



Baseball, Cap

Purchase Description



File no. CBSA/ASFC-2011-08-106
Date of issue: 2013-07-24

PROTECTION • SERVICE • INTEGRITY

PURCHASE DESCRIPTION

CAP, BASEBALL

1. SCOPE

This purchase description describes the requirement for materials, design, construction and inspection of an embroidered baseball cap for use by Border Service Officers (BSO) within the Canada Border Services Agency (CBSA).

2. GENERAL REQUIREMENTS

This one-size-fits-most baseball cap, made from 100% brushed cotton shall be dark navy blue in colour. The baseball cap shall be constructed completely from fabric, made with six (6) panels, and a pre-curved peak/visor. It shall have a tuck-in-style strap adjuster, with a fabric strap, brass buckle snap and grommet. The center front of the crown and the center back of the baseball cap shall be embroidered. The sealed sample clearly defines the requirement for all components of this item.

3. SEALED SAMPLE

A sealed sample, identified by the purchase description number noted in the contract, will be supplied to the successful tenderer when available. This will constitute the standard in regards to any properties not identified in this purchase description. Variation from the purchase description may appear in the sample in which case the purchase description shall govern unless otherwise identified on the sealed sample tag.

The sealed sample will be sent “prepaid” and is to be returned “prepaid”.

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

4. All articles or materials covered by this purchase description 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 sealed sample.

In the event of inconsistency with the purchase description, the Technical Authority shall be contacted for clarification.

5. **DETAILED DESCRIPTION**

5.1 **Materials:**

5.1.1 **Shell Material:** Commercially available, 100% Cotton Twill in a brushed finish, 290 g/m² (8.5oz/yd²), dark navy blue in colour, equivalent to the sealed sample.

5.1.2 **Thread**

5.1.2.1 **Thread for Seams & Stitching:** Polyester core, polyester wrap, Class B, R50 Tex, Type 1 Soft, of matching colour to the shell material, meeting CAN/CGSB 4.131-93.

5.1.2.2 **Thread for Embroidery:** Viscose rayon, Schiffli twist, bright finish, linear density of 99 dtex/2 - 167 dtex/2. An equivalent Polyester thread may be used.

5.1.3 **Peak/Visor Stiffener:** Commercially available, pre-curved peak/visor, 7cm (2¾") in depth. Equivalent to the sealed sample.

Note: For information purposes CP-8 Visa, pre-curved 0575 gauge is known to meet this requirement.

5.1.4 **Sweatband (three layers):** 3.2 cm (1¼") wide, commercially available navy blue cotton twill for the outer layer; 1.5mm thick foam, fused to a non-woven pellon for the inner layer; seam binding covering all raw edges. Equivalent to the sealed sample.

5.1.5 **Front Crown Interlining:** Shall be fusible, plain weave with a yarn count of 20 x 20/cm, 65% Polyester/35% cotton, equivalent to the sealed sample.

5.1.6 **Adjustment Strap:**

5.1.6.1 **Fabric strap:** Two layers of shell material 15.25cm (6") long by 1.6cm (5⁄8") wide finished, stitched together to form a strap.

5.1.6.2 **Buckle & Snap:** Commercially available brass buckle with a snap backing (female portion) in an antique brass finish. Corresponding male portion of the snap attached to the right rear of the ball cap.

5.1.6.3 **Grommet:** Brass grommet in an antique brass finish, 2.5cm (1") long with a functional opening of 5mm (3⁄16").

5.1.7 **Seam Binding:** Shall be dark navy to match the shell material, plain weave, 100% Polyester. Equivalent to the sealed sample.

5.1.8 **Button:** One 15mm (24 ligne) galvanized steel button, covered in shell material as specified in Para. 5.1.1.

5.1.9 **Eyelets:** Six (6) machine eyelets, one eyelet per panel, 3.2mm (1/8”) made from thread as specified in Para. 5.1.2.

6 **EMBROIDERY**

Using the thread as specified in Para. 5.1.2.2, and colours identified below, the front and back of the ball cap shall be embroidered with the CBSA Heraldic Crest and “Canada” wordmark. Copies of artwork can be provided upon request to the Technical Authority. The embroidery of both front and back logo’s shall be equivalent to the sealed sample and drawings.

6.1 **Embroidery Colours:**

- GREY: PANTONE COOL GREY 3C
- RED: PANTONE 032C
- GOLD: PANTONE 124C
- BLACK: PANTONE BLACK C
- GREEN: PANTONE 334C
- BLUE: PANTONE 3035C
- PANTONE WHITE
- NAVY: MATCH HAT COLOUR

6.2 **Front Logo:** It shall be embroidered directly to the center front of the two front panels 1.27cm (1/2”) above the peak. The completed front logo shall contain not less than 18,875 embroidery stitches and shall be equivalent to the sealed sample.

6.3 **Back Logo:** Consisting of the “Canada” wordmark and flag, shall be embroidered in a curve 1.6cm (5/8”) above the center back opening. The completed back logo shall contain not less than 4800 stitches and shall be equivalent to the sealed sample.

6.3.1 **Back Logo – Font:** Back logo font shall be CALSON 2D Flat EMB with sizes as outlined in drawing 5. Equivalent to the sealed sample and drawings.

7 **CONSTRUCTION**

7.1 **Cutting:** The baseball caps including the covered button shall be cut from the piece of fabric specified in para. 5.1.1.

7.2 **Sizing:** Standard adult size; one-size-fits-most design, fitting a range of 55.8cm – 60.6cm (22”-23 7/8”) or hat sizes of 7 - 7 5/8.

- 7.3 **Stitching:** All seams must be a minimum of 6.4 mm ($\frac{1}{4}$ ") wide, lock stitched or lock chain stitched with not less than 3.5 not more than 4 stitches per centimetre. The beginning and ending of all stitching shall be backstitch tacked.
- 7.4 **Crown:** The crown of the cap shall be constructed from shell material as specified in Para 5.1.1. It shall consist of 6 long triangular shaped gores (sections). These sections shall be sewn together with the raw edges on the inside taped with seam binding as specified in Para 5.1.7. Six (6) machine thread eyelets positioned as per the drawings shall be centered on each section. A covered button shall be applied securely at the top of the cap at the point where all seam sections meet. The front center portions of the crown after application of the embroidery shall be lined with a fusible interlining as specified in Para. 5.1.5. The back of the crown shall have a cut-out with a size adjustment strap and a snap-buckle and grommet as specified in Para. 5.1.6.2. The male portion of the snap shall be applied to the right corner at the back of the cap, beside the cut-out. The grommet shall be applied to the right back portion 3.8cm ($1\frac{1}{2}$ ") from the cut-out and 2.5cm (1") from the male snap. The edge of the back cut-out portion shall be bound and top stitched using a 1.6 mm ($\frac{1}{16}$ ") and 6.4 mm ($\frac{1}{4}$ ") gauge. The crown shall be shaped, dimensioned and constructed as per the sealed sample.
- 7.5 **Size Adjustment Strap & Buckle:** The strap shall be made from two layers of shell material as specified in Para. 5.1.1, sewn together and turned and topstitched. The finished dimensions of the strap shall be 15.25cm (6") long by 1.6cm ($\frac{5}{8}$ ") wide. The raw edge of the strap shall be sewn securely to the left side of the opening. The strap shall be fed through the snap-buckle as per the sealed sample. The corresponding male snap shall be applied to the right rear of the cap back. All components of the adjustment strap shall be as per the sealed sample and drawings.
- Note:** Care shall be taken to ensure that the male and female portions of the snaps are applied securely to the cap. Snap failures will be a cause for rejection.
- 7.6 **Sweatband:** A sweatband constructed as per Para 5.1.4, shall be sewn into the cap with sewn edge stabilized to reduce stretching. The finished sweatband shall be shaped, dimensioned and constructed as per the sealed sample.
- 7.7 **Peak/Visor:** Shaped and dimensioned as per the sealed sample, the peak shall be constructed from shell material as specified in Para. 5.1.1 and the peak stiffener as specified in Para. 5.1.3. Six (6) rows of top stitching spaced 6.4mm ($\frac{1}{4}$ ") apart with the first row starting 1.27cm ($\frac{1}{2}$ ") from the peak edge shall secure the components together. Care shall be taken to ensure that the peak is centered when attached to the cap. The completed peak/visor shall be equivalent in all respects to the sealed sample.

8 **MARKINGS**

The cap must be permanently identified with a bilingual label with the information as shown below. The label shall be sewn to the inside left portion attached to the sweatband.

- Size designation
- Fibre content of shell/lining/interlining
- Contract number
- Material Master Number

9 **PACKAGING**

9.1 It is the responsibility of the manufacturer to ensure that goods are packaged in a suitable manner to be delivered in an undamaged condition. Any goods received in a damaged condition will be returned to the manufacturer for replacement at his full cost.

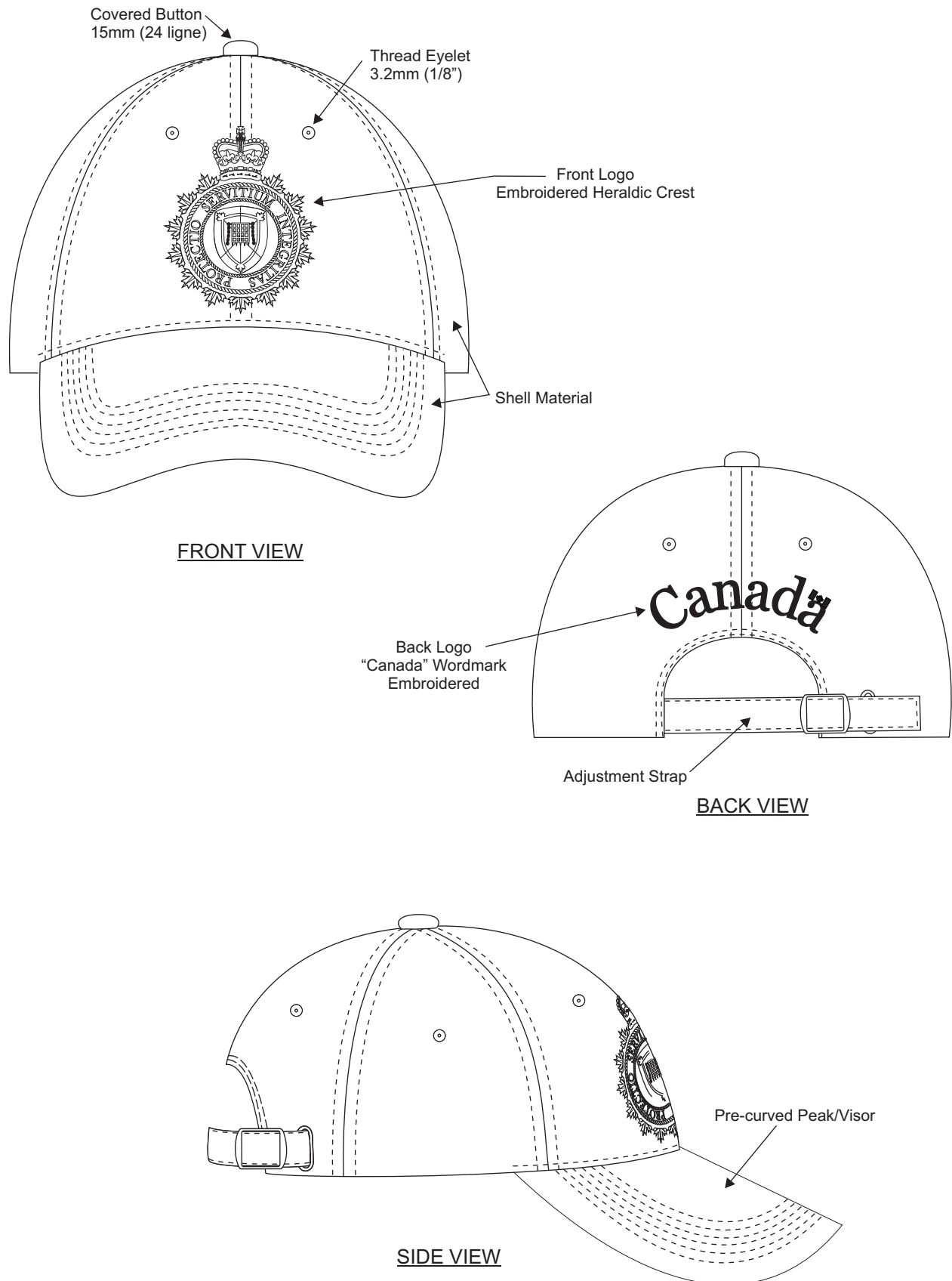
9.2 The contractor will individually package the caps in accordance with the best commercial packaging with 25 caps per box.

9.3 The contractor will also identify clearly on the outside of each package (box) the following items:

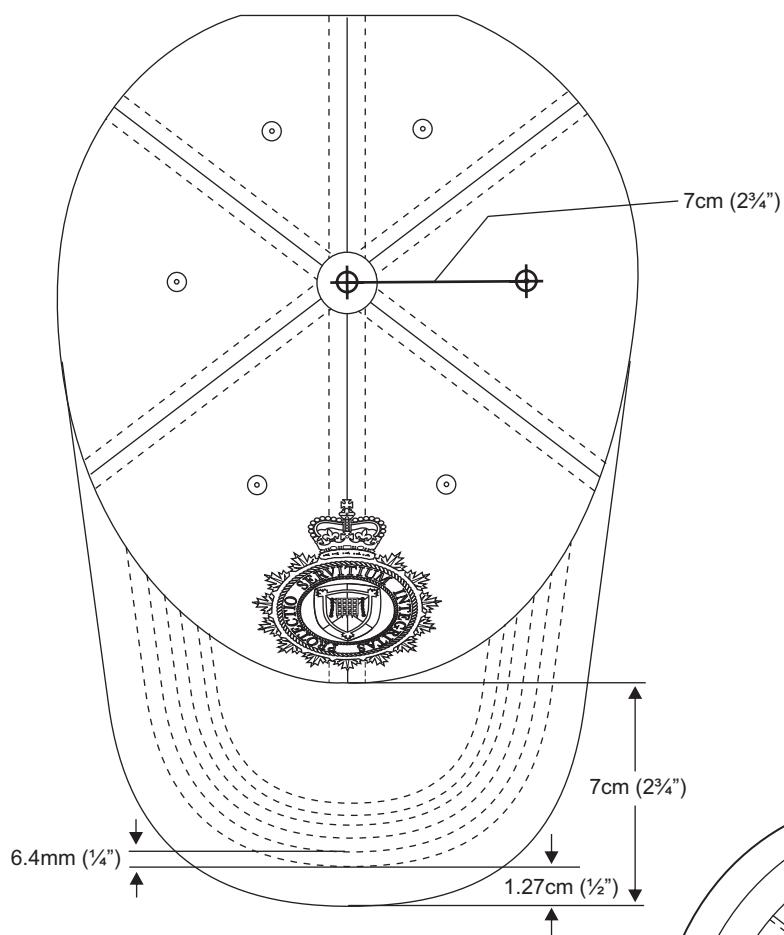
- Material Master number (see contract for specified size numbering);
- Quantity of each size contained in the box;
- Contract number

10 **APPENDICES**

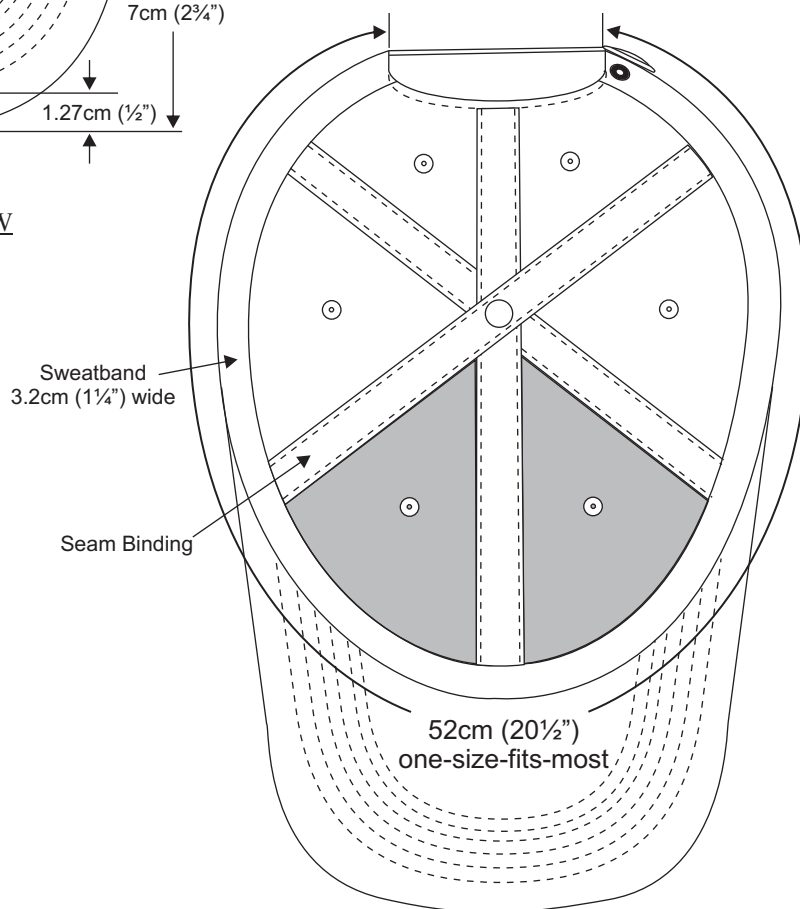
Drawings – as per Appendix A.



NOT TO SCALE

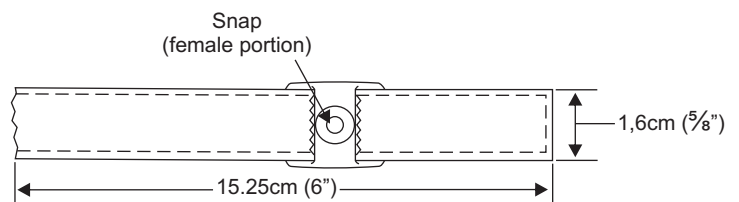
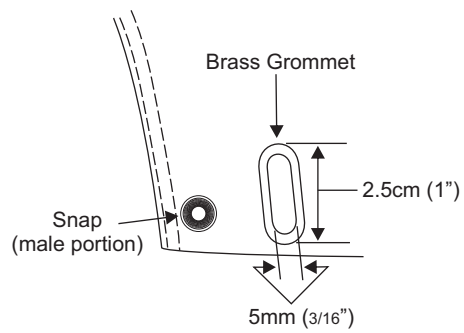
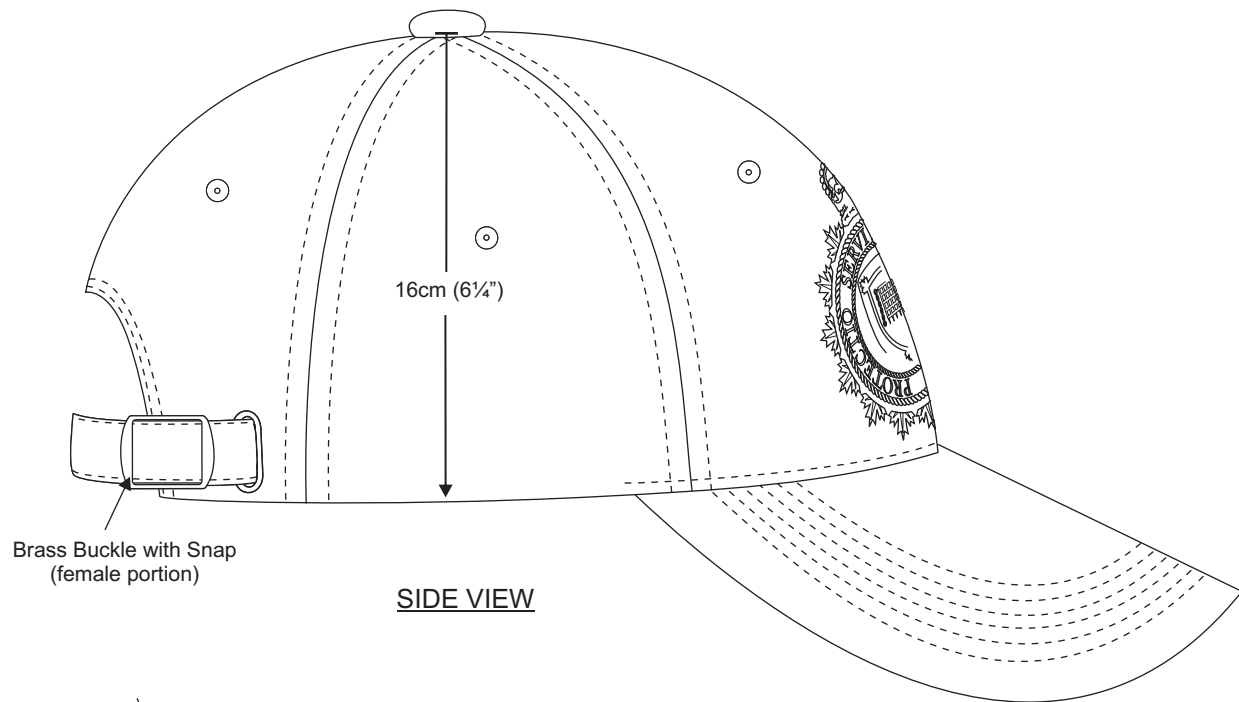


EXTERIOR TOP VIEW



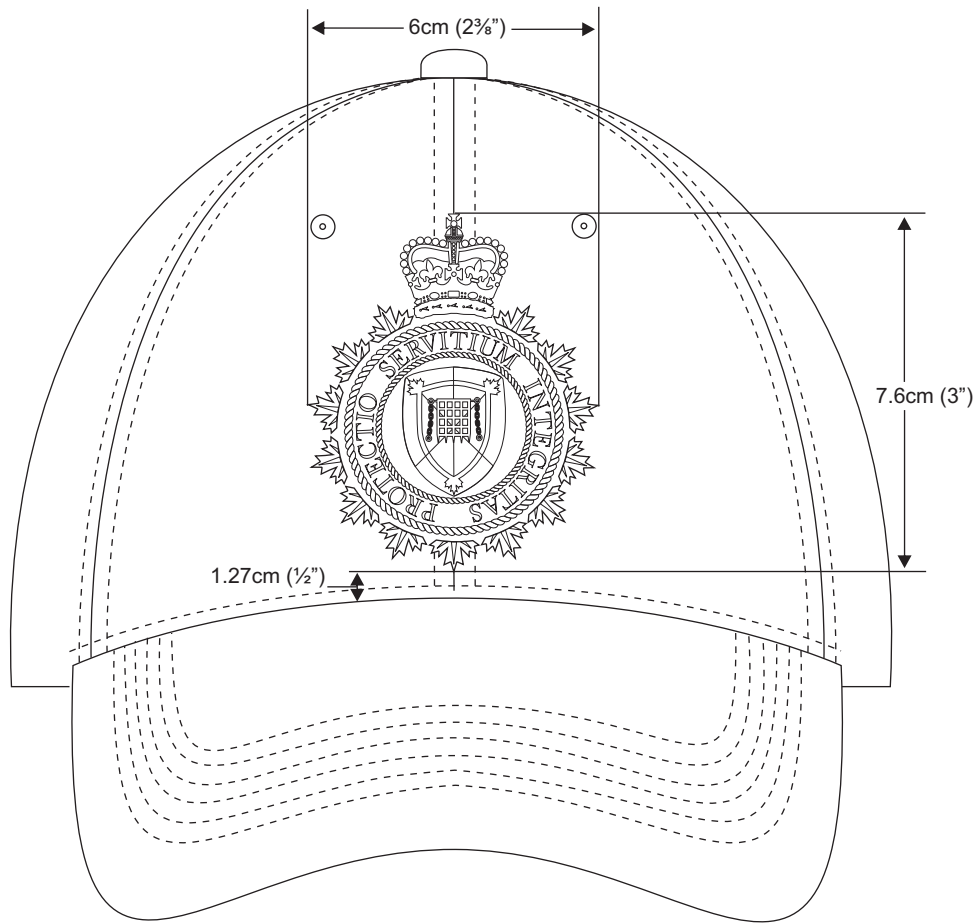
INTERIOR INSIDE VIEW

NOT TO SCALE



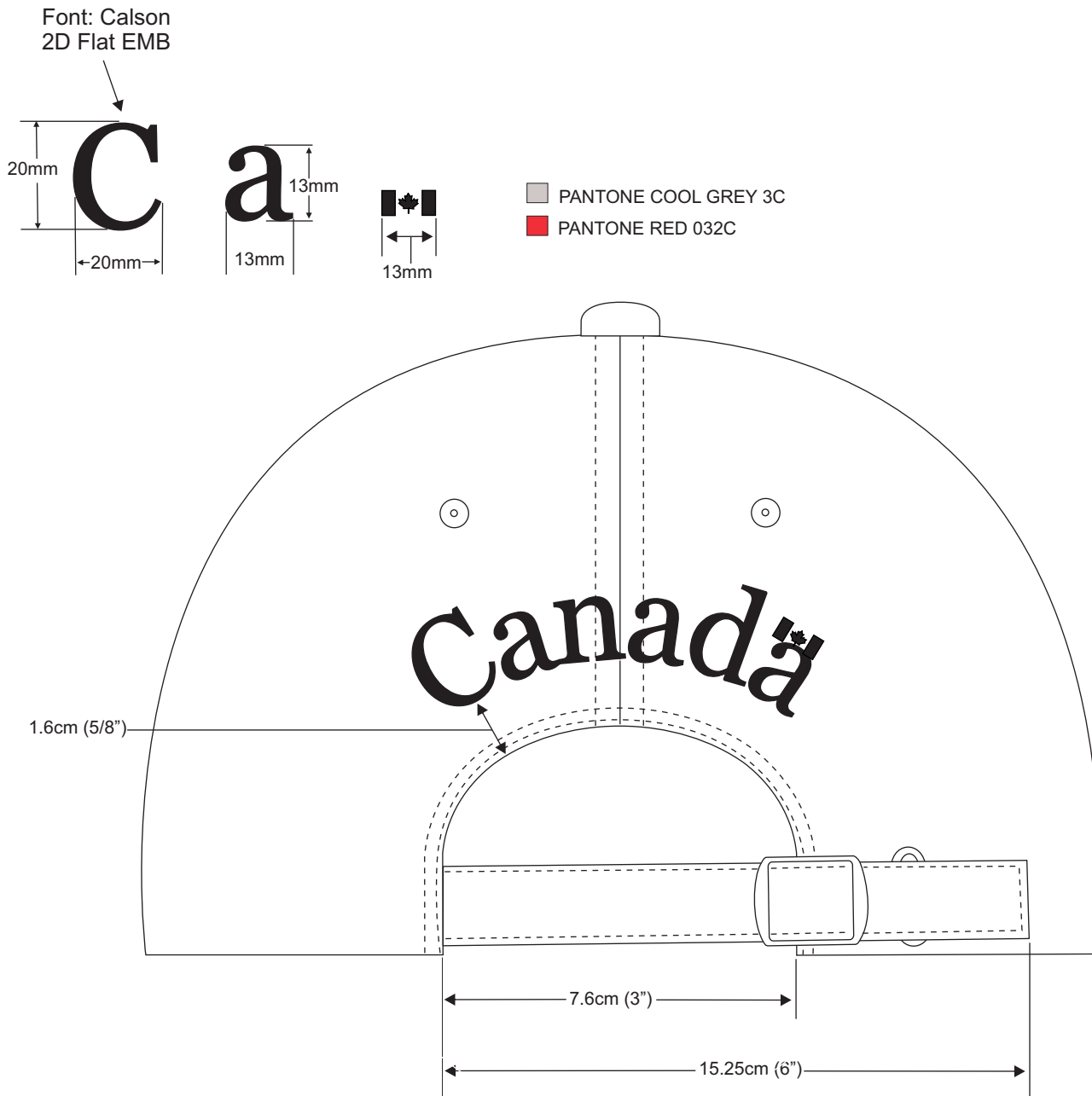
ADJUSTMENT STRAP SHOWING INSIDE VIEW

NOT TO SCALE



- PANTONE COOL GREY 3C
- PANTONE RED 032C
- PANTONE GOLD 124C
- PANTONE BLACK C
- PANTONE GREEN 334C
- PANTONE BLUE 3035C
- PANTONE WHITE
- NAVY MATCHING CAP COLOUR

NOT TO SCALE



BACK VIEW - BACK LOGO EMBROIDERY

NOT TO SCALE