

**PURCHASE DESCRIPTION  
HEAVY NYLON BALLISTIC WEB DUTY BELT SYSTEM FOR  
CANADA BORDER SERVICES AGENCY**

**DEFINITION**

These specifications are issued normally for use with a specific requirement. Recipients should ensure that these specifications are identical with that quoted in the related procurement document.

**SCOPE**

This specification describes the requirement by Canada Border Services Agency for a padded Web Duty Belt System. The outer belt is 2 ¼ inches wide and is produced using a five part laminate heavy duty Nylon Blended Ballistic Fabric, black in colour. The outer belt style is a foamed, individual soft closed cell foam load with support pads, which evenly distributes weight of the duty gear. The inner belt is 1 ½ inches wide black in colour and is produced using a two-part laminate. The belt shall be secured by a Tri-Release belt buckle, which is injection molded, from a modified Polymer. The belt is designed to accommodate the holster and the tools such as handcuffs, O.C. spray and baton. The Web Duty Belt System shall have 8 (eight) keepers (2 (two) sliding nylon keepers included on the outer belt, plus 6 (six) additional snap closure keepers.)

Please refer to Appendix A of this document for the required test methods.

Please refer to Appendix B of this document for the technical drawing of the buckle.

**A sealed sample identified by the purchase description number, shall constitute the standard for any properties not identified in these specifications, for quality and design.**

**1. OUTER BELT****1.1. Material for Outer Belt**

1.1.1. The outer belt is constructed from a five-part laminate featuring the following:

**Outer Layer**

Heavy Duty Woven Black Nylon Blended Ballistic Fabric, 840 Warp Polypropylene, 975 Fill Polyester.

**Middle Layer #1**

High-density impact modified polyethylene .060 to .070 inch thick.

**Middle Layer #2**

1/8 inch thick 4 lb Volara Type EO foam. See Test Methods required for the following in Appendix A: Compression Strength, Shore Hardness, and Water Absorption.

**Middle Layer #3**

3/8 inch thick 4 lb Polyethylene foam

**Inner Layer**

Style 3001 Black Velcro loop or equivalent is acceptable

Shear Strength length-wise 14.0 psi (pounds per square inch)

Shear Strength width-wise 7 psi

**Edge bind**

¾ inch wide black nylon binding tape, .020 -.023 inch thickness, 840 denier X 420 denier

**Thread**

Thread is #69 bonded nylon thread, black in colour.

**1.1.2. Snap Closure Keepers**

There shall be 6 (six) snap closure keepers, produced using the same heavy duty Woven Black Nylon Blended Ballistic Fabric. There shall be snap closures positioned at each end of the keeper. The snaps shall be made from Solid Brass with a black oxide finish. The snap performance shall be regular action.

**1.1.3 Sliding Nylon Keepers**

There shall be 2 (two) sliding nylon keepers, produced using the same heavy duty Woven Black Nylon Blended Ballistic Fabric. The nylon keepers are a 1 inch wide permanent sliding loop positioned on the front part of the outer belt to secure the belt overlap.

**1.2. Construction of Outer Belt**

All 5 (five) layers of the belt are laminated. The entire thickness of the belt is .270 inch (+/- 10%).

The belt is stitched as to create 1¾ inch long pillows, each spaced apart the entire length of the interior of the belt. Each pillow is 1⅜ inch wide.

Velcro hook #88 is used on the ends of the belt to allow for attachment of the buckle.

All stitching shall be performed with #69 bonded nylon thread with a lock stitch, with 6 (six) to 8 (eight) stitches per inch.

The edge bind seam has a maximum of 1 inch overlap. Nylon ends shall be fused or hot cut to prevent fraying.

*See sealed sample.*

### **1.3. Buckle Hardware**

The Tri-Release belt buckle is injection molded from a modified polymer. The security three point release buckle provides for a single-handed release by first pressing the center tongue, then both sides of the buckle with the thumb and forefinger. The buckle allows for use with a gloved hand. Separation strength is greater than 300 lbs.

Please refer to Appendix B of this document for the technical drawing of the buckle.

*See sealed sample.*

## **2. INNER BELT**

### **2.1. Material for Inner Belt**

2.1.1. The inner belt is constructed from a 2 (two) part laminate featuring the following:

#### **Outer Layer**

Heavy Duty 1½ inch Nylon Webbing.

#### **Inner Layer**

Hook Velcro #88 or equivalent.

#### **Edge Binding**

¾ inch wide black nylon binding tape .020 - .023 inch thickness,  
840 denier X 420denier Thread, #69 black bonded nylon, 6-8 psi

### **2.2. Construction of Inner Belt**

All stitching is performed with a lock stitch, with 6 (six) to 8 (eight) stitches per inch. The edge bind seam has a maximum of 1 inch overlap. Nylon ends shall be fused or hot cut to prevent fraying. The liner belt includes one nylon web keeper 1 inch wide.

Hook and Loop Closure.

*See sealed sample.*

## **3. DECONTAMINATION**

AccuMold can be cleaned with most disinfectant soaps without harm to the material.

#### 4. SIZING REQUIRED

Outer belt size	Inner belt size
24-26	XS 24-28
26-28	S 28-34
28-30	S 28-34
30-32	S 28-34
32-34	M 34-40
34-36	M 34-40
36-38	M 34-40
38-40	L 40-46
40-42	L 40-46
42-44	L 40-46
44-46	L 40-46
46-48	XL 46-52
48-50	XL 46-52
50-52	XL 46-52
52-54	XXL 52-56
54-56	XXL 52-56

#### 5. MARKINGS

The size information and contract number shall be legibly and permanently inscribed on the inside of both the inner and outer belts.

#### 6. PACKAGING

- 6.1 It is the responsibility of the manufacturer to ensure that goods are packaged in a suitable manner to be delivered in an undamaged condition.
- 6.2 Any goods received in a damaged condition must be returned to the manufacturer for replacement at his full cost.
- 6.3 The contractor will individually package each Web Duty Belt System in a plastic bag. Each plastic bag shall contain
  - 1 (one) outer duty belt
  - 1 (one) inner belt
  - 6 (six) keepers in total
- 6.4 The sticker on the outside of each plastic bag shall clearly identifying the size and the materiel master number.
- 6.5 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

## APPENDIX A

### TEST METHODS REQUIRED

**AATCC 8 Colour Fastness to Crocking** 0 to 5 is the test; the requirement is for 4.5

**STOLL Abrasion** Greater than 2,100 cycles

**Taber Abrasion Resistance** (3,000 cycles, H-38 wheels, 500g load)  
Max weight loss 91.1 mg

**Taber Wear Index** 30.4\*

**Tongue Tear Strength, lbf** (average) Warp: 119.5 lbf,  
Filling: 160.3 lbf

\*The Taber Wear Index (rate of wear) is expressed as the loss in mass (in milligrams) per one thousand cycles of abrasion.

**Middle Layer #2** 1/8 inch thick 4 lb Volara Type EO foam

Compression Strength	ASTM D 3575 16 PSI @50%
Shore Hardness	ASTM D 2240 10
Water Absorption	ASTM D 1667 0.04 lbs/sq ft. of cut surface

## Appendix B

### WEB DUTY BELT SYSTEM - BUCKLE

