



Royal Canadian Mounted Police
Gendarmerie Royale du Canada

Doc. no: G.S. 1045-181
Date: 2013-12-06

Specification

Cap, Baseball

This document has 15 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 and 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

CAP, BASEBALL STYLE

1. Definitions

- 1.1 This specification shall govern the manufacture and inspection of Cap, Baseball Style.
- 1.2 This specification, pattern, 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 Cap, Baseball Style.

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 CGSB, CAN 2-4.2, Textile Test Methods.
- 2.3 CAN/CGSB 4.131-93, Thread, Polyester.
- 2.4 R.C.M.P., G.S.1045-284, Cloth, Twill, Poly/Cotton.

3. General Requirements

- 3.1 The article or material covered by this specification must 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 must be equivalent in all respects to the viewing sample.
- 3.2 **Design** - The design will be a baseball style cap, available in two sizes, Small/Medium (S/M) and Large/Extra Large (L/XL). The caps shall be designed in accordance with the drawings attached and forming part of this specification and the viewing sample. They will be available in three different types as outlined in the table below:

Type	Fabric/Fabric Colour	Embroidered Letters & Yarn colour
I – Police	Dark Navy Blue poly/cotton	RCMP/POLICE/GRC (grey)
II – ERT	Black poly/cotton	RCMP/POLICE/GRC (grey)
III – Chaplain	Dark Navy Blue poly/cotton	RCMP/CHAPLAIN AUMÔNIER/GRC (yellow)
IV - Cadet	Dark Navy Blue poly/cotton	N/A

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

- (i) Contract
- (ii) Specification
- (iii) Drawing
- (iv) Viewing sample

4. **Detail Requirements**

4.1 **Material Requirements**

4.1.1 **Shell Fabric** - The shell fabric for Type I, III, and IV must be Cloth, Twill, Poly/Cotton dark navy blue in colour, as per Para. 2.4 above; for Type II caps, must be Cloth, 65% polyester/ 35% cotton, black in colour, as per Table I.

Note: Fabric for Types I, III and IV shall be purchased from the R.C.M.P.

Fabric for Type II shall be supplied by the manufacturer. Certification of compliance shall be provided from the known supplier in Table I or a test report for an alternate material meeting all criteria in Table I must be provided.

4.1.2 **Peak Stiffener** - The stiffener must be made from a highly purified, medium density, water resistant alpha-cellulose vegetable fibreboard, impregnated with approximately 32% of compounded neoprene. The thickness must be 2.5 mm.

Note: Material known in the trade as "Texon" has been found to be acceptable. Other materials shall be considered acceptable if equal in performance characteristics to the viewing sample.

- 4.1.3 **Sweatband Lining** - Must be a lightweight non-woven fabric, black in colour, equal to viewing sample.
- 4.1.4 **Seam Tape and Seam Binding** - The tape and binding material must be made from rayon twill lining, 92 g/m², dark navy blue for Types I, III, IV and black for Type II caps. Colour fastness to perspiration must be no less than grey scale 4, when tested in accordance with CAN/CGSB 4.2 Method 23-M90 (2004).
Certification of compliance must be provided.
- 4.1.5 **Sweatband Stiffener** - Must be a stiff plastic material, 7 mm wide, equal in all respects to the viewing sample.
- 4.1.6 **Front Crown Lining** - As per viewing sample.
- 4.1.7 **Thread** – The thread must be polyester wrap, polyester core, Tex 40, Class B of matching colour, meeting CAN/CGSB 4.131-93.
Certification of compliance must be provided.
- 4.1.8 **Embroidery Thread** - The embroidery thread used for the front crown embroidery on all cap types must be viscose rayon, Schiffli twist, bright finish. The linear density and ply must be either 110 dtex/2 or 167 dtex/2. The use of polyester in lieu of rayon is permitted with the stipulation that the linear density and ply must be 99 dtex/2 or 148dtex/2. The colour must be as per viewing sample. The thread must be colour fast to grey scale 4 when tested to colourfastness to light, laundering, perspiration and dry cleaning. See Dwgs 1 & 2 for wording details.
- 4.1.9 **Elastic** - The elastic to be used for the size adjustment strap must be non-roll, pre-shrunk, with a knitted or woven construction. It must be 25mm (1"). The elastic must have elongation of 125%. The elastic used must be equal in respect to the viewing sample for durability requirements.
Certification of compliance must be provided.
- 4.2 **Dimensions** - The Cap, Baseball Style must be dimensioned in accordance with the drawing and viewing sample and subject to a tolerance of ± 5 mm for the diameter of the headband.

4.3 **Construction**

- 4.3.1 **Stitching** - All stitching must be lockstitch. There must be not less than three nor more than five stitches per centimetre. The beginning and ending of all stitching must be securely backstitch tacked unless secured by other stitching.
- 4.3.2 **Crown** - Of the material specified in Para. 4.1.1 with the front portion lined with the material specified in Para. 4.1.6 (to be laminated or cemented), the crown must be in six sections: The two back sections must be cut-out as shown in the drawing and viewing sample to accommodate the size adjustment strap. The six sections must be seamed together and the seams pressed open. The seams on the inside must be covered with tape specified in Para. 4.1.4. The taping must be done with a double edge folder using a two needle machine with the needles set 10 to 13 mm apart. The length of the seam must be 16 cm from the point where the seams converge to the finished bottom. The edge of the cut-out portion at the back must be bound with bias cut material specified in Para. 4.1.4 and the folded edges of the binding stitched 1.5 mm gauge. An eyelet must be sewn in each section as shown in the drawing and viewing sample with thread specified in Para. 4.1.7 or as considered appropriate for this purpose
- 4.3.3 **Headband Stiffener** - A piece of plastic stiffener specified in Para. 4.1.5, 7 mm in width, must be stitched to the inside bottom edge of the cap 6 mm gauge. The stiffener must enable the cap to retain its circumferential shape.
- 4.3.4 **Peak** - The peak must be made from two pieces of shell material. The two pieces must be seamed together and turned. The peak stiffener specified in Para. 4.1.2 must be inserted between the two plies and held in place by stitching the two shell plies together directly behind the peak stiffener. Six rows of stitching spaced 7 mm apart must pass through the three plies of the peak along the front edge as shown on the drawing. The peak must be stitched to the front of the crown, the stitching to be directly behind the back edge of the peak stiffener. The peak must be permanently curved as per the viewing sample.
- 4.3.5 **Sweatband** - Must be made of shell material and lined with a non-woven material equivalent to the viewing sample. The side edges of the shell material of the sweatband must be folded over the lining and stitched 3 mm gauge. The sweatband must be 34 mm finished width. One edge of the sweatband must be placed on the outside overlapping the bottom edge of the cap so as to cover all stitching, and the sweatband stitched to the cap 1.5 mm gauge.

- 4.3.6 **Size Adjustment Strap** - Each cap must have a size adjustment strap 1.75 cm wide made of shell material, to be positioned across the cut-out portion. The strap must be 25 cm long including two 5 cm long pieces of elastic specified in Para. 4.1.9, attached by stitching to both ends of the back strap. The attachment point for the elastic ends of the back strap must be on the sweatband with one row of stitching 7 cm from the edge of the cut-out portion. A channel must be created by 1.5 cm of horizontal stitching of the sweatband 2 cm up from the bottom edge of the cap starting at the cut-out portion to enable the size adjustment strap to move back and forth when the cap is worn. The elastic ends of the back strap must be turned and stitched to prevent fraying of the elastic prior to assembly of the back strap.
- 4.3.7 **Embroidery** - Each baseball cap must have the following words embroidered on the front two sections: RCMP POLICE GRC for Type I & II caps, RCMP CHAPLAIN AUMÔNIER GRC for Type III caps, using the embroidery yarns specified in Para. 4.1.8, font and size per viewing sample. It must be backed with the front crown lining as per Para. 4.1.6 to provide sufficient stiffness equal to the viewing sample.
- 4.3.8 **Marking** - A label must be sewn on the sweatband at the back of the cap legibly and indelibly marked in accordance with good commercial practice with the following information:
- Manufacturer's Identification
 - RCMP Item Name (in French and English – ‘Cap, Baseball’ & ‘Casquette de baseball’)
 - Size designation – S/M or L/XL
 - RCMP Stock Number
 - Date of Manufacture in numerical format (e.g. YYYY/MM)

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

- 5.1 Unless otherwise specified the items must be delivered to the Commissioner, R.C.M.P., Uniform and Equipment Program, Ottawa, Ontario, free of transportation charges and provincial tax.
- 5.2 Packing and marking of shipping containers must be as specified in the invitation to tender.
- 5.3 A packing slip must 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 and 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 and 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 R.C.M.P., Uniform and Equipment Program.
- 6.2 The R.C.M.P., Uniform and 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 must 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 I

	SPECIFICATION	TESTED BY CAN/CGSB-4.2
Colour	To match colour swatch provided by Uniform and Equipment Program	
Weave	Twill	
Mass	245 ± 8 g/m ² (237 - 253)	Method 5.1-M90
Width	160 cm (min.)	Method 4.1-M87
Yarns per 10 cm	Warp 340 (min.) Weft 170 (min.)	Method 6-M89
Breaking Strength	Warp 850 Newtons (min.) Weft 630 Newtons (min.)	Method 9.2-M90
Tearing Strength - Rip Method	Warp: 45 Newtons min Weft: 25 Newtons min	Method 12.1-M90
Dimensional Change to Domestic Laundering	Warp 2% (max.) Weft 2% (max.)	Method 58-2004, Wash Procedure II; Dry Procedure E; Restoration Procedure 3)
Colourfastness to Light	At least AATCC L4	Method 18.3-97
Colourfastness to Perspiration	Grey scale 4 or better	Method 23-M90 (2004)
Colourfastness to Rubbing (Crocking)	Dry - grey scale 4 or better Wet - grey scale 3 or better	Method 22-2004
Water Repellency	<i>Initial</i> - 100	Method 26.2-94 (2003)
Pilling	after 90 mins - no less than 4 after 120 mins - no less than 4	Method 51.2-M87
Crease Recovery	warp - 70% weft - 70%	Method 45-M88
Non-Fibrous Material	3.1% (max.)	Method 15
Fibre Blend	Polyester 65% ± 3% Cotton 35% ± 3%	

Note: For information purposes, Doubletex “Tuff Twill MF2S” 65/35 Poly/cotton is known to meet this specification. Other Manufacturers’ fabrics shall be acceptable provided a test report is submitted to verify compliance.

Appendix A

Certification & Testing Criteria

Appendix A contains the definitions for certificate of compliance and test reports that are required for this specification. The tables of requirements shall be used by the manufacturer and RCMP Uniform and Equipment Program to ensure proper documentation is received and meets the requirements outlined in this specification.

Certification of compliance: Compliance certification documents must 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 must 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.

Certification & Evaluation Criteria

Para. Title/Test	Certification of Compliance	Test Report	Pass/Fail
Type II Shell Fabric (Para. 4.1.1) (Table I)	Required		
Seam Tape & Seam Binding (Para. 4.1.4)	Required		
Thread (Para. 4.1.7)	Required		
Elastic (Para. 4.1.9)	Required		