



Royal Canadian Mounted Police
Gendarmerie Royale du Canada

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Specification

Equipment, Sam Browne, Officer's

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.

Modifications

Date	Para. No's/N ^o de par.	Modifications
2008-10-01	Para. 4.2, Dwg. 2	Long Shoulder strap added to specification; some other dimensions changed
2009-09-28	Paras. 2.4, 4.1.3, 4.3.1.3, 4.3.2.9, 4.3.2.11 & Dwg. 1	List of hardware items & composition, sword hook location; sliding keeper location; thickness of stud retainer
2010-12-02	Dwg. 1	Stud location measurement added for sizes 31-33.
2012-07-06	4.1.1.6, 4.1.3, 4.3.2.8, Table I, Dwg. 1	Thickness clarified, tolerance to length added, tongue dimension clarified with tolerance, Table I dimensions, and Dwg 1 - stud, stud hole location and tongue length.
2014-04-08	Paras. 2.2 – 2.6 Para. 4.1.1 Para. 4.1.2 Para. 4.1.3 Para. 4.3.2.1 (new) 4.3.2.7 (deleted) Para. 4.3.2.8 Para. 4.3.2.10 Para. 4.3.3.1 Para. 4.3.3.8 (new) Para. 4.3.3.9 Para. 4.3.4 (new) Para. 5.4 (deleted) Para. 5 (deleted) Scale of Measurements Appendix 'A' Dwgs. 1, 2	New leather and thread standards. New leather requirements & Certification of Compliance added. New Table I added. New thread requirement & Certification of Compliance added. Hardware detail amended. New design paragraph added, later paragraphs renumbered Information added to Para. 4.3.2.8 Dimension definitions added. Marking detail amended. Shoulder strap design details added. New paragraph for shoulder strap keepers. New paragraph for shoulder strap marking. New assembly paragraph added. Old assembly paragraph deleted. Deleted in its entirety, Para. 6 renumbered. Dimension indicators amended, tolerances added, belt measurement for all sizes added, table renamed; Certification of Compliance appendix added. Dimension indicators amended, tolerances added, drawing details added. Three sizes of removable loop added to shoulder strap detail.

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**EQUIPMENT, SAM BROWNE, OFFICER'S****1. Definitions**

- 1.1 This specification shall govern the manufacture and inspection of Equipment, Sam Browne, Officer's.
- 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 Equipment, Sam Browne, Officer's.

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.
- 2.6 R.C.M.P., G.S.1045-140, Hardware, Equipment, Sam Browne.

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** - Shall be a military style leather Sam Browne belt and coordinating shoulder strap.

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 **Material Requirements**

4.1.1 **Leather** – The leather shall be vegetable 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. It shall be free from slaughter cuts, damaged grain, open scratches, open grub holes, brands or heavy fat wrinkles. Light well-healed over scratches or grub holes and light wrinkles that do not affect appearance will be accepted in the finished leather. The grain side of the leather shall be lightly corrected by buffing. The corrected leather shall be printed with a smooth ‘hair seal’ type of print as per the viewing sample. The grain side shall be stained brown with a stain that will penetrate below the grain surface. After staining, the grain surface shall be sealed with a pigmented resin coat of suitable sealer and then finished with a coat of semi-bright lacquer. The finish shall be durable and colourfast. The flesh side shall be free from loose flesh and shall be buffed to a smooth natural finish. The colour shall match the viewing sample. Leather thickness shall be from 2.75 to 3.25 mm. The leather shall meet the following physical requirements:

Table I

Property	Requirement	Test Method
Crocking	‘Good’	ASTM 5053-03 [2009]
Cracking, 11mm mandrel	None	ASTM D6075-13
Grain Crack index	25 psi min.	ASTM D2210-00 [2012]

Certificate of Compliance required.

4.1.2 **Thread** – The thread shall be twisted multifilaments 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 , brown in color to match the leather.

Certificate of Compliance required.

4.1.3 **Hardware** - The hardware shall conform to the requirements of RCMP G.S.1045-140, listed as follows:

G.S.1045-140 Item Number	Item Name
1	Buckle, Double Prong
2	Claw, Buckle, Double Prong
4	Buckle, Single Prong
5	‘D’ Ring, Large
8	Hook, Sword
9	Stud, Round Head, Rivet
10	Stud, Round Head, Flange
Items 1 & 2 to be purchased from the RCMP. All other items shall be acquired by the manufacturer.	

4.2 **Size & Dimensions** - Equipment, Sam Browne, Officer’s, to this specification shall be supplied in the sizes specified by the RCMP and to the dimensions given in the Scale of Measurements and in the attached drawings, forming part of this specification. Shoulder straps shall be available in Regular or Long Sizes, dimensions as per Dwg. 2.

4.3 **Construction**

4.3.1 **General Construction Requirements**

4.3.1.1 **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 2 nor more than 3 stitches per cm.

4.3.1.2 **Stud Hole Relief** - The slot of all stud holes shall be skived on both edges to reduce the leather to approximately half its thickness.

- 4.3.1.3 **Stud Retainers** - All studs shall be secured by the use of a circular piece of leather stitched to the back side of the leather, unless secured by other layers of leather, in accordance with the viewing sample. For the Shoulder Strap Assembly loop, where the stud is placed on top of the leather, and secured from behind by a circular piece of leather, this piece of leather shall be not less than 1.5 mm thick, secured with stitching and glue, in accordance with the viewing sample. This circular piece of leather shall have one slit cut on one side only from the centre allowing the stud head to pass through.
- 4.3.1.4 **Sealing** - All open flesh parts of the leather shall be sealed with "super-clear lacquer".
- 4.3.2 **Belt c/w Sword Hook & "D" Ring Straps**
- 4.3.2.1 **Design** – Shall be made of leather specified in Para. 4.1.1, with a sword hook, sliding keeper and ‘D’ ring straps.
- 4.3.2.2 **Skiving** - The buckle end of the belt shall be taper skived to reduce the end to a thickness of 2.38 mm to 2.58 mm. The skiving shall start at the back end of the buckle bar. The keeper shall be skived to a thickness of 2.38 mm to 2.58 mm.
- 4.3.2.3 **Belt Lining** - The belt shall have a leather lining 0.79 mm to 1.0 mm in thickness, of a type, quality and colour similar in all respects to the viewing sample, stitched to the flesh side of the belt in accordance with the viewing sample. Adhesive, if used, shall be sufficient to permanently adhere the lining to the belt.
- 4.3.2.4 **Stitching** - The stitching shall be lockstitch using thread specified in 4.1.2. The assembled belt shall be stitched in accordance with the viewing sample and attached drawing. There shall be a scroll, as shown in Drawing #1, starting 1.3 cm from the sword hook and ending 1.3 cm from the last set of double prong holes.
- 4.3.2.5 **Bevelling** - The assembled 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.
- 4.3.2.6 **Creasing** - Each edge of the keeper shall be creased on the grain side. The crease shall be not less than 1 mm nor more than 1.5 mm in width and shall be located 3 mm from the edge.

- 4.3.2.7 **Edge Finishing** - All edges, including the keeper, shall be stained and filled with a wax-type of brown edging ink and then burnished to a solid smooth and durable edge. Lacquer or varnish-type edge finishes shall not be used.
- 4.3.2.8 **Size and Dimensions** - The size and dimensions of the belt shall be as specified in the Scale of Measurements and the attached drawings. Measurements shall apply when the belt is laid flat without the double prong buckle attached. The following dimensions shall be defined as:
Belt Size – shall be the distance from the edge of the belt to the third set of double buckle prong holes.
Dimension ‘A’ – Shall be the distance from the edge of the belt to the centre of the sword hook.
Dimension ‘B’ – Shall be the distance from the centre of one set of double prong holes to the centre of the next, measured horizontally.
Dimension ‘C’ - Shall be the distance from the middle of the third set of double prong holes to the end of the tongue
Dimension ‘D’ – Shall be the distance from edge of the belt to the middle of the stud location.
Dimension ‘E’ – Shall be the distance from the middle of the third set of double prong holes to the middle of the third stud hole.
- Tolerance of +/-0.25 cm unless otherwise indicated.
- 4.3.2.9 **Sword Hook** - A sword hook in conformance with the requirements of Para. 4.1.3 shall be positioned on the belt in accordance with the attached drawing, centred between the ‘D’ ring straps.
- 4.3.2.10 **Marking of Belts** - The size of the belt shall be legibly stamped on the outside of the belt at the claw end. The manufacturer's name and date of manufacture in MM/YYYY format shall be legibly stamped on the lining of the belt.
- 4.3.2.11 **Belt Sliding Keeper** – Each belt shall have a sliding keeper made from the leather specified in Para. 4.1.1, dimensioned in accordance with Drawing #1 and the viewing sample. The sliding keeper shall be positioned on the belt so as to ensure that the tongue end of the belt shall be captured by the sliding keeper when the belt is worn. On belts up to size 40, the sliding keeper shall be positioned between the sword hook and first ‘D’ ring strap; on size 41 and larger, the sliding keeper shall be positioned between the stud and the first ‘D’ ring strap.

4.3.3 **Shoulder Strap**

4.3.3.1 **Design** – Shall be made from the leather specified in Para. 4.1.1. It shall come in two sizes: Regular and Long. It shall have two keepers and be similar in all respects to Drawing #2 and the viewing sample. The Removable Loop portion of the Shoulder Strap will be available in three sizes, dimensioned and detailed as per Drawing #2.

Note: All Shoulder Straps will come equipped with the Standard Size Removable Loop only.

4.3.3.2 **Skiving** - The buckle end of the shoulder strap shall be taper skived to reduce the end to a final thickness ranging from 2.38 mm to 2.58 mm.

4.3.3.3 **Bevelling** - The shoulder strap 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.

4.3.3.4 **Creasing** - Each edge of the shoulder strap and keepers shall be creased on the grain side. The crease shall be not less than 1 mm nor more than 1.5 mm in width and shall be located 3mm from the edge. The curved end portions of the shoulder strap shall be creased as per the viewing sample.

4.3.3.5 **Stitching** - The stitching shall be lockstitch using the thread specified in para. 4.1.2. The assembled shoulder strap shall be stitched in accordance with the viewing sample and attached drawing.

4.3.3.6 **Edge Finishing** - All edges, including the keepers, shall be stained and filled with a wax-type of brown edging ink and then burnished to a solid smooth and durable edge. Lacquer or varnish-type edge finishes shall not be used.

4.3.3.7 **Dimensions** - The dimensions of the finished shoulder strap shall conform to Drawing #2.

4.3.3.8 **Shoulder Strap Keepers** – Shall be made from the leather specified in Para. 4.1.1 and shall be similar in all respects to Drawing #2 and the viewing sample. The keepers shall provide a sufficient friction fit to properly retain the separate segments of the assembled shoulder strap.

4.3.3.9 **Marking of Shoulder Straps** – The size of the shoulder strap, Regular or Long , shall be legibly stamped on the flesh side of shoulder straps, using the upper case letters ‘R’ for Regular and ‘L’ for Long sizes.

- 4.3.4 **Assembly** – Equipment, Sam Browne, Officer’s, shall be properly assembled in a wearable state with all buckles placed in the third hole, keepers and removable loops attached as specified prior to shipment. The shoulder strap shall be packaged separately with the standard size removable loop attached. All other removable loops shall be individual packaged.

5. **Quality Assurance Provisions**

- 5.1 **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 his own facilities or any commercial testing establishment acceptable to the R.C.M.P., Uniform & Equipment Program.
- 5.2 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.
- 5.3 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.

Scale of Measurements

Belt Size		Dimension				
Imperial designation	Metric	Sword Hook Placement	Double Prong Holes Placement	Tongue Length	Stud Placement	Middle Double Prong Holes to Middle Stud Hole Distance
in	cm	cm	cm	cm	cm	cm
26	65	15.5	2.5	19	5.4	6.9
27	67.5	16.25				
28	70	16.75				
29	72.5	17.5				
30	75.25	18				
31	77.75	18.75				
32	80.25	19.25				
33	82.75	20				
34	85.25	20.5	3.8	23	8.9	10.4
35	88	21.25				
36	90.5	21.75				
37	93	22.5				
38	95.5	23.25				
39	98	23.75				
40	100.5	24.50				
41	103.25	25				
42	105.75	25.75				
43	108.25	26.25				
44	110.75	28.25				
45	113.25	28.75				
46	115.75	29.50				
47	118.50	30				
Tolerance	+/- 0.5 cm	+/- 0.25 cm			-0.25 cm ONLY	
Measurement Location		A	B	C	D	E

Note: Measurements shall apply when the belt is laid flat without the double prong buckle attached.

**Scale of Measurements
(Continued)**

Belt Size		Dimension				
Imperial designation	Metric	Sword Hook Placement	Double Prong Holes Placement	Tongue Length	Stud Placement	Middle Double Prong Holes to Middle Stud Hole Distance
in	cm	cm	cm	cm	cm	cm
48	121	32	3.8	23	8.9	10.4
49	123.5	32.5				
50	126	33.25				
51	128.5	33.75				
52	131	35.75				
53	133.5	36.5				
54	136.25	37				
55	138.75	37.75				
56	141.25	39.5				
Tolerance	+/- 0.5 cm	+/- 0.25 cm			-0.25 cm ONLY	
Measurement Location		A	B	C	D	E

Note: Measurements shall apply when the belt is laid flat without the double prong buckle attached.

Appendix A

Certification & Evaluation 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 & Equipment Program to ensure proper documentation is received and meets the requirements outlined in this specification.

Certification of compliance: A Certificate of Compliance is defined, for this solicitation, as a signed and dated certification by an appropriate official of the component manufacturer (e.g. slide fastener, hook and loop, webbing, etc.). It must specifically address the adherence of the offered component to the specification or manufacturing data of the technical requirement.

A separate certificate of compliance is required for each individual product or component. It must be dated within 18 months of the solicitation posting date; and must certify that the product for which the certificate of compliance was issued is the same product used in the bid submission, or in the pre-award samples or in the pre-production samples, or in the production units as applicable.

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
Leather (Para. 4.1.1)	Required		
Thread (Para. 4.1.2)	Required		