pile portion sewn to the underside of the flap. The Velcro tape is to measure 1" long by 3/8" wide, is to be positioned on the outer points of both pocket flaps, and is to be the same color as the shirting material.

SHORT SLEEVES:	The sleeves are to be straight and whole, to have a 3/4" hem and to finish approx. 9" long from the shoulder seam (8" on female).
BUTTONS:	Will be first grade white 19 ligne pearlescent plastic to match the color of the shirt fabric.
STITCHING:	Single needle throughout. All top-stitching, except collar, is to be 1/16" off the edge. The sleeve inserting and side close felling will be safely stitched.
THREAD:	All sewing threads are to be color fast Polyester core cotton wrap to match the color of the shirt fabric.
MILITARY CREASES:	There shall be five (5) "Lintraked" military creases on all shirts. One (1) crease in each front extending from the hem to the shoulder seam. The crease is to run under the pocket and pocket flap. The front pockets and flaps are to be centered over the creases. Three (3) vertical creases in back, side creases spaced equally from the center crease.
LINING:	All collar bands, flaps, and epaulets are to be interlined with Crease-n-Tack.
YOKE:	There shall be a center pointed Western style yoke on the back matching the scalloped design of the pocket flaps. The depth of the yoke is to be 4" at the center point and 3" at the sides. The three military creases on the back of the shirt are to go under the yoke. The center crease is to go through the center point of the yoke and the other two creases are to be equidistant between the center point and side points of the yoke.
EMBLEM ATTACHMENT:	The U.S. Immigration Inspector emblem will be attached 1/2" below the left shoulder seam, centered with colorfast Poly core thread matching the emblem. It is to be attached during the assembly of the shirt.

NAMEPLATE REINFORCEMENT: Two-ply reinforcement 3/8" x 2-5/8" of self material sewn to the inside of the shirt and centered over the right parallel to 5/8" above the top of the right pocket flap. It shall have two (2) embroidered eyelets. The eyelets, spaced 1-3/4" apart with each eyelet 5/8" above the top of the flap, are to be attached in a horizontal direction.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - TSH

DESCRIPTION:	Trooper style straw hat or Montana Peak Summer Straw Hat
QUALITY:	#1 quality bedford Hemp Braid, tight weave, 5 to 5-1/2 mm width.
COLOR:	Navy blue
CROWN:	Montana peak traditional four dent style, crown to be 5-1/2" high.
BRIM:	3" wide straight flat set. Two separate brims joined for extra strength and shape retention. Brims are sewn together, heavily stiffened and shower proofed. Made from 5-5 1/2 mm Bedford Hemp braid.
STIFFENING:	Crown double dipped. Brim triple dipped with #21 sizing by Kempen Paint Company.
CROWN EYELETS:	One eyelet on each side and one in the rear of hat, all three to be 2-3/4" above the brim.
BRIM EYELETS:	3/8" oval, one on each side, to accommodate the chin strap, eyelets normally centered on each side.
BADGE EYELETS:	To your specifications, normally one in front 2-1/8" above the brim.
SWEAT BAND:	Head culture foam sweat with oil silk liner.
HAT BAND:	Regulation USINS black leather brim band, 1" wide, untooled, Colonial gild buckle on left.
PACKING:	Hats are to be packed one to a box with size on the outside of each box.
SHIPPING:	The hats are to be packed in shipping containers of sufficient strength to withstand transportation by common carrier and to assure safe arrival at the delivery point.

IMMIGRATION AND NATURALIZATION SERVICE

EMBROIDERED SHOULDER EMBLEM

#1992 ESE

It is the intention of the Immigration and Naturalization Service to establish the grade of embroidered emblems suitable for its needs. The grade, rendition, and quality of embroidered emblems specified herein may not be deviated from in any way.

In the event of an inconsistencies in the solicitation the specifications shall take precedence.

This section consists of the embroidery specification, plus various pages of ADDENDI.

1. DIMENSIONS

See attached photocopy for overall sizes, shape, color and layout. Emblems must measure B* (see ADDENDUM) at the widest part by C* (see ADDENDUM) at the highest part. For uniformity, all embroidery detail must be the same height, composition, and weight as indicated on the design; stiehle borders must be the same thickness all the way around the elements they enclose; design features must be the same height and thickness; design features must be clearly delineated; and all materials, elements and colors of the emblems must be of the same construction, size, thicknesses, depths, shades and radiance as those of the established emblem design standard(s). Samples are available for review at the Immigration and Naturalization Service.

2. BACKGROUND MATERIAL

a. The background material must be **D* (see ADDENDUM)** of factory first quality manufacture. The material must be **vat dyed, 7 oz/yd., 65/35 polyester cotton, and/or 100% emblem polyester, 2/1 or 3/1 construction, cured and preshrunk,** (resin impregnated and oven cured). Tensile strength shall be in the **170/120 range. with an absolute minimum of 150/110.**

Seconds will not be acceptable. Embroiderer must indicate here, or on the back, the names of the background material and the manufacturer.

There can be no exceptions to the material used as indicated in the above descriptions.

The color of the background material **must be E* (see ADDENDUM).**

3. EMBROIDERING

Prior to embroidery, a four mil polyurethane film sheet must be applied to the back side of the material. This is done to stabilize the material in the loom.

Emblems must be machine embroidered on swiss embroidery looms with automats and may not be produced on multihead equipment.

Thread color and names and numbers are the applicable standard samples for shade and obtainable from Robison-Anton (R/A# below), 175 Bergen Blvd., Fairview, NJ 07022.

Thread colors and deniers, along with the necessary number of color changes are identified as follows and must be equal to F* Robison-Anton (R/A#) color shades.

COLOR R/A	DENIER
See ADDENDUM	

The embroidery thread should be rayon yarn, finest quality, continuous filament regenerated cellulose type, in the deniers specified.

Each emblem must contain not less than P* (see ADDENDUM) stitches, Q* (see ADDENDUM) revolutions, not including the stitching in the overlocked merrow edge. Besides the customary and usual understanding of an embroidery stitch to mean that length of thread between two needle entry points on an embroidered emblem, one stitch is further identified as that space on a Schiffli embroidery program roll between two transport holes. One meter equalling one hundred stitches. Manufacturer must indicate here the number of stitches (and revolutions) in his/her versions of the hidden emblems.

Stitch scale must be of sufficient density as to preclude the "bleeding" (or see through) of the background material, and uneven matting (register) of color elements. There must be sufficient underlay stitching to give a full three-dimensional, high-relief appearance to these emblems, and must have the exact appearance as the standard. No stitch may be greater than ten millimeters in length. Double thread or any thread of different deniers or plys or composition will not be permitted in any part of these emblems. Single thread stitching in the deniers and plys above must be used throughout.

4. OVERLOCKED MERROW EDGE

Overlocked merrow edges shall be applied to the emblems after the loom operation. Zig-zag stitches (in the configuration of alternating V's and inverted V's. supported by running stitched must be applied around the entire periphery of the individual emblem, under the overlocked merrow edge, to prevent the merrow edge from pulling away from the base material. Straight line

running stitches alone will not serve this purpose; buttonhole stitched edge under the merrow edges do not meet this requirement.

The overlocked merrow edge shall consist of seven separate threads: five 150/2 denier rayon threads for the top (or front) portion of the edge or five 135/2 denier polyester and two 20/2 denier cotton threads for the underneath (or back side) of the edge.

The overlocked merrow edge must be at least twenty-two (22) threads per inch.

The overlocked merrow edges shall be overrun a minimum of 3/8", and the seven end threads shall be pulled through the entire length of the overrun to prevent ravelling. Threads must not be taped, pasted down, knotted, tied, fused into, onto, or under the plastic film backing, cut off, tucked under, or chained off, all seven threads must be pulled through the entire length of the overrun.

The color of the overlocked merrow edges shall be R* (R/A S*) (see ADDENDUM).

5. FINISHING

A four mil polyurethane film sheet shall be bonded to the back side of the emblems before die cutting. Sufficient heat shall be applied to cause the film to melt and bond to the fabric and bobbin threads. The film must be capable of withstanding home, commercial and industrial laundering formulas. The film must not stiffen nor crack in any of the previously mentioned wash formulas.

The film should be applied in such a manner as to preclude the crushing, flattening, or depressing of the three-dimensionality or high-relief of the embroidery, caused by the application of pressure during the bonding process, nor may there be jump stitch indentations on the fronts of the emblems. The film sheet must be applied to the span of loomed emblems, prior to die cutting, in the manufacturer's own facilities, under constant supervision. This process or any other may be subcontracted.

The film backing must completely engulf all the raised elements on the reverse (back) side of the emblems, and fill all depressions.

All emblems shall be die cut with forged steel dies to the exact shape and geometry of the approved design.

6. WORKMANSHIP

There shall be no distortion of the exterior shape of the emblem. Emblems to be template checked.

The finished emblem must show a clear out execution and must be clean; neatly made, with full tension on all threads. They must be capable of laying completely flat on a smooth surface. Threads must not buckle nor show underlay stitching when emblems are bent.

The finished product must show no broken stitches, nor may any stitches be out of proper alignment. No parts of the emblems may be mended. Each quality control inspection is to have a copy of the embroidery specifications along with an approved sample.

The finished product must conform to the quality standard of this specification in all characteristics. No exceptions.

7. CERTIFICATION

By submission of its proposal the vendor certifies that all materials used in the construction of this embroidered emblem are washable and satisfy the weight, dimension, tensile strength and thread count in accordance with all applicable industry standards and the specifications herein.

8. SAMPLES

The successful vendor will be required to submit twelve (12) each actual loom production samples of the embroidered emblem(s) to the Immigration and Naturalization Service for its approval prior to shipment. These samples must incorporate all the detail of the specifications provided.

INSPECTION AT THE MANUFACTURING FACILITY

Individual inspection of each and every embroidered emblem is required. Each emblem must be inspected against these specifications and a pass/fail determination must be made for each emblem. No random sampling inspection will be allowed. All emblems, which fail to pass this individual inspection, must be retained by the manufacturer for a period of three months after the delivery of the entire order, and must be available for inspection by the purchaser. The manufacturer must maintain records of the number and percentage of rejected emblems and provide this information promptly upon request.

PACKAGING

Emblems must be packaged in clear plastic bags, 25/30 per package depending on the size of the emblems. A packaging slip is inserted in each bag showing the manufacturer's name, the quantity and the inspector's number.

TESTING

The Immigration and Naturalization Service reserves the right to have any delivered finished product tested by any approved independent testing agency. This test will be for compliance to this specification. Failure to pass test shall result in return of all delivered products for full credit, including any products which may have been used in the intervening time, the vendor will also be responsible to pay for cost of testing. If the testing is satisfactory, the Immigration and Naturalization Service will pay the cost of testing.

LAUNDERING

Emblem must be able to withstand 52 home laundering, dry cleaning, commercial, industrial laundering and/or a combination of all. Emblems shall not fade, shrink, distort, delaminate or in any way show signs of deterioration.

U.S. MADE

The emblems are to be produced entirely in the United States of America. All materials used in the production of these emblems, material, thread, plastic coating and bobbins are to be U.S. made.

ADDENDUM
EMBROIDERED EMBLEMS

DESCRIPTION: U.S. Immigration Inspector

DIMENSIONS: (B* & C*)

4" X 5"

BACKGROUND MATERIAL/FABRIC:

65/35 poly/cotton and/or 100% Emblem Polyester

BACKGROUND COLOR: (E*)

Midnight Navy Blue

EMBROIDERY COLORS: (F*)

COLOR:	CABLE COLOR:	DENIER RAYON:
Midnight Blue FDB1	Midnight Blue HZ 67125	150/2
Special Dark Gold FDB73	Air Force Yellow HL 67103	150/2
Fawn	Khaki HCS 67193	150/2
Black FDA59	Black HAN 67138	150/2
White FD008	White HA 67101	150/2

NUMBER OF STITCHES & REVOLUTIONS: (P* & Q*)

11,506 Stitches - 23012 Revolutions

OVERLOCKED MERROW EDGE COLOR: (R* & S*)

COLOR:	CABLE COLOR:	DENIER RAYON:
Midnight Blue FDB1	Midnight Blue HZ 67125	150/2

UNITED STATES
IMMIGRATION
INSPECTOR

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - HCA

DESCRIPTION: Hat Cord With Acorn

Shall consist of a gold Mylar cord double looped and passing through a Mylar covered bead at the center front designed to allow size adjustment. Both ends of the cord shall incorporate a Mylar covered "acorn" bead.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - RDCW-5

DESCRIPTION: Rough Duty Cap - Winter Twill

FABRIC: **Graniteville Chetopa IV, Navy Blue #80000**

COLOR: Navy Blue

STYLE: The style shall be a full twill with an adjustable headband. The official Inspections Badge patch shall be embroidered to the front panel.

FRONT PANEL: The high front crown panel shall be constructed of one piece which shall be equal to 1/3 of the circumference of the cap. The panel shall be 7 1/2 inches wide at the visor, 4" high at the center measured from the visor to the seam and 7 1/4" long at each side. The front panel shall be laminated.

CROWN: The crown shall consist of two parts. The front part shall be a one panel fabric insert with pleat with the official emblem centered on the frontpiece approximately 3/4" above the visor. The twill fabric must be laminated to a tricot foam. The rear part shall be a four panel, triangular in design and arched at the center rear to allow for headband adjustment. Joining seams must be taped.

BILL: The bill of the cap shall be approximately 2 5/8" at center front and approximately 4 1/2" at the side edges. It shall be rounded and interlined so that the finished thickness is approximately 3/16". The bill covering shall be firmly stitched to the lining with eight stitch lines. The visorboard shall be of fiber impregnated with latex with a weight of 5 oz. and thickness of .060 inches.

VISOR: The visor and visor lining shall be twill fabric interlined with a visor stiffener and sewn with six parallel rows of 3/16" gauge stitching that follow the contour of the visor. The visor shall finish smooth without twists or pockets.

SWEATBAND: The sweatband shall be a cotton or rayon polyester blend, black in color and interlined with a moisture barrier. The sweatband shall be at least 1 1/8" wide when finished and shall be one piece, extending to the ends of the arched mesh inserts.

CROWN: The crown pieces shall be sewn together, the seam allowance pressed flat, then sewn down with 5/8" tape with stitch type 301 or 401.

CLOSING SEAMS: The visor and sweatband shall be sewn to the crown with type 301 stitch and the sweatband shall finish smooth and be flat against the side of cap. A button covered with basic material, size 22 line, shall be set into the crown at the junction of the six crown pieces.

REAR OUTLET: The rear outlet cut shall be folded under and taped down. The size adjuster shall be plastic tape to match twill material with seven holes and pins that snap together to provide a secure closure.

DIRECT EMBROIDERY: An "Immigration Inspector" Badge Patch shall be directly embroidered onto the front panel in the center. The patch shall be the shape, color and size in accordance with the figure on page 59.

The wording and patch on the front panel shall be machine embroidered on embroidery machines with automats, and shall not be produced on multi-head equipment.

The solid-stitched background field shall be a running stitch field. A blatt (or loose) stitched field will not be acceptable. There shall be no visible "corduroy" effect. A "corduroy" type field is one in which the overall appearance consists of a regular succession of stitches and spaces, similar to the regular rises and falls in corduroy fabric, and is not acceptable.

Thread color names and numbers are the applicable standard sample for shad and are contained in the DOD Standard Color Card of Official Standardized Shades for heraldic Yarns for embroidery and ribbons. This Color Card is obtainable from the Color Association of the United States, Inc., 343 Lexington Avenue, New York, NY 10016 (Tel No. 212 683-9531.)

Thread colors and deniers, along with the necessary number of color changes are identified as follows, and shall closely match the following heraldic yarn color shades:

Description	Cable Name/No.	Rayon
Inner circle and shield	Buff HAK 67135	150/2
Shield and top eagle	Gold Mylar	100/2
Ribbons & U.S.	Midnight blue 67125	150/2
Flag, Eagle Tail Head, Lettering	White HA 67101	100/2
Outline	Midnight Blue 67125	100/2
Flag	Scarlet HL 67111	100/2
Flag	Yale Blue HCA 67176	100/2
Leaves	Prophet Green HCM 67187	100/2
Eagle	Gold Brown HCT 67194	100/2
Eagle's beak	Yellow HH 67108	100/2

- Thread shall be rayon yarn, finest q u a l i t y , continuous filament, and colorfast, in the deniers specified above.

  Besides the customary and usual understanding of an embroidery "stitch" to mean that length of thread between two needle entry points on an embroidered emblem, one stitch is further identified as that space on a shiffli embroidery program roll between the two transport holes. One meter equalling one hundred stitches.

  Stitch scale shall be of sufficient density as to preclude the "bleeding" (or see through) of the background material, and uneven matting (register) of color elements. There shall be sufficient underlay stitching to give a full three-dimensional, high-relief appearance to the embroidery. No stitch may be greater than ten millimeters in length.

  Double thread of any thread of different deniers of plys will not be permitted in any part of the embroidery. Single thread stitching in the deniers and plys above shall be used throughout.

THREAD: The thread shall be polyester, size 40 or cotton-cove cotton-covered polyester, size 50 color dyed to match basic material except the direct embroidery threads which shall conform to the specifications above.

STITCHES PER INCH: The stitches per inch shall be 7-9 for all cap operations except 5 stitches per inch on the visor.

SIZING: A sizing fiber shall be attached to the sweatband before the sweatband is installed so that the finished cap will retain its size and shape.

SIZES: One size fits all.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - RDCS-5

DESCRIPTION: Rough Duty Cap - Summer Mesh

FABRIC: Graniteville Chetopa IV, Navy Blue #80000

COLOR: Navy Blue.

STYLE: The style shall be an open mesh with adjustable headband. The official Inspections Badge patch shall be embroidered on to the front panel.

REAR PANEL: **The rear panel mesh shall be medium crisp hand 100% polyester to match the base fabric.**

FRONT PANEL: The front panel shall be constructed of one piece. The panel shall be equal to 1/3 the circumference of the cap and shall accommodate the emblem design. The panel shall be 7 1/2" wide at the visor, 4" high at the center measured from the visor to the seam and 7 1/4" long at each side. The front panel shall be laminated.

CROWN: The crown pieces shall consist of two parts. The front part shall be a one panel fabric insert with pleat with the official emblem centered on the front piece approximately 3/4" above the visor. The twill fabric must be laminated to a tricot foam. The rear part shall be a four panel nylon mesh insert, triangular in design and arched at the center rear to allow for headband adjustment. Joining seams must be taped.

BILL: The bill of the cap shall be approximately 2 5/8" at center front and approximately 4 1/2" at the side edges. It shall be rounded and interlined so that the finished thickness is approximately 3/16". The bill covering shall be firmly stitched to the lining with eight stitch lines. The visorboard shall be fiber impregnated with latex with a weight of 5 oz. and thickness of .060 inches.

VISOR: The visor and visor lining shall be twill fabric interlined with a visor stiffener and sewn with six parallel rows of 3/16" gauge stitching that follow the contour of the visor. The visor shall finish smooth without twists or pockets.

SWEATBAND: The sweatband shall finish a minimum of 1-3/8" wide and be interlined with foam sheeting. The sweatband shall not pucker, curve, arc, buckle or twist.

ADJUSTABLE HEADBAND: The adjustable headband shall be approximately 3/4" in width, black in color, and made of a durable and flexible plastic. The adjustment shall be a seven hole and peg design and the ends must be firmly attached to the sweatband and mesh inserts. The arched area at the back must be bound with black binding material.

CROWN STIFFENER: The stiffener shall be made of 100% woven nylon, Government, heavy mesh, black in color, with an open weave, bound on exposed edges. It shall be sewn to the top of the sweatband. It shall be 8 1/4" long, 3 1/4" high at the center, and 2 1/2" high at the sides tapering to the center.

CLOSING SEAMS: The visor and sweatband shall be sewn to the crown with type 301 stitch and the sweatband shall finish smooth and be flat against the side of cap. A button covered with basic material, size 22 line, shall be set into the crown at the junction of the six crown pieces.

REAR OUTLET: The rear outlet cut shall be folded under and taped down. The size adjuster shall be plastic tape to match twill material with seven holes and pins that snap together to provide a secure closure.

DIRECT EMBROIDERY: An "Immigration Inspector" Badge Patch shall be directly embroidered onto the front panel in the center. The patch shall be the shape, color and size in accordance with the figure on page 4.

The wording and patch on the front panel shall be machine embroidered on embroidery machines with automats, and shall not be produced on multi-head equipment.

The solid-stitched background field shall be a running stitch field. A blatt (or loose) stitched field will not be acceptable. There shall be no visible "corduroy" effect. A "corduroy" type field is one in which the overall appearance consists of a regular succession of stitches and spaces, similar to the regular rises and falls in corduroy fabric, and is not acceptable.

Thread color names and numbers are the applicable standard sample for shad and are contained in the DOD Standard Color Card of Official Standardized Shades for heraldic Yarns for embroidery and ribbons.

This Color Card is obtainable from the Color Association of the United States, Inc., 343 Lexington Avenue, New York, NY 10016 (Tel No. 212-683-9531.)

Thread colors and deniers, along with the necessary number of color changes are identified as follows, and shall closely match the following heraldic yarn color shades:

Description	Cable Name/No.	Rayon
Inner circle and shield	Buff HAK 67135	150/2
Shield and top eagle	Gold Mylar	100/2
Ribbons & U.S.	Midnight blue 67125	150/2
Flag, Eagle Tail Head, Lettering	White HA 67101	100/2
Outline	Midnight Blue 67125	100/2
Flag	Scarlet HL 67111	100/2
Flag	Yale Blue HCA 67176	100/2
Leaves	Prophet Green HCM 67187	100/2
Eagle	Gold Brown HCT 67194	100/2
Eagle's beak	Yellow HH 67108	100/2

Thread shall be rayon or polyester yard, finest quality, continuous filament, and colorfast, in the deniers specified above.

Besides the customary and usual understanding of an embroidery "stitch" to mean that length of thread between two needle entry points on an embroidered emblem, one stitch is further identified as that space on a shiffli embroidery program roll between the two transport holes. One meter equalling one hundred stitches.

Stitch scale shall be of sufficient density as to preclude the "bleeding" (or see through) of the background material, and uneven matting (register) of color elements. There shall be sufficient underlay stitching to give a full three-dimensional, high-relief appearance to the embroidery. No stitch may be greater than ten millimeters in length.

Double thread of any thread of different deniers of plys will not be permitted in any part of the embroidery. Single thread stitching in the deniers and plys above shall be used throughout.

THREAD: The thread shall be polyester, size 40 or cotton-cove cotton-covered polyester, size 50 color dyed to match basic material except the direct embroidery threads which shall conform to the specifications above.

STITCHES PER INCH: The stitches per inch shall be 7-9 for all cap operations except 5 stitches per inch on the visor.

SIZING: A sizing fiber shall be attached to the sweatband before the sweatband is installed so that the finished cap will retain its size and shape.

SIZES: One size fits all.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - IRTP (Male & Female)

DESCRIPTION:	LAPD Style Uniform Pant
MATERIAL:	The fabric is of 7.70 oz. 65/35 Indestructible Twill, made by Galey & Lord. Dacron wrapped thread size 30. Non-rusting metal snaps.
CONSTRUCTION:	Straight stitch length 10-12 stitches per inch. Overlock stitched leg seams. All stress points are reinforced.
FEATURES:	Two quarter front pockets. Two large pleated expando cargo pockets thighs. Large pleated cargo pockets have Velcro closure flaps. Double reinforced knees, with side pleats for easy bending. Two rear pockets with Velcro closure flaps. Fly with covered zipper. Snap at top of fly. Waist band accommodates Sam Brown Belt.
SIZES:	Waist sizes 28 through 54 - even sizes only. Also available in women's sizes 6 to 22. Comes unhemmed unless specified.
COLOR:	Black

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - IRTS (Male & Female)

DESCRIPTION:	LAPD Style Uniform Shirt
MATERIAL:	The fabric is of 7.70 oz. 65/35 Indestructible Twill, made by Galey & Lord. Dacron wrapped thread size 30. Black non-rusting metal snaps.
CONSTRUCTION:	Straight stitch length 10-12 stitches per inch. Overlock stitched arm, side seams and collar assembly. All stress points are reinforced.
FEATURES:	Two pleated expando breast pockets with flaps and Velcro closures. Pen/pencil pocket on sleeve. Pleated cuffs close with concealed snaps. Concealed zipper front closure. Concealed snaps at the top and bottom of brass zipper.
SIZES:	XS thru XXXL in regular and tall sizes.
COLORS:	Black.
NOTE:	**Inspections approved shoulder emblem, badge patch, and TDF patch will be affixed to the uniform under prescribed manner. Silk screening will be affixed to the back and will read "INS" in 5-inch letters, spaced proportionately. Color of silk-screen letters shall be non-reflective bright white.**

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - IRTJ (Unisex)

DESCRIPTION:	Waist Length Outer Jacket
FABRIC:	Milliken Style 2929, Poplin, 87% Polyester 13% cotton, DWR Finish. Black
DESIGN:	The jacket shall be a windbreaker style uniform jacket with a plain back and zipper front closure to the neck. Includes Thinsulate zip-in, zip-out liner. (spec for liner to follow.)
BODY DETAIL:	The front shall be constructed of two pieces on each side reaching from the bottom of the jacket to the shoulder seam. These two pieces shall be joined with welt stitched seams. A 1" shirring shall extend across the bottom ending 2" from the side seams to accommodate optional side zippers. The inside facing of the jacket shall extend from the bottom of the jacket continuously around the neck to the bottom of the other side in such a manner as to furnish sufficient curtain whereby a zip-in liner can be attached. The jacket shall be sewn using the serge-sew method.
SIDE PANEL POCKETS:	There shall be two side panels each with a vertical opening of 6" and they shall extend inside the jacket for a depth of 5" on the angle. The openings shall be bartacked at top and bottom for extra strength.
BREAST POCKETS:	There shall be two mitred patch and pleated pockets lined with pellon for stability. The pockets shall finish to be approximately 5-1/4" wide and 6" long with the center pleat being 1-1/4" wide. The pockets shall be attached with single needle stitching leaving a 1/4" welt along the edges. The top of the pockets shall be bartacked for extra strength.

POCKET FLAPS:	The pocket flaps shall be pointed with the center peak being 3" at the widest point. They shall be attached 1/4" above the patch pocket being attached with single needle stitching. There shall be sewn in buttonhole in the center of the flap to accommodate a 24 ligne metal button.
CUFF:	The cuffs are to be pointed with two button for cuff adjustment. The cuff is to be joined to the jacket using the serge-sew method with an outside seam welt.
COLLAR:	The collar shall be topstitched.
ZIPPER:	The jacket shall close with a nylon Camlock separating zipper with automatic lock and preshrunk tape. The color of the zipper tape shall be compatible with that of the outer goods.
THREAD:	Ball sewing is to be done with Polyester core thread or 100% Spun Polyester thread.
SIZE TAG:	Each jacket shall have a sewn in label giving care instructions and shall be marked with a lot number, size, fiber content and WPL number.
FINISHING & PRESSING:	All loose threads shall be removed. Each jacket shall be pressed and shipped properly.
ORIGIN:	Made in USA.
WARRANTY:	One year against workmanship or fabric defects.

LINER SPECIFICATIONS

FABRIC:	Face - 100% Nylon Taffeta, 104 x 86 thread count Batting - Thinsulate by 3M. Quilted 200 gram body with 150 gram sleeves. Back - 100% Nylon Taffeta, 104 x 86 thread count
DESIGN:	The liner shall be made over a full cut long sleeve liner pattern, with side vents to accommodate side zip jackets.

BODY DETAIL: The liner shall have long sleeves and knit wristlets and tab to accept anchor buttons. The entire body shall be bound with 1-9/16" Rayon bias binding. The side seams, shoulder seams and sleeve seams shall be joined with a serge-sew safety stitch machine.

POCKET: There shall be 1 lower right inside patch pocket. The pocket shall be bound with 1-9/16" Rayon bias binding and shall be attached with a single needle machine.

ZIPPER: There shall be attached to the liner an interlining molded nylon zipper, center marked, and interchangeable. The zipper shall be of sufficient length to be satisfactorily attached to the facing of the jacket.

THREAD: All sewing shall be done with polyester core or 100% spun Polyester Thread.

SIZE TAG AND CARE INSTRUCT: Each liner shall be marked with lot number, size, fiber content and WPL number. The liner shall also contain a sewn-in care instruction label.

FINISHING: All loose threads shall be removed.

ORIGIN: Made in USA.

NOTE: **Inspections approved shoulder emblem, badge patch, and TDF patch will be affixed to the uniform under prescribed manner. Silk screening will be affixed to the back and will read "INS" in 5-inch letters, spaced proportionately. Color of silk-screen letters shall be non-reflective bright white.**

ADJUSTABLE HEADBAND: The adjustable headband shall be approximately 3/4" in width, black in color, and made of a durable and flexible plastic. The adjustment shall be a seven hole and peg design and the ends must be firmly attached to the sweatband and mesh inserts. The arched area at the back must be bound with black binding material.

CROWN STIFFENER: The stiffener shall be made of 100% woven nylon, Government, heavy mesh, black in color, with an open weave, bound on exposed edges. It shall be sewn to the top of the sweatband. It shall be 8 1/4" long, 3 1/4" high at the center, and 2 1/2" high at the sides tapering to the center.

CLOSING SEAMS: The visor and sweatband shall be sewn to the crown with type 301 stitch and the sweatband shall finish smooth and be flat against the side of cap. A button covered with basic material, size 22 line, shall be set into the crown at the junction of the six crown pieces.

REAR OUTLET: The rear outlet cut shall be folded under and taped down. The size adjuster shall be plastic tape to match twill material with seven holes and pins that snap together to provide a secure closure.

BADGE PATCH: The authorized Immigration Inspector TDF Patch shall be affixed as with other ball caps in this program, centered on the front panel (Directly Embroidered).

ADJUSTABLE HEADBAND: The adjustable headband shall be approximately 3/4" in width, black in color, and made of a durable and flexible plastic. The adjustment shall be a seven hole and peg design and the ends must be firmly attached to the sweatband and mesh inserts. The arched area at the back must be bound with black binding material.

CROWN STIFFENER: The stiffener shall be made of 100% woven nylon, Government, heavy mesh, black in color, with an open weave, bound on exposed edges. It shall be sewn to the top of the sweatband. It shall be 8 1/4" long, 3 1/4" high at the center, and 2 1/2" high at the sides tapering to the center.

CLOSING SEAMS: The visor and sweatband shall be sewn to the crown with type 301 stitch and the sweatband shall finish smooth and be flat against the side of cap. A button covered with basic material, size 22 line, shall be set into the crown at the junction of the six crown pieces.

REAR OUTLET: The rear outlet cut shall be folded under and taped down. The size adjuster shall be plastic tape to match twill material with seven holes and pins that snap together to provide a secure closure.

BADGE PATCH: The authorized Immigration Inspector TDF Patch shall be affixed as with other ball caps in this program, centered on the front panel (Directly Embroidered).

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - IRTCW-5

DESCRIPTION: Standard Winter/Enclosed Ball Cap

FABRIC: Graniteville Chetopa IV

COLOR: Black

STYLE: The style shall be a full twill with an adjustable headband. The official Inspections TDF patch shall be embroidered to the front panel.

FRONT PANEL: The high front crown panel shall be constructed of one piece which shall be equal to 1/3 of the circumference of the cap. The panel shall be 7 1/2 inches wide at the visor, 4" high at the center measured from the visor to the seam and 7 1/4" long at each side. The front panel shall be laminated.

CROWN: The crown shall consist of two parts. The front part shall be a one panel fabric insert with pleat with the official emblem centered on the frontpiece approximately 3/4" above the visor. The twill fabric must be laminated to a tricot foam. The rear part shall be a four panel, triangular in design and arched at the center rear to allow for headband adjustment. Joining seams must be taped.

BILL: The bill of the cap shall be approximately 2 5/8" at center front and approximately 4 1/2" at the side edges. It shall be rounded and interlined so that the finished thickness is approximately 3/16". The bill covering shall be firmly stitched to the lining with eight stitch lines. The visorboard shall be of fiber impregnated with latex with a weight of 5 oz. and thickness of .060 inches.

VISOR: The visor and visor lining shall be twill fabric interlined with a visor stiffener and sewn with six parallel rows of 3/16" gauge stitching that follow the contour of the visor. The visor shall finish smooth without twists or pockets.

SWEATBAND: The sweatband shall be a cotton or rayon polyester blend, black in color and interlined with a moisture barrier. The sweatband shall be at least 1 1/8" wide when finished and shall be one piece, extending to the ends of the arched mesh inserts.

CROWN: The crown pieces shall be sewn together, the seam allowance pressed flat, then sewn down with 5/8" tape with stitch type 301 or 401.

CLOSING SEAMS: The visor and sweatband shall be sewn to the crown with type 301 stitch and the sweatband shall finish smooth and be flat against the side of cap. A button covered with basic material, size 22 line, shall be set into the crown at the junction of the six crown pieces.

REAR OUTLET: The rear outlet cut shall be folded under and taped down. The size adjuster shall be plastic tape to match twill material with seven holes and pins that snap together to provide a secure closure.

BADGE PATCH: The authorized Immigration Inspector TDF Patch shall be affixed as with other ball caps in this program, centered on the front panel. (Directly Embroidered)

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATIONS

#1992 - TDF

DESCRIPTION:	**TDF National Team Patches (see attachment)**
SIZE:	3 1/2 x 2 3/4"
EMBROIDERY:	50% approx. embroidery
COLOR:	#323 Dark blue cotton twill backing #334 Dark blue stitched merrow around patch #544 yellow-gold embroidery on patch
BACKING:	Cotton twill backing that is heat sealed to allow for iron on application.

NATIONAL
T.D.F.
TEAM

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - SOC-2

DESCRIPTION: SUPERVISORY OFFICER'S STANDARD CAP (male)

NOTE: Same specifications as Immigration Inspectors Standard Cap - but with embroidered gold leaf attached to bill.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - SWC-2

DESCRIPTION: SUPERVISORY OFFICER'S STANDARD WAVE CAP (female)

NOTE: Same specifications as Immigration Inspectors Standard Wave Cap - but with embroidered gold leaf attached to bill.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - LSMS-5 (long sl.)
SSMS-5 (short sl.)

DESCRIPTION: **Maternity Smock - Long and Short Sleeve**

STYLE: Long and short sleeve Maternity shirts, 10" placket front with four button closure. Front pleat starts at bottom of placket and continues to finished bottom of shirt. Long-sleeve shirt has button cuff. Dress collar with center back pleat. Short-sleeve has the finished length hemmed.

FABRIC: 65% polyester/35% cotton, Poplin, White. (FABRIC 5)

PATCH: The patch is to be sewn securely in the center of the left sleeve with top edge 1-1/2" below the shoulder seam. The patch is to be sewn with inconspicuous stitching using thread matching the emblem background color.

SIZES: S - L

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - ME-1, FE-1, ME-2, FE-2, ME-3, FE-3, ME-4, FE-4, ME-5, FE-5, ME-6, FE-6, ME-7, FE-7, ME-8, FE-8, ME-9, FE-9

IMMIGRATION INSPECTOR'S UNIFORM EPAULET

FABRIC: Fabric - 2, as stated.

DESCRIPTION: Shoulder boards or epaulet sleeves shall be of the soft military style. Pellon lining shall be utilized to ensure retention of shape and to eliminate peaking of epaulet sleeves when worn on the uniform shirt. They shall be approximately 4-1/4 inches long on center and taper from approximately 2-3/8 inches at the bottom or outside sleeve edge to approximately two inches at the top or inside edge.

Women's epaulets shall be sized proportionately with the reduced size of the uniform shirt shoulder strap.

The solid dark blue epaulet will be plain and without rank or insignia.

When required, fully embroidered military style rank insignia shall be centered approximately 1 inch from the bottom or outside sleeve edge and shall be white in color except Major which shall be yellow.

Ranks required shall be: First Lieutenant, Captain, Major, Lieutenant Colonel, Colonel, Brigadier General, and Major General.

Vanguard #AFS-R1, or equivalent.

SPEC NO.	GRADE/TITLE	DESCRIPTION
ME-1, FE-1	GS-5/7/9 TRAINEE	STANDARD EPAULET
ME-2, FE-2	GS-09 JOURNEYMAN	EPAULET W/ WHITE STRIPE
ME-3, FE-3	GS-11 NON-SUPERVISORY OFFICER	WHITE STRIPE-ONE SILVER BAR (FIRST LIEUTENANT)
ME-4, FE-4	GS-11 SUPERVISOR	WHITE STRIPE-TWO SILVER BARS (CAPTAIN)
ME-5, FE-5	GS-12 SUPV/MGR.	WHITE STRIPE - GOLD OAKLEAF CLUSTER (MAJOR)

ME-6, FE-6	GS/GM-13 SUPV/MGR.	WHITE STRIPE-SILVER OAKLEAF CLUSTER (LT. COLONEL)
ME-7, FE-7	GS/GM-14 SUPV/MGR.	WHITE STRIPE-SILVER EAGLE (COLONEL)
ME-8, FE-8	GS/GM-15 SUPV/MGR.	WHITE STRIPE-ONE SILVER STAR (BRIGADIER GENERAL)
ME-9, FE-9	ES/OO SUPV/MGR.	WHITE STRIPE-TWO SILVER STARS (MAJOR GENERAL)

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992- I-1, I-2, I-3, I-4, I-5, I-6, I-7

INSIGNIA

GENERAL: Insignia supplied shall conform in general to Military Specification MIL-I-3949D, Insignia, Rank, Officer, Metal, dated 31 December 1971, as amended and supplemented, and in specifics as stated below.

SPEC	GRADE/TITLE	MIL SPEC
I-1	GS-11 Non-Supervisory Officer	Mil-I-3949/24D-4 First Lieutenant
I-2	GS-11 Supv. Immigration Inspector	MIL-i-3949/14D-1 Captain
I-3	GS-12 Supv. Immigration Inspector	MIL-I-3949/12C-3 Major
I-4	GS/GM-13 Supervisor or Manager	MIL-I-3949/12C-1 Lieutenant Colonel
I-5	GS/GM-14 Supervisor or Manager	MIL-I-3949/11D Colonel
I-6	GS/GM-15 Supervisor or Manager	MIL-I-3949/4B-1 Brigadier General
I-7	ES Supervisor or Manager	MIL-I-3949/49-1 Major General

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -TT

IMMIGRATION INSPECTOR'S TIE TACK

SIZE: Of same size and design as the 24 ligne regulation USINS uniform button.

FEATURES: The tie tack shall be of equal appearance to the regulation button and shall utilize a gold plated back fastener and button chain. The design shall incorporate a grommet washer to prevent rotation of the tie tack.

Made from 01-13662 Waterbury guilt regulation USINS uniform button or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - FABRIC-1

DESCRIPTION:	Fabric #1
WEAVE:	Serge
WEIGHT:	17-1/2-18 ounces per linear yard on 60 inches
FIBER CONTENT:	100% Wool
PLY OF YARN:	2 ply warp and filling
BREAKING STRENGTH: (Tensile & Tear)	115 pounds in the warp 90 pounds in the filling
CONSTRUCTION:	68 ends per inch 58 picks per inch
COLOR:	Navy Raeford 8818 shade
NOTE:	Fabric must be marked on the Back Face with Mill Trademark or Kaumograph. Raeford #8250-8818 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -FABRIC-2

DESCRIPTION:	Fabric #2
WEAVE:	Serge
WEIGHT:	13-13-1/2 ounces per linear yard on 60 inches
FIBER CONTENT:	55% Dacron Polyester, 45% Wool
PLY OF YARN:	2 ply warp and filling
BREAKING STRENGTH: (Tensile & Tear)	120 pounds in the warp 100 pounds in the filling
CONSTRUCTION:	73 ends per inch 66 picks per inch
COLOR:	Navy, Raeford 8107 shade
NOTE:	Fabric must be marked on the Back Face with Mill Trademark or Kaumograph Raeford #8330-8107 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -FABRIC-3

DESCRIPTION:	Fabric #3
WEAVE:	Elastique
WEIGHT:	13-13-1/2 ounces per linear yard on 60 inches
FIBER WEIGHT:	100% texturized Dacron Polyester
PLY OF YARN:	Singles
BREAKING STRENGTH: (Tensile & Tear)	244 (15.7) pounds in the warp 212 (20.0) pounds in the filling
CONSTRUCTION:	133 ends per inch 78 picks per inch
SPECIAL FINISH:	Soil-release (Visa)
COLOR:	Dyed to match Raeford #8330-8107
NOTE:	Fabric must be marked on the Back Face with Mill Trademark or Kaumograph. Milliken #4911 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -FABRIC-4

DESCRIPTION:	Fabric #4
WEAVE:	Tropical
WEIGHT:	6.9 to 7.0 ounces per square yard, minimum.
FIBER CONTENT:	65% Polyester, 35% Avril Rayon
PLY OF YARN:	Singles
BREAKING STRENGTH: (Tensile & Tear	100 Pounds in the warp 60 Pounds in the filling
CONSTRUCTION:	49 ends per inch. 36 picks per inch
PILLING:	4.9 rating out of 5.0 Lippman #6600-101 or equivalent
COLOR:	White, Lippman 101 shade

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 -FABRIC 5

DESCRIPTION:	Fabric #5 - II Summer Poplin Shirt Fabric
FIBER CONTENT:	65% polyester, 35% cotton
COLOR:	White, Lippman 101
FINISHED WEIGHT:	4.25 oz./sq. yd.
FINISHED COUNT:	104 x 52
YARN SIZE:	Warp: 26/1 65/35 P/C Fill: 26/1 65/35 P/C
CONSTRUCTION:	Plain weave poplin
FINISHED WIDTH:	61" - 62" O.A. 60" Cuttable
TENSILE:	Warp: 130 lbs. +/- 10% Fill: 70 lbs. +/- 10%
TEAR:	Warp: 5.8 lbs. +/- 10% Fill: 4.2 lbs. +/- 10%
PILLING:	3.0
SHRINKAGE:	3%
COLORFASTNESS:	Specification for color will vary depending on individual colors.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

#1992 - FABRIC 6

DESCRIPTION:	Fabric #6 - Comfort Fiber Plain Weave
FIBER:	Warp: Hoechst-Celanese Comfort Fiber Spun Polyester 18/1 Filling: Filament 150 Denier Polyester
WEAVE:	Plain
CONSTRUCTION:	75 x 45
WIDTH:	62"/63"
WEIGHT:	6.6 - 7.1 oz./sq. yd. 11.4 oz. per 60" lin yd.
WASHFASTNESS:	4% at 120 f
TENSILE STRENGTH:	Warp: 145 lbs. Fill: 250 lbs.
TEAR:	Warp: 12 lbs. Fill: 8 lbs.
SHRINKAGE:	Warp: 2.8% Fill: .2%
ROUGHING & PILLING:	15 min. 4.0 30 min. 4.0 60 min. 3.5
COLOR:	Dark Navy Blue