



Royal Canadian Mounted Police
Gendarmerie royale du Canada

Doc. no: G.S. 1045-92
Date: 2013-09-16

Specification

Boots, Congress, Male & Female

This document has 19 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

BOOTS, CONGRESS, MALE AND FEMALE

1. Definition

- 1.1 This specification shall govern the manufacture and inspection of Boots, Congress, Male and Female.
- 1.2 This specification, viewing sample, drawing 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. Boots, Congress, Male and Female.

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 CAN/CGSB 4.2 Textile Test Methods.
- 2.3 A-A-509826, Thread, Nylon.
- 2.5 ASTM, American Society for Testing and Materials, Method D2807, D2810, D2617, D4705 and D2211.
- 2.7 FED-STD 311-7011.1, Federal Standard, Textile Test Methods.

3. General Requirements

- 3.1 The article or material covered by this specification shall be free from imperfections or blemishes that 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** - Boots, Congress shall be constructed of black calfskin uppers, leather soles, heel bases and top lifts, and elastic gore sides. They shall conform in all respects to the viewing sample.

- 3.3 **Manufacture** - The boots shall be made on lasts the same as the viewing sample or equivalent, by what is known as the Goodyear Welt Process. Last #436 has been found suitable for female Congress Boots. Each pair shall have matching components similar in weight and quality. The boots shall be available in both male and female boot sizing.
- 3.4 **Basic Dimensions** - The height of the upper shall be 14cm with a plus tolerance of 3mm, when measured from the heel seat at the back after lasting for size 8D Male Congress. All other sizes and widths shall be in correct proportion.
- 3.5 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 **Vamps** - The vamps shall be cut from high quality black chrome-tanned Calfskin leather from the best portion of the butt, as per Table III. It shall have a minimum thickness of 1.3 mm and a maximum of 1.6mm. It shall be free from open or healed-over scratches and grub damage.

Certification of compliance must be provided.

- 4.1.2 **Quarters** - The quarters shall be cut adjacent to the vamp area specified in 4.1.1 and from parts of the shoulder that are not hinged and are free from excessive fat wrinkles. Light, well healed over scratches that do not affect the serviceability or seriously affect the appearance will be accepted. The quarters shall have a minimum thickness of 1.2 mm and a maximum of 1.6 mm.

Certification of compliance must be provided.

- 4.1.3 **Quarter Linings** - The quarters linings shall be vegetable or chrome vegetable retanned leather cut from cowhides, taken from the sides, shoulders or bellies. It shall be grey or beige in colour. No stretchy, spongy or hard bony linings will be accepted. Linings with light, well healed-over scratches and grub holes will be

accepted provided they do not affect the wear or seriously affect the appearance. They shall have a minimum thickness of 1mm and a maximum of 1.2 mm.

Certification of compliance must be provided.

- 4.1.4 **Vamp Linings** - The vamp linings shall be vegetable or chrome vegetable retanned leather cut from cowhides, taken from the sides, shoulders or bellies. It shall be 1.0 to 1.2 mm thick, natural or light russet in colour. English kip lining has been found satisfactory.

Certification of compliance must be provided.

4.1.5 **Counters**

- 4.1.5.1 **Material** - Material for counters shall be reconstituted leather fibre sheet, made only of leather fibres bound with suitable binders, between 2.54 and 2.79 mm thick, and between 0.85 and 1.0g/m³ in density. The finished sheet shall be smooth and shall meet the requirements in Table I.

Table I

Property	Minimum	Maximum	Test Method
Bursting Strength (Dry)	2652.55 kPa	---	CAN 2-4.2
Bursting Strength (Wet)	2135.9 kPa	---	CAN 2-4.2
Tensile Strength (Wet)	4895 N	---	CAN 2-4.2

Other materials may be considered provided they meet with the approval of the RCMP. Counters shall not bulge or cause a warping of the quarters along their forward edges.

- 4.1.5.2 **Moulding** - The counters shall be properly skived and moulded on left and right moulds, which shall correspond closely in shape and design to the heel portion of the lasts. The counters shall be available in all sizes and widths.

- 4.1.6 **Welting** - The welting leather shall be first quality squared double shoulder leather of welting tannage. It shall be firm but flexible, with no soft, spongy or loose fibred leather accepted. No hide or mechanical defects shall be allowed. It shall have a minimum width of 12.7mm and a thickness of between 3.2 mm and 3.4 mm.

- 4.1.7 **Bottom Filler** - The filler shall be a granulated cork bonded by a waterproof and thermo-setting binder which is free from any material subject to rapid deterioration with age. Thermoplastic binders shall not be less than 50 kg/m^3 nor more than 52 kg/m^3 . The filler shall be compatible with the specified soling adhesive and shall not stain nor bunch and shall retain flexibility throughout the life of the boot. The cantilever movement between the filler surface and the outsole shall not cause squeaking.
- 4.1.8 **Heel seat Lift** - The lift shall be a good commercial quality, cut from leather.
- 4.1.9 **Box Toes** - The box toes shall be cut from a styrene-butadiene box toe material. The material shall be a laminate. The material used in forming the laminate shall consist of a single ply, double napped (napped both sides) unbleached cotton having an approximate average weight of 248 g/m^2 . The napping must be continuous and even to allow a finished thickness of not less than 1.4 mm nor more than 1.5 mm in the inactivated state, when impregnated with a dry load of styrene of 522g plus or minus 10 percent. No fillers shall be added to the styrene. Other materials acceptable to the RCMP may be substituted. The box toes shall be skived to a feather edge across the front with a 13 mm scarf. After lasting, the box toe shall be 6.5 cm, $\pm 1.5 \text{ mm}$ in length for a male size 8 boot. For all other boot sizes the box toe length increments shall increase or decrease by 1.5 mm per full size, measured with a tape around the curve of the toe, from the welt, after lasting.
- 4.1.10 **Shanks** - The shanks shall be made of high-carbon, cold-rolled strip steel, sound and free from roughness, pitting, blisters, limitations, surface defects or edge cracks. The shank shall be appropriately curved to fit the bottom of any designated last. The surface shall be suitably plated with a rust-inhibiting bright zinc (or other suitable material) coating. The shanks may be covered with a tape material to reduce the possibility of squeaking.
- 4.1.11 **Spur Boxes** - Spur boxes are to be purchased from the R.C.M.P.
- 4.1.12 **Pull Tabs** - The pull tabs shall be cut from No. 1 quality woven tape, black in colour, equivalent in all respects to the viewing sample. The tabs shall be 22-25 mm wide and 4 cm long when attached to the finished butt, in accordance with the viewing sample.
- 4.1.13 **Gore Fabric** - The gore fabric shall be cut from high quality woven elastic fabric, black in colour equivalent in all respects to the viewing sample. The elastic fabric

shall stretch at least 60 percent of its normal unstretched length to permit the boot to be pulled on and off the wearer's foot.

- 4.1.14 **Insoles** - The insoles shall be cut from combination tanned (vegetable tanning followed by chrome retannage, or chrome tanning followed by vegetable retannage) bends or shoulders of cowhides. The leather shall be mellow and of medium-tight fibres. Loose or pipy leather will not be acceptable. The grain surface and all loose flesh shall be carefully removed by the use of a "Summit" or other similar splitting machine. The removal of the grain or flesh by equipment employing sandpaper or wire brushes shall not be permitted. The degrained and fleshed insoles shall be firm, free of open grub holes or cuts and shall have a minimum thickness of 3.2 mm and a maximum of 3.7 mm.

Certification of compliance must be provided.

- 4.1.15 **Outsoles** - The outsoles shall be cut from first quality bends. The leather shall be full grain (not buffed or snuffed) and free from imperfections or blemishes that may affect its appearance or serviceability. The leather shall be soft smooth and pliable. After all excess flesh has been removed and the outsoles are evened, they shall have a minimum thickness of 5.8mm and a maximum of 6.3 mm. Outsoles graded as "Number One Scratch" will be accepted.

Certification of compliance must be provided.

Note: The term "Number One Scratch" denotes a grade of leather that may include grain damage such as healed wire scratches, medium fat wrinkles (not hinged), light healed-over brands and shallow flesh cuts in the shank and under the heel, minor grain blemishes, and soles with some stain or wild grain defects that will not affect the wearing quality of the leather, but shall not include "Butty" toes, soft spots or open grub holes.

- 4.1.16 **Heels** - The heel base shall be built up with firm whole lifts. The leather shall be full grain (not buffed or snuffed) and free from imperfections or blemishes that may affect its appearance or serviceability. The leather shall be soft smooth and pliable. After all excess flesh is removed, each lift shall have a minimum thickness of 3.2mm. The grain side of the rand and the lifts may be lightly scoured with a rough sand paper to obtain maximum adhesion after gluing and compression. The rand shall be 2cm in width, and 2.1 to 2.38mm in thickness. The rand shall be taper skived, across the full width, to a thin edge at the inside part. No soft or spongy lifts or rands shall be used. The lifts and rands shall be glued together with a water-resistant glue and then compressed tightly together with the use of molds and compressing equipment. The heel base shall be gouged

out at the breast to give what is known as a "Full Cup". The compressed heel base when combined with the lift shall be of sufficient height at the heel breast and heel to cause the boot tread correctly. The heel base shall be of sufficient length and width to provide the specified extension in the finished boot.

Certification of compliance must be provided.

4.1.17 **Rubber Toplift** - The rubber toplift shall be black rubber equal in all respects to the viewing sample, 6mm in thickness. The toplift may alternatively be the kind that has pre-located holes in place with washers inside used to secure nails in place during the heel attachment process.

4.1.18 **Heel-Pads** - The heel-pads shall be cut from leather specified in Para. 4.1.3.

4.1.19 **Nails**

4.1.19.1 **Heel base Attaching** - The heel base attaching shall be steel, half-rough type of sufficient length to burr securely and smoothly on the insole.

4.1.19.2 **Heel seat** - The heel seat nails shall be brass, loose type. Nails shall be of sufficient length to clinch firmly and smoothly on the inner sole.

4.1.20 **Thread**

4.1.20.1 **Upper** - All upper stitching shall be done with Class A, Type II, size "E" bonded nylon thread (top and bottom) in accordance with specification A-A-59826. The thread colour shall be black.

Certification of compliance must be provided.

4.1.20.2 **Welting** - The welting shall be sewn with Class A, Type I, Size 8 (Tex 600) soft filament nylon in accordance with specification A-A-59826.

Certification of compliance must be provided.

4.1.20.3 **Sole Stitching** - The stitching shall be done with Type II, Class B, size 6 (Tex 400) in accordance with specification A-A-59826.

Certification of compliance must be provided.

4.2 **Construction**

4.2.1 **Cutting Uppers** - The uppers shall be cut from the leather specified in Para. 4.1.1. No open scratches, hard, bony or flanky leather will be accepted. The two

portions of the vamps shall be free from all damage. Leather with light, well-healed-over damage that does not affect serviceability or appearance will be accepted in the rest of the upper.

- 4.2.2 **Skiving** - All the upper parts shall be skived on the flesh side with a straight taper skive 5 mm in width. The top edges shall be skived, cemented and turned in with a fold that is not less than 4 mm or more than 5 mm. All seams in the finished boot shall be smooth and serviceable.
- 4.2.3 **Size Marking of Uppers** - The size and width of the boot (e.g. 8E Male) shall be inscribed on the top inside at the front. The letters or numerals shall be at least 6mm in height.
- 4.2.4 **Upper Fitting** - All upper stitching shall be lockstitch using the thread specified in Para. 4.1.20.1. The lock shall be positioned approximately three quarters from the surface: not less than four nor more than five stitches per centimetre shall be used. The loose ends of all upper stitchings are to be trimmed off with the use of scissors or knife. Burning or 'flaming' off the loose ends will be permitted providing no damage occurs to upper leather. The needles used shall be the smallest size possible.
- 4.2.4.1 **Vamp and Quarter Doublers** - The vamp and quarter doublers shall be cut from material specified in Para. 4.1.4. They shall be cemented smoothly to the flesh side of the vamps and quarters.
- 4.2.4.2 **Quarters** - The quarters shall be butted and seamed at the front and back on a zigzag machine - three to four stitches per centimetre shall be used. The seams shall be rubbed out flat. After lasting, the quarters shall show no gaping.
- 4.2.4.3 **Elastic Gore Fabric** - The fabric shall be place between the quarter and quarter lining and caught by two rows of stitching spaced 1.5 mm apart, with the first row spaced not more than 1.5 mm from the edge.
- 4.2.4.4 **Quarter Lining and Backstrap** - The three-piece leather quarter lining shall serve as a counter-pocket as well as an inside backstay. The two back pieces shall be sewn together and, with the seam rubbed out flat, stitched along each edge with one row of stitching. The front edges of the joined back pieces shall be butted to the back edges of the front piece, and seamed on a zig-zag machine. These seams shall be placed on the inside of each boot directly in line with the outside seams joining the vamps and quarters, using three to four stitches per centimetre. The

seams shall be rubbed out flat. The top of the back and front portions of the lining shall be sewn to the top of the vamps and quarters by one row of stitching placed 2mm from the top edges. The latter stitching shall secure the pull tabs, which are inserted between the lining and the vamp or quarters as in the viewing sample. The backstrap shall be stitched to the back of the quarters by two rows of stitching on each vertical edge and across the top, spaced 1.5 mm apart, with the first row not more than 1.5mm from the edges of the backstrap.

- 4.2.4.5 **Vamps** - With the vamp overlapping the quarters, the two shall be stitched together with two rows of stitching starting and stopping at the bottom of the vamps. The rows shall be spaced 1.5 mm apart, with the first row spaced not more than 1.5 mm from the edge of the vamps.
- 4.2.4.6 **Vamp Lining** - The vamp lining shall be stitched with the quarter lining overlapping it 1 cm and shall be sewn together with two rows of stitching spaced 1.5 mm apart.
- 4.2.5 **Counters** - The counters specified in Para. 4.1.5, shall be dipped in latex counter paste just prior to assembling. The appropriate size of counter to fit the designated upper shall be used. Counters shall be caught with not less than two welting stitches in each wing.
- 4.2.6 **Box Toe** - The box toe specified in Para. 4.1.9, shall be positioned between the vamp lining and the doubler in such a way that it will meet the length requirement of the finished boot. The bottom edge of the box toe shall be fully caught by the welting stitches.
- 4.2.7 **Shaft Marking** - The shaft of the boot shall have the following inscribed on the inside:
- Size
 - Width of Boot
 - Manufacturer's Name
 - Year of manufacture (Numeric form)
 - Letters RCMP-GRC

These markings are to endure for the life of the shoe. Alternatively, the manufacturer may insert a permanently-marked, durable label to be captured in the quarter lining stitching in a position visible to the wearer with the following information:

- Size
- Width of Boot
- Manufacturer's Name
- Year of manufacture (Numeric form)

- 4.2.8 **Lasting** - Lasts shall be "picked" in the correct sizes and widths in accordance with the sizes and widths of the uppers. Insoles shall be evenly tacked to the lasts with one tack at the toe, two at the ball, and one in the shank and heel. The uppers shall be lasted 14 mm, \pm 1.5 mm over and all around the heel seat. The heels and toes shall be smoothly, firmly and evenly wiped in against the shoulder of the insole. The uppers shall be pulled down tight to the lasts. The back seams shall be straight. Lasts shall not be pulled until after edge and heel finishing operations are completed. Boots shall remain on the lasts until completely dry, and for at least six days, unless a heat setting machine acceptable to the inspecting authority is being used.
- 4.2.9 **Welting** - The welting specified in Para. 4.1.6 shall be sewn level and close to the shoulder of the channel with the welt thread specified in 4.1.20.2, positioned at the root of the shoulders. Dropped or broken stitches, broken or torn channel lips will not be accepted. There shall be not more than one joint in the welting for each boot. Tension on the stitches shall be tight. There shall be not less than one nor more than 1.5 per centimetre. The ends of the welt shall be trimmed with a 15 mm, \pm 1.5 mm bevel, pulled in, tacked down and pounded. The welt shall be beaten out while in temper.
- 4.2.10 **Removal of Tacks** - All lasting tacks shall be removed following the welting operation.
- 4.2.11 **Inseam Trimming** - The excess part of the upper and insole shoulder shall be trimmed off. Care should be taken not to trim too close to the welting stitches.
- 4.2.12 **Shanks** - The shanks shall be as specified in 4.1.10. They shall be tacked to the insole with two tacks, under the heel, in such a position that the shank shall not extend too far forward and interfere with the tread across the ball. Alternatively, the shanks may be set in position using a suitable thermoplastic adhesive. The fitting for male Congress Boots shall be as the table below:

Table II

SHANK LENGTH (cm)	MALE SHOE SIZE	WIDTHS
10	7 – 7 ½	ALL WIDTHS
11	8 - 9	
11.5	9½ – 10 ½	
12	11 - 12	
12.5	12 ½ and up	

Shank length for female Congress Boots shall be appropriate for the required size, as determined by the manufacturer.

- 4.2.13 **Bottom Filler** - The bottom filler shall be as specified in 4.1.7. The filler shall be applied by heat and mechanical pressure to ensure level and uniform bottoms. The bottoms including the open space in the heel seat, shall be completely filled.
- 4.2.14 **Sole Laying** - The outsole specified in Para. 4.1.15 shall be fully scoured on a rapidly revolving steel wire brush. The steel wire bristles in the brush shall have a diameter of 3 mm, \pm 0.025 mm. The outsole shall be cemented and laid with the aid of a sole laying machine using correct pressure and suitable shaped pads. The use of temporary tacks or nails while sole rounding and stitching is not permitted.
- 4.2.15 **Rough Rounding** - The edges of the sole and welt shall be rounded on a rough rounding machine to provide the required extension for edge trimming.
- 4.2.16 **Sole Stitching** - The outsole shall be stitched to the welt by lockstitch in a groove on the outsole. The thread specified in Para. 4.1.20.3 shall be thoroughly coated with hot wax and be sewn using a needle and awl of the smallest combination for the specified threads. The number of stitches shall be not less than 2.5 nor more 2.75 stitches per centimetre. The lock shall be embedded in the outsole to approximately 1/3 of the depth below the surface. A tight tension shall be used on the thread. The distance between stitching and the edge shall be minimum to allow for edge trimming and shaping operations. The sole stitching shall continue to at least 1cm back of the breast of the heel. The stitches shall be neatly and lightly separated with the use of a stitch separating machine.
- 4.2.17 **Bottom Levelling** - The outsoles shall be levelled in order to conform to the shape of the bottom of the last. The seats shall be pounded down firmly and evenly.
- 4.2.18 **Heel seat Fastening** - The seats shall be nailed with brass nails as specified in 4.1.19.2 spaced 13 mm, \pm 1.5 mm apart. They shall be clinched firmly and

smoothly on the heel seat part of the insole. The fastening shall be on the outside of the lasting tacks. They are to start and stop approximately 13 mm behind the breast of the heel.

4.2.19 **Heeling**

4.2.19.1 **Heel base** - The heel base and heel part of the outsole shall be scoured with the steel wire brush used in sole laying, and cemented firmly together with the cement specified in Para. 4.1.21. Heel bases shall be attached with nine to eleven nails as specified in Para. 4.1.19.1. Alternatively, the heel base may be attached using 6 steel nails of an appropriate type through the toplift and four inside nails (with washers).

4.2.19.2 **Rubber Toplift** - The toplift specified in Para. 4.1.17 shall be securely cemented to the heel base with a suitable cement. Alternatively, the toplift may be attached with up to six steel nails of an appropriate type through the toplift and four inside nails.

4.2.19.3 **Spur Boxes** - The spur boxes shall be inserted into the centre of the back of each heel during the heeling operation and secured by two steel nails as in the viewing sample.

4.2.20 **Trimming**

4.2.20.1 **Heels** - The heels shall be trimmed to form a heel shaped as in the viewing sample. The heel seat shall be trimmed with not more than 1.5mm extension all around. The heel breast shall be curved as in the viewing sample. Heels shall not be under seated and shall tread flat.

4.2.20.2 **Sole Edges** - Boots shall be trimmed in pairs, square around the forepart and shank. Edges shall have the following extensions, measured at right angles to the upper; 6 mm at outside ball, gradually decreasing to 5 mm at end of toe and inside ball. Edges shall be smoothly trimmed with a correct size cutter. No ragged or wavy edges will be accepted.

4.2.21 **Finishing**

4.2.21.1 **Sole Edges** - The sole edges shall be filled with best quality filler and set up with a hot oscillating iron the same size and shape as the edge trimming cutter. The edges shall then be inked in with best quality edging ink, and set up again with the

same iron to produce a solid, smooth edge that shall then be padded and brushed to a bright finish.

- 4.2.21.2 **Heels** - The heels shall be scoured with two scouring operations, using a fine Grit (No. 120) paper in the second scouring operations, and then stained black. Heels shall be hot waxed, padded and brushed to a bright finish, then wheeled and brushed again. The heel breast shall be scoured with one paper, using no stain.
- 4.2.21.3 **Bottoms** - The outsole bottoms shall be clean and free from stains. They shall not be buffed, painted or stained. After cleaning, the bottoms shall be brushed. The size and width shall be inscribed on the outsole near the heel breast. Alternatively, if size and width is indicated suitably elsewhere on the boot, bottom marking may be omitted.
- 4.2.21.4 **Insoles** - All tacks or nails shall be smoothly clinched and there will be no roughness to the hand when examined.
- 4.2.21.5 **Upper Finishing** - Uppers shall be thoroughly cleaned, then dressed with one coat of semi-bright dressing. No filler shall be used on the uppers.
- 4.2.21.6 **Sole Stitching** - Sole stitches shall be inked in black on the welt side. The welt and stitches shall be cleaned and brushed.
- 4.2.22 **Heel Pads** - The heel pads shall be cut from the leather specified in Para. 4.1.3. They shall be skived at the breast with a 1 cm straight taper skive. The heel pad shall be at least 4 cm in length from the centre of the breast to the back for a size 8 boot.

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

- 5.1 Unless otherwise specified the items shall be delivered to the Commissioner, R.C.M.P., Uniform & Equipment Program, Ottawa, Ontario, free of transportation charges, Provincial 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 R.C.M.P., 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 R.C.M.P., Uniform & Equipment Program that conformity to this specification of manufacturing processes is assured. The contractor may use any commercial testing establishment acceptable to the R.C.M.P., Uniform & Equipment Program.
- 6.2 The R.C.M.P., 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 or two out of any number delivered under 100 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.

TABLE III
Upper, Calfskin, Chrome Tanned

CHEMICAL REQUIREMENTS	MINIMUM	MAXIMUM	ACCEPTABLE TESTED METHODS
Chloroform extract, Average (%)	3.5	6	ALCA B4
Chromic Oxide (Cr ₂ O ₃) percent	4.0		ASTM D2807
Acidity (pH)	3.5		ASTM D2810
Total Ash %		8.5	ASTM D2617
PHYSICAL REQUIREMENTS	MINIMUM	MAXIMUM	ACCEPTABLE TESTED METHODS
Shrinkage Temperature, average (degrees Celsius)	100°C		FED STD 311 Method 7011.1
Mullen Burst Strength, average (lbs/sq. in.)	350		CAN/CGSB-4.2 method 11.1
Stitch Tear Strength based on 4½ - 5 oz. leather, average (lbs.)	40		ASTM D4705
Elongation at 2000 psi		50%	ASTM D2211

Inspection for Defects

CLASS OF DEFECT	ACCEPTABLE	NOT ACCEPTABLE
Fibre Quality	Tight Fibre	Loose Fibre
Brands	Not acceptable	Not acceptable
Fat wrinkles	Medium wrinkles	Heavy wrinkles
Ticks and Fly bites	Minor scars and bites	Severe scars or bites
Grain Damage	Slight grain damage	Deep grain cuts, or extensive grain damage
Appearance (Salt Stains, Iron Stains, Unremoved hair and discolouration)	Good Appearance	Salt or iron stains, unremoved hair or serious discolouration
Slaughter cuts	Slight slaughter cuts	Deep slaughter cuts
Fleshiness	Clear	Excessively fleshy

APPENDIX A

Certification & Evaluation Criteria

Appendix A contains definitions of compliance and certification requirements for all materials specified in this document. The evaluation criteria is a reference list and shall be used by RCMP Uniform & Equipment Program 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 supplier is also acceptable.

Test Report: Test report documents shall include the test method, test conditions and test results performed by an independent, third-party accredited laboratory 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 shall be cause for rejection.

Para. Title/Test	Certification of Compliance
Leather Material (Para. 4.1.1- 4.1.4)	Required
Insoles (Para. 4.1.14)	Required
Outsoles (Para. 4.1.15)	Required
Heels (Para. 4.1.16)	Required
Thread (Para. 4.1.20.1, 4.1.20.2 & 4.1.20.3)	Required