



Royal Canadian Mounted Police
Gendarmerie royale du Canada

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Specification

Badges and Epaulettes, Rank (Woven Type)

This document has 25 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.

Modifications

Date	Para. No's	Modifications
1989-12-19		Original Specification
1991-02-06	Appendix 'A'; DIAGRAMS 9 & 10	Addition of drawings to spec.
1991-03-07	All pages	File # changed as per request from Records Office
1991-10-28	Drawing No. 3	Corrected spelling of the word 'Auxiliaire'
1993-03-31	Drawings 11, 12, 13, & 14	Drawings for new items added.
1993-10-18	Pg. 2 & Drawing No. 15.	Cadet Epaulette added.
1993-12-10	Page 2, Para. 4.2	Construction detail for item 15 added.
2002-12-05	Drawing 3, 16	New Auxiliary Badge design. Community Constable Badge added.
2007-03-29	Entire specification Para. 4.1.3	Nomenclature changed from sealed sample to viewing sample. Gold yarn type re-specified.
2013-02-12	Entire Specification	Specification re-issued to amend requirements for colour fastness and finish and include requirement for independent test data to prove compliance.
2013-05-23	Paras. 2.3, 4.1.5, 4.1.6, 4.4.1, Appendix 'A', Dwg. 1	Hook tape backing and stitching thread specified, new badge added w/hook tape backing added to specification. Nomenclature changed for names in drawings 1,2,3 and Appendix 'A'.

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

BADGES AND EPAULETTES, RANK (WOVEN TYPE)

1. Definition

- 1.1 This specification shall govern the manufacture and inspection of Badges and Epaulettes, Rank (Woven Type).
- 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 Badges and Epaulettes, Rank (Woven Type).

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 CAN/CGSB 4.131-93, Thread, Polyester, Polyester Covered.

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 badges and epaulettes shall be designed in accordance with the drawings attached and forming part of this specification; and the viewing sample.
- 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 **Warp Yarn** - The warp yarn shall be black in colour, 100% polyester 100 dtex (90 denier).
- 4.1.2 **Ground Yarns** - The ground yarns shall be navy blue and royal blue in colour, 100% polyester 167 dtex (150 denier).
- 4.1.3 **Design Yarns** - The design yarns shall be a combination, as applicable for the individual badges or epaulettes in the following colours:
- Gold, 100% polyester, 160 dtex (63Nm). Lurex PMRP 2545, colour DG856 is known to meet the requirements.
 - Royal Blue, 100% polyester, 167 dtex (150 denier).
 - Red, 100% polyester, 167 dtex (150 denier).
 - White, 100% polyester, 167 dtex (150 denier).
 - Green, 100% polyester, 167 dtex (150 denier).
- 4.1.4 **Thread, Merrowing** - The thread shall be 100% rayon, 666 dtex (600 denier) 2 ply, navy blue in colour, matching the navy blue ground colour yarn of the finished badges.
- 4.1.5 **Thread, Stitching** - Shall be polyester-wrap, polyester-core, Tex 40, Class B, meeting CAN/CGSB 4.131-93, matching the navy blue ground yarn colour of the finished badges.
- 4.1.6 **Hook Tape Backing** – For any badge requiring hook tape backing, shall be woven nylon, black in colour, with a high life cycle, to match viewing sample. When combined with loop tape on RCMP uniform clothing (e.g. duty shirts) the combined hook and loop shall have no less than 8 P.S.I length-wise shear strength. The initial peel strength shall not be less than 1 P.I.W and after 1000 cycles shall be not less than .5 P.I.W. with a minimum lengthwise shear of 4 P.S.I.
- 4.2 **Certification** - Test data from an independent testing facility must be provided for the requirements in Para. 4.7.1 to 4.7.4. All values and test methods are provided below.
- 4.3 **Weaving** - The weaving shall be 1 x 3 right hand twill. All design yarns shall be bound down. The ground (base) of the shoulder badges, Police and Transport shall have 552 warp ends and 348 picks. The epaulettes and other badges shall be similar, respective to their design and size. Item 15 (Cadet Epaulette) shall be if double shuttle panel construction as per viewing sample.
- 4.4 **Finish** - All badges and epaulettes shall have a resin hand building finish. After die cutting, the badges shall be finished with a merrow edge, overlapping at the center bottom. The resulting end tail shall not be cut off. It shall be glued to the

back. The epaulettes shall be interlined, the edges serged or sealed, then sewn and pressed forming a sleeve with the insignia properly centered as per viewing sample.

4.4.1 **Hook Tape Backing** – The Badge, Shoulder, Police w/Hook Tape (RCMP Stock Number 2136-209 as per Appendix ‘A’ below) shall have a single layer of hook tape specified in para. 4.1.6 above sewn on the back of the badge with a single row of the thread specified in Para. 4.1.5, lockstitched. The hook shall not extend beyond the merrow edging. Stitching shall be located as close to the inner border of the merrow edging as possible while thoroughly securing the hook tape backing, and shall not cross any of the symbol/lettering/emblem on the surface of the badge.

4.5 **Dimensions** - The dimensions shall be as per applicable drawing and viewing sample.

4.6 **Colour and Shade** - The finished badges and epaulettes shall match the viewing samples in colour and shade.

4.7 **Colour Fastness**

4.7.1 **To Light** - At least equal to AATCC standard L5. (CAN/CGSB-4.2 Method 18.3-97).

4.7.2 **To Crocking - Dry & Wet (Water)** - No more staining in the warp and weft than grey scale 4-5 for dry crocking and grey scale 3-4 for wet crocking. (CAN/CGSB-4.2 Method 22-2004).

4.7.3 **To Washing** - No more change in shade and no more staining than grey scale 4. (CAN/CGSB-4.2 Method 19.1-2004 Test No.2).

4.7.4 **To Dry Cleaning** - No more change in shade and no more staining than grey scale 4. (CAN/CGSB-4.2 Method 29.1-M89 (1997)).

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

5.1 Unless otherwise specified the items shall be delivered to the Commissioner, R.C.M.P., Quality Control Section, Ottawa, Ontario, free of transportation charges and provincial tax.

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, Quality Control that the material and services being supplied conform to this tender, contract and specification. This shall be accomplished by performing the tests specified in this specification. The contractor must use any independent, North American, ISO 9001 certified and ISO 17025 "Textile" certified testing facilities. Certification will be required.
- Note: CTT Group Inc., Quebec, is known to meet this requirement.
- 6.2 **Test Methods** - The methods of test shall be as specified with each requirement.
- 6.3 The RCMP, Quality Control reserves the right to perform any inspection considered necessary to ensure the material and services conform to the specified requirements. Inspection may be done during manufacture and is subject to testing and approval by the RCMP Quality Control. Imperfections shall be assessed in accordance with current RCMP practice. If the cloth is found to be inferior to the viewing sample or not in accordance with this specification, the entire delivery may be rejected. The entire delivery may also be rejected if it is found that materials previously rejected due to non-repairable defects are redelivered for inspection.
- 6.4 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'

R.C.M.P. STOCK No.	ITEM DRAWING	BADGE, EPAULETTE, RANK	COLOUR
2135-108	1	Badge, Shoulder, Police	Navy Blue, Gold, Royal Blue, Red, White & Green
2138-506	2	Badge, Shoulder, Transport	Navy Blue, Gold, Royal Blue, Red, White & Green
2075-504	3	Badge, Shoulder, Auxiliary	Navy Blue, Gold, Royal Blue, Red, White & Green
1750-305	4	Badge, Special Constable	Navy Blue & Gold
2140-004	5	Badge, Student	Navy Blue & Gold
3360-300	6	Epaulette, Rank, Corporal	Navy Blue & Gold
3360-407	7	Epaulette, Rank, Sergeant	Navy Blue, Gold, Red, White & Green
3360-504	8	Epaulette, Rank, S/Sergeant	Navy Blue & Gold
3370-208	9	Epaulette, Rank, Sergeant Major	Navy Blue, Gold, Red, White & Green
3370-305	10	Epaulette, Rank, Corps Sergeant Major	Navy Blue, Royal Blue, Gold, Red, White & Green
7070-C40	11	Epaulette (Canada) Corporal	Navy Blue & Gold
7070-C30	12	Epaulette (Canada) Sergeant	Navy Blue, Gold, Red, White & Green
7070-C20	13	Epaulette (Canada) S/Sergeant	Navy Blue & Gold
7070-C10	14	Epaulette (Canada)	Navy Blue & Gold
3360-150	15	Epaulette, Rank, Cadet	Yellow & Navy Blue
1250-100	16	Badge, Constable, Community	Navy Blue & Gold
2136-209	1	Badge, Shoulder, Police w/Hook Tape Backing	Navy Blue, Gold, Royal Blue, Red, White & Green

Evaluation Criteria

The evaluation criteria is a reference list used by RCMP Quality Control Section to ensure all required documentation has been received and meets the requirements outlined in this specification.

Definitions:

Certificate of Compliance: Certificate of Compliance documents shall be based on testing from a raw goods manufacturer from an in-house or independent laboratory acceptable to the RCMP to verify performance requirements as specified in this specification.

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. Failure to provide the requested documentation shall be cause for rejection. Failure to meet the requirements when tested by the RCMP Quality Control Section shall be cause for rejection.

Para.	Title/Test	Test Methods CAN/CGSB-4.2	Requirement	Test Report Results	Pass or Fail	
6.1	Lab Facility Used		Certified Independent Test Facility			
4.4	Finish		Resin Hand building finish	Certificate of Compliance Required		
4.6	Colour		As per viewing sample			
4.7.1	Colourfastness to Light	Method 18.3-97	equal to or better than AATCC Standard L5			
4.7.2	Colourfastness to Crocking	Method 22-2004	No more Staining than Grey Scale	No more Staining than Grey Scale		
			Dry: Warp	4 - 5	Dry: Warp	
			Dry: Weft	4 - 5	Dry: Weft	
			Wet: Warp	3 - 4	Wet: Warp	
Wet: Weft	3 - 4	Wet: Weft				
4.7.3	Colourfastness to Washing	Method 19.1-2004 Test 2	No less than Grey Scale	No less than Grey Scale		
			Colour Change	4	Colour Change	
			Staining:	4	Staining:	
4.7.4	Colourfastness to Dry Cleaning	Method 29.1-M89 (1997)	No less than Grey Scale	No less than Grey Scale		
			Colour Change	4	Colour Change	
			Staining:	4	Staining:	