



Royal Canadian Mounted Police
Gendarmerie royale du Canada

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Specification

Belt, Duty, Leather

This document has 13 pages including the drawings.

This document was created in English.

The document is available in English and French.

English/Anglais
Français/French

The photograph on this page is for reference only.



RCMP VIEWING SAMPLE

A viewing sample, when available, will be supplied to the successful tenderer.

This will be used for the guidance of the manufacturer in all factors not covered by this specification or referred to therein. Variation from the specification may appear in the sample in which case the specification shall govern.

It may be obtained from:

Royal Canadian Mounted Police
ATTN: Uniform & Equipment Program
(440 Coventry Road, Warehouse Building)
1200 Vanier Parkway
Ottawa, Ontario
K1A 0R2

It will be sent “prepaid” and is to be returned “prepaid”.

The viewing sample shall be returned to the RCMP in the same condition as received by the manufacturer. Lost or damaged viewing samples shall be replaced by an identical item or the RCMP shall be reimbursed for the cost of an acceptable replacement.

SPECIFICATION

BELT, DUTY, LEATHER

1. Definitions

- 1.1 This specification shall govern the manufacture and inspection of Belt, Duty, Leather.
- 1.2 This specification, drawing, viewing sample, or other information issued in connection therewith, may only be used for specific enquiries, tenders, or orders placed on behalf of the Royal Canadian Mounted Police.
- 1.3 This specification supersedes all previous specifications for R.C.M.P. Belt, Duty, Leather.

2. Applicable Specifications

- 2.1 The following publications are applicable to this specification and to the issues in effect on the date of the invitation to tender, unless otherwise specified.
- 2.2 ASTM D6075-13 Standard Test Method for Cracking Resistance of Leather.
- 2.3 ASTM D5053-03 [2009]. Standard Test Method for Colorfastness of Crocking of Leather
- 2.4 ASTM D2210-00 [2012]. Standard Test Method for Grain Crack and Extension of Leather by the Mullen Test
- 2.5 Federal Standard A-A-59826, Thread, Nylon.

3. General Requirements

- 3.1 The article or material covered by this specification shall be free from imperfections or blemishes such as may affect its appearance or serviceability. In all particulars not covered by this specification or contract documents, production shall be equivalent in all respects to the viewing sample.
- 3.2 **Design** - The Belt, Duty, Leather is designed to carry various types of equipment & accessories. It shall secure by means of double claw buckle closure and belt keepers.

3.3 In the event of any inconsistency in contract documents, specification, drawing, or viewing sample, the aforementioned shall prevail in the following order:

- i) Contract
- ii) Specification
- iii) Drawing
- iv) Viewing Sample

4. **Detail Requirements**

4.1 **Materials**

4.1.1 **Leather** - The leather shall be tanned from fresh or cured packer steer hides. Dry hides shall not be used. The finished leather shall be thoroughly tanned and be firm, tight fibred and mellow. Loose or pipy leather will not be accepted. The leather shall be rated 'good' when tested for crocking (ASTM 5053-03 [2009]). The leather shall show no signs of cracking when tested using a mandrel of 11 mm diameter (ASTM D6075-13). The leather grain crack index shall be 25psi minimum (ASTM D2210-00 [2012]) when RH is 65%. All leather items shall be dip dyed in a medium gloss black penetrating dye and sprayed with a black tinted acrylic protective coating for water resistance and lustre. The only exception shall be the belt lining which shall be a natural colour and finished with a coating to protect it from moisture and perspiration.

Certificate of Compliance required.

4.1.2 **Thread** - The thread shall be twisted multifilament bonded nylon, left twist, tex 135, Type II, Class A, size FF, with a minimum breaking strength of 17.5 pounds in accordance with U.S. government standard A-A-59826 , black in color. Bonded polyester may be substituted for nylon provided the other general performance requirements are met.

Certificate of Compliance required.

4.1.3 **Hardware** - The hardware shall consist of the following components;

1. Buckle, double prong; solid brass or bronze, gold plated.
2. Hook, buckle, double prong, with stem; mild steel, black anodized and/or surface hardened.
3. Stud, mild steel, black anodized and/or surface hardened.

Certificate of Compliance required.

- 4.2 **Size and Dimensions** - Belt, Duty, Leather to this specification shall be supplied in the sizes specified by the R.C.M.P. and to the dimensions given in the attached drawings, forming part of this specification and the viewing sample.
- 4.3 **Construction**
- 4.3.1 **Stitching** - The loose thread ends shall be trimmed off close to the leather. Burning or ‘flaming off’ the thread ends will not be permitted. The beginning and ending of all stitching shall be securely backstitch tacked unless secured by other stitching. There shall be not less than two nor more than three stitches per centimetre. Care shall be taken to ensure the leather is not ‘cut’ by excessively tight and/or ‘dense’ stitching (i.e. high stitch count). The stitch used shall be a lock-stitch using the thread specified in para. 4.1.2 above.
- 4.3.2 **Cutting** - The component leather parts of the Belt, Duty, shall be cut from the leather specified in para. 4.1.1. The belt shall be cut parallel to the backbone of the “back”. The pattern dimensions for all components shall be strictly in accordance with the applicable drawings. Care shall be taken to see that the best part of the leather is cut into the belt. Loose or pipy leather will not be accepted.
- 4.3.3 **Stud Hole Relief** - The holes shall have a diameter of 6 mm and an unskived slot 12 mm. Note: The specified stud hole diameter is intended for a stud with a head of diameter 6.7 mm. Studs with larger diameter heads if found acceptable to the RCMP will require a correspondingly larger stud hole.
- 4.3.4 **Sealing** - All open flesh parts of the leather shall be viewing with “Super Clear Lacquer”.
- 4.3.5 **Bevelling** - The belt shall be bevelled on both edges and both sides with a bevel of 1 mm in width with a plus tolerance of 0.5 mm.
- 4.3.6 **Edge Finishing** - All edges, including the keepers, shall be stained and filled with a wax type of matching black edging ink and then burnished to a solid smooth and durable edge. Lacquer or varnish type edge finishes shall not be used.
- 4.3.7 **Size** - The size of the belt shall be as specified in the contract and shall be the distance from the inside of the claw to the third double buckle prong holes, as illustrated in the drawing. The finished belt shall extend 190 mm beyond the third double prong holes for all sizes. There shall be five double prong holes spaced 29 mm apart, from centre to centre.

4.3.8 **Construction Details** - The belt shall be constructed of the leather specified in para. 4.1.1. The outer layer shall be top grain russet cowhide 2.8 to 3.0 mm thick. The middle layer may be chrome or vegetable tanned, shall be 1.5 to 1.7 mm thick and shall extend from just before the stud to 40 mm before the first pair of prong holes. The lining shall be full length and 1.7 to 1.9 mm thick. The layers of the belt shall be glued in place and then stitched together. Belt width shall be 57 mm (2 1/4"). The double claw piece shall be inserted in the opposite end to the tongue between two layers of leather, secured by one row of stitching through the body of the belt. The belt must close properly and effectively without any misalignment of the double prong buckle and the stud hole. There shall be a hanging hook hole at the claw end of the belt cut into the leather, 1 cm diameter, as per Dwg. 1. The belt and all components used in its construction shall function correctly and appropriately for the purpose for which they were made.

Note: The finished belt shall have a combined thickness of 6.0 to 6.6 mm in the three layer portion and 4.5 to 4.9 mm in the two layer portion, which extends from the tip to just past the last set of prong holes, to ensure sufficient rigidity and stiffness to support holsters and accessories.

4.3.9 **Keeper, Belt, Sliding** – Each Belt, Duty, Leather shall have a sliding belt keeper which shall be constructed of the material listed in para. 4.1.1. The leather shall be not less than 3 mm thick. The loop shall be 20 mm (3/4") wide and equal in all respect to the viewing sample.

4.3.10 **Finish** - The Belt, Duty, Leather shall have an embossed pattern known as ‘basket weave’, as per the viewing sample.

4.3.11 **Marking** - The size of the belt in inches and centimetres, the manufacturer’s identification, the date of manufacture (YYYY/MM/DD) and the appropriate RCMP stock number (as stipulated in the contract) shall be legibly stamped on the grain side at the claw end of the belt or otherwise indicated such as by a permanent label affixed by stitching to the body side of the belt.

5. **Delivery, Packing and Marking of Containers**

5.1 Unless otherwise specified the items shall be delivered to the Commissioner, RCMP, Uniform & Equipment Program, Ottawa, Ontario, free of transportation charges, provincial tax and federal tax where applicable.

5.2 Packing and marking of shipping containers shall be as specified in the invitation to tender.

5.3 A packing slip shall be enclosed showing contents of each shipment.

6. **Quality Assurance Provisions**

6.1 **Responsibility for Inspection** - Unless otherwise stipulated in the contract, it is the prime contractor's responsibility to satisfy the RCMP, Uniform & Equipment Program that the material and services being supplied conform to this specification. This may be accomplished by performing the tests specified in this specification or by demonstrating to the satisfaction of the RCMP, Uniform & Equipment Program that conformity to this specification of manufacturing processes is assured. The contractor may use his own facilities or any commercial testing establishment acceptable to the RCMP, Uniform & Equipment Program.

6.2 The RCMP, Uniform & Equipment Program reserves the right to perform any inspection considered necessary to ensure the material and services conform to the specified requirements. For the purpose of inspection, a portion of each delivery not exceeding two percent may be put to tests that could destroy the articles. If found to be inferior or not in accordance with this specification, all articles so destroyed shall be replaced by others of proper quality and pattern at the expense of the contractor. The entire delivery may also be rejected if it is found that articles previously rejected due to non-repairable defects are redelivered for inspection.

6.3 The contractor will be promptly notified when any articles are not accepted and such articles will be returned at the contractor's risk and expense.

Appendix 'A'

Certification of Compliance & Test Data

Appendix A contains definitions of compliance and certification requirements for all materials specified in this document. These definitions shall be used by RCMP Uniform & Equipment Program Section to ensure all documentation is received and meets the requirements outlined in this specification.

Definitions:

Certification of compliance: Compliance certification documents shall be based on testing from a raw goods manufacturer, from an in-house or independent, third-party accredited laboratory acceptable to the RCMP to verify performance requirements as specified in this specification, or, where indicated, an invoice from the raw good manufacturer is also acceptable.

Test Report: Test report documents shall include the test method, test conditions and test results performed by a laboratory or test facility acceptable to the RCMP to verify requirements as specified in this specification.

All certificates and test reports that verify the performance of materials used in manufacturing the finished item shall be retained by the manufacturer and shall be made available to ensure that all items meeting the requirements have completed all of the testing and certification required by this specification. Failure to provide the requested documentation shall be cause for rejection. Failure to meet the requirements when tested by the RCMP Uniform & Equipment Program Section shall be cause for rejection.