



# Shirt, "T", Crested, Unisex



## Purchase Description



File no. CBSA/ASFC-2013-05-123  
Date of issue: 2014-04-28

**PURCHASE DESCRIPTION**

**SHIRT, "T" CRESTED, UNISEX**

**1. SCOPE**

This purchase description describes the requirement for materials, design, construction and inspection of a poly/cotton, unisex fit, crested T-Shirt to be used by Border Service Officers (BSO) within the Canada Border Services Agency (CBSA).

**2. GENERAL REQUIREMENTS**

- 2.1. **DESIGN** - The CBSA crested t-shirt is a crew neck style shirt constructed from a dark blue poly/cotton jersey knit. The shirt front shall be embroidered with the CBSA Heraldic Crest, with the Agency signature and Canada Wordmark embroidered on the bottom edge of each sleeve. All T-Shirts shall be constructed in accordance to the attached scale of measurements and drawings which are integral parts of this specification.
- 2.2. All articles or materials covered by this purchase description shall be free from imperfections or blemishes such as may affect its appearance or serviceability.
- 2.3. In the event of any inconsistency in the contract documents, purchase description, drawings, or sealed samples. The aforementioned shall prevail in the following order:
- I) Contract
  - II) Purchase Description
  - III) Drawings
  - IV) Sealed Sample

### 3. SEALED SAMPLE

A sealed sample, identified by the purchase description number noted in the contract, will be supplied to the successful tenderer if available. This will constitute the standard in regards to any properties not identified within. 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. APPLICABLE SPECIFICATIONS

- 4.1. CAN/CGSB, 4.2, Textile Test Methods.
- 4.2. CAN/CGSB 4.131-93, Polyester-Covered Polyester Thread.
- 4.3. CAN/CGSB 4.131-94, Thread, Polyester, Staple Spun.
- 4.4. ISO 4915:1991, Textiles - Stitch Types.
- 4.5. ISO 4916:1991, Textiles - Seam Types.
- 4.6. CAN/CGSB-86.1-M91, Care Labelling of Textiles.

### 5. DETAILED REQUIREMENTS

#### 5.1. MATERIALS

- 5.1.1. **Shell** - As specified in TABLE I attached.
- 5.1.2. **Ribbing** - As specified in TABLE I attached.
- 5.1.3. **Reinforcement Tape** - Shall be shell material as specified in para. 5.1.1, 1- 1.5cm ( $\frac{3}{8}$ " -  $\frac{1}{2}$ ") in width when applied.

- 5.1.4. **Thread** - The thread for all operations shall be dark blue in colour matching the shell material constructed from either polyester core, polyester wrap, R27 Tex meeting CAN/CGSB 4.131-93 or polyester staple spun, R27 Tex meeting CAN/CGSB 4.139-94.
- 5.1.5. **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.

## 6. GENERAL CONSTRUCTION:

- 6.1.1. **Cutting** - The shirt body may be cut with or without side seams as long as finished garment dimensions meet the requirements in the Scales of Measurements. Care shall be taken to cut the material without stretching or skewing to ensure a symmetrical appearance. Cutting on the fold lines is acceptable provided the crease not be visible in the finished garments.
- 6.1.2. **Stitching** - Using the specified thread, there shall be not less than 4 and no more than 5.5 stitches per cm. All stitching shall conform to the specified type outlined in ISO 4915. The construction of the shirt body and sleeve shall be overlock type 512. The stitching at the hem and sleeve hem shall be cover stitch type 406. Stitching on the tape at the shoulder and neck shall be two rows chain stitch Type 401. The beginning and ending of all stitching shall be securely backstitched and tacked unless secured by other stitching. Where seaming, turning and stitching is required the edges shall be properly worked out before stitching. Care shall be taken to minimize unsightly gathering and puckering.

## 7. CONSTRUCTION:

- 7.1.1. **Body** - The front and back panels shall be made from material as specified in para. 5.1.1. The front, back and sleeve seams shall be sewn together using overlock stitch type 512 with a minimum width of 6mm ( $\frac{1}{4}$ " ) seam allowance. The front and back panels shall be sewn together at the shoulder seams and shall be stabilized on each shoulder and at the back of the neckline with a reinforcement tape as specified in para. 5.1.3 to prevent stretching. The reinforcement tape shall be applied after the shoulder seams and neckline have been constructed.

- 7.1.2. **Neckline** - The neckline shall be constructed from one ply of rib material, as specified in para. 5.1.2, folded lengthwise to have a 3cm (1 $\frac{1}{8}$  inch) wide ribbing and serged to the neckline then coverstitched.
- 7.1.3. **Sleeves** - The sleeves shall be constructed from shell material as specified in para. 5.1.1 and set into the arm hole of the shirt. The bottom edge of the sleeves shall be embroidered with the text as specified in the drawings. The hem shall be finished by turning in the raw edge and finishing using a coverstitch Type 406. The completed sleeves shall be equivalent in all respects to the sealed sample.
- 7.1.4. **Joining Sleeve, Underarm and Side Seams** - The join shall be by means of a serged safety stitch Type 512. The sleeve shall be sewn to the armhole first and then the side seam and underarm seam shall be sewn in one continuous seam.

7.2. **EMBROIDERY:**

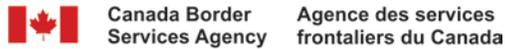
7.2.1. Using the thread as specified in Para. 5.1.5, and colours identified below, the t-shirt shall be embroidered with the CBSA Heraldic Crest, Agency signature and Canada Wordmark. Copies of artwork can be provided upon request to the CBSA Technical Authority. The finished embroidery shall be equivalent to the sealed sample and drawings.

7.2.2. **Embroidery Colours:**

- Blue (background including shield segments): PANTONE 532C
- Grey (shield segments): PANTONE COOL GREY 2C
- Gold (leaves, rope, crown, Latin text, inner shield, portcullis):  
PANTONE 123C
- Red (Canada Flags, crown, red jewel): PANTONE 186C
- Green (green jewel): PANTONE 349C
- Blue (blue jewel): PANTONE 301C
- Black: (highlights, crown outline)
- White: (crown base, circles, accents, Canada Wordmark, Agency Signature)

- 7.2.3. **Sleeve Embroidery:** Shall consist of one of two styles of text. (English-language first and French-language first). The following text shall be embroidered directly onto the shirt sleeve positioned as per the drawings.

Right Sleeve: English-language first



Canada

Left Sleeve: French-language first



Canada

## 8. LABELLING

- 8.1. All labeling must be in a bilingual format. The text on all labels shall be of permanent inks of a contrasting colour which shall remain visible and withstand a minimum of 40 washes.

### 8.2. Identification Labels

- a. Size Designation (as referenced in the contract documents)
- b. Fibre Content
- c. Manufacturers' Name & Contract #
- d. Material Master Number (reference contract documents)

### 8.3. Cleaning Instructions

- a. Machine wash - cold (30°C)
- b. Do not bleach
- c. Tumble dry - low
- d. Steam Iron - medium

## 9. TECHNICAL INSPECTION

The contractor shall be responsible for the performance of all inspections and tests necessary to demonstrate that the materiel and services being supplied conform to the requirements of this purchase description. This may be accomplished by performing the test specified in this purchase description or by demonstrating to the satisfaction of the CBSA Technical Authority, that conformity to the purchase description and manufacturing process is assured. The contractor may use any independent, ISO 9001 certified and ISO 17025 "Textile" certified testing facilities acceptable to the CBSA Technical Authority. Certification documents will be required.

The CBSA Technical Authority reserves the right to perform any inspection considered necessary to ensure the materials 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 fewer than 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 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.

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.

## 10. DELIVERY, PACKING & MARKING OF CONTAINERS

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.

Packing and marking of shipping containers shall be as specified in the invitation to tender.

A packing slip shall be enclosed showing the contents of each shipment.

The contractor shall also identify clearly on the outside of each package (box) the following items.

- Size
- Material Master Number
- Quantity of each size contained in the box
- Contract Number

## 11. APPENDICES

TABLE I - Shell Material Requirements

SCALES OF MEASUREMENTS

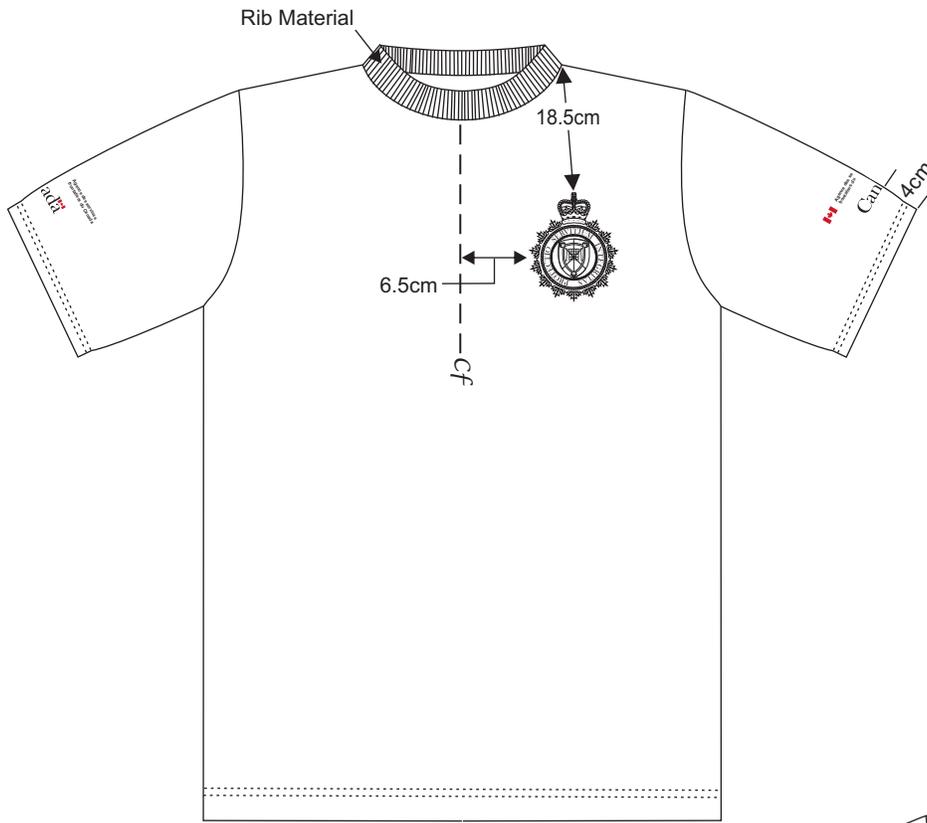
DRAWINGS - Appendix A

TABLE I - SHELL MATERIAL &amp; RIBBING

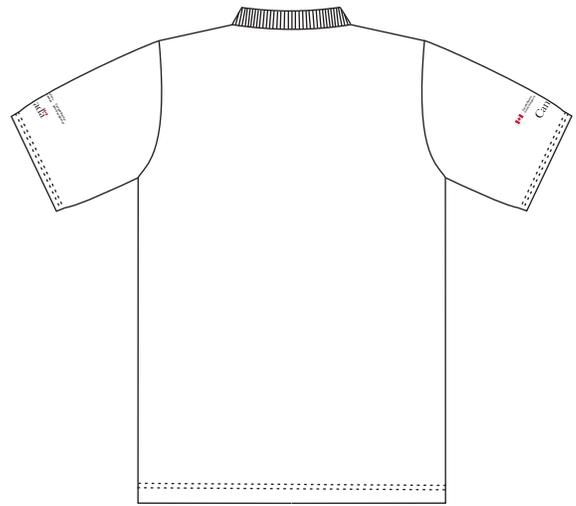
SHELL FABRIC / RIBBING	SPECIFICATION	TESTED BY CAN-2-4.2
Colour	Dark Blue To match sealed sample	
Fiber Content	50/50 Polyester/Cotton	
Knit Construction: Body Neckline	Jersey 1x1 Rib knit	
Mass	180 g/m <sup>2</sup> - 200g/m <sup>2</sup>	Method 5.1-M90
Dimensional Change to Domestic Washing <i>After 5 cycles</i>	Warp 5% (max.) Weft 5% (max.)	Method 58-2004,3,E,2
Colour fastness to Light	Equal to or better than AATCC Standard L4	Method 18.3-97
Colourfastness to Washing	Colour change and staining - Grey Scale 4 or better	Method 19.1-2004 Test #2
Colourfastness to Perspiration	Colour change and staining (Acid & Alkaline) - Grey scale 4 or better	Method 23-M90
Pilling	No less than 3 after 20 minutes	Method 51.2-M87

**SCALE OF MEASUREMENTS - T-SHIRTS, CRESTED, UNISEX**

SIZE DESIGNATION	BODY MEASUREMENTS		GARMENT MEASUREMENTS									
	CHEST		CHEST CIRC. (½ ONLY)		SHIRT WIDTH - At bottom (½ ONLY)		BACK LENGTH - Top of collar to hem		SLEEVE LENGTH - From shoulder to bottom of sleeve cuff		SHOULDER LENGTH	
	INCHES	CM	INCHES	CM	INCHES	CM	INCHES	CM	INCHES	CM	INCHES	CM
X-SMALL	30" - 32"	76.25 - 81.25	16	40.6	16	40.6	27	68.5	6 ¾	17	6	15.25
SMALL	34" - 36"	86.25 - 91.5	18	45.7	18	45.7	28	71	7	17.75	6 ¼	15.75
MEDIUM	38" - 40"	96.5 - 101.5	20	50.8	20	50.8	29	73.5	7 ¼	18.5	6 ½	16.5
LARGE	42" - 44"	106.5 - 111.75	22	55.8	22	55.8	30	76	7 ½	19	7	17.75
X-LARGE	46" - 48"	116.75 - 122	24	61	24	61	31	78.5	7 ¾	19.75	7 ¼	18.5
2X-LARGE	50" - 52"	127 - 132	26	66	26	66	32	81	8	20.25	7 ½	19
3X-LARGE	54" - 56"	137 - 142.25	28	71	28	71	33	83.75	8 ¼	21	7 ¾	19.75
4X-LARGE	58 - 60"	147.25 - 152.5	30	76	30	76	34	86.25	8 ½	21.5	8	20.25
5X-LARGE	62" - 64"	157.5 - 162.5	32	81.25	32	81.25	35	89	8 ¾	22.25	8 ¼	21
DRAWING LOCATION			A		B		C		D		E	
TOLERANCE ±			½	1.3	½	1.3	½	1.3	¼	.6	¼	.6

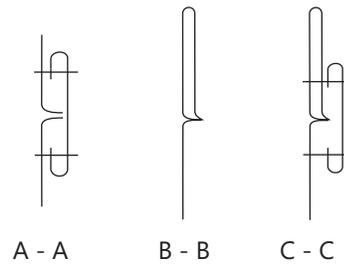
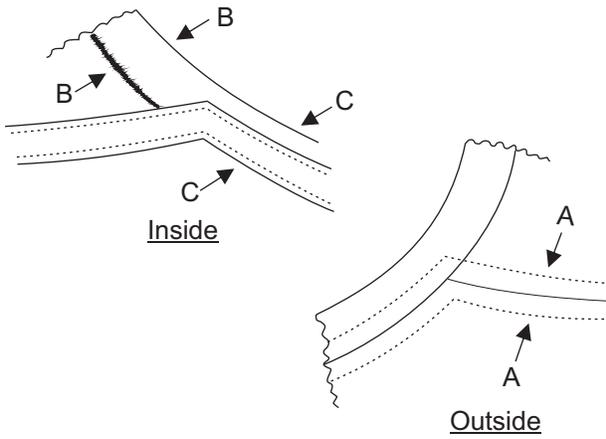


Front View



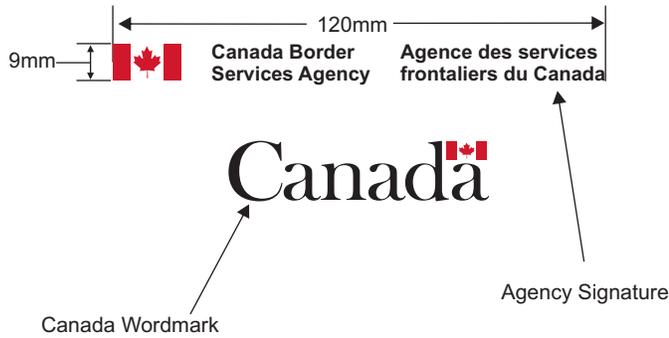
Back View

Shoulder & Neckline Seams

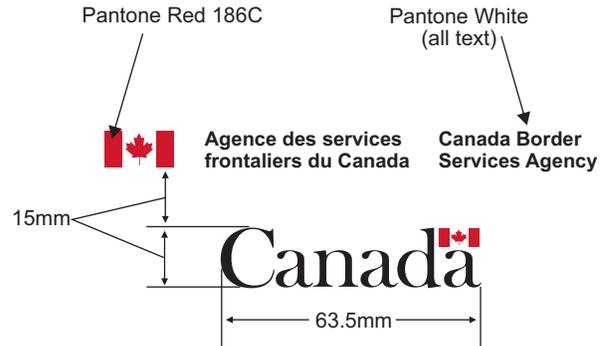


NOT TO SCALE

APPENDIX A  
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 CBSA/ASFC-2013-05-123  
 Dwg 2



Right Sleeve Embroidery  
 (English Language First)

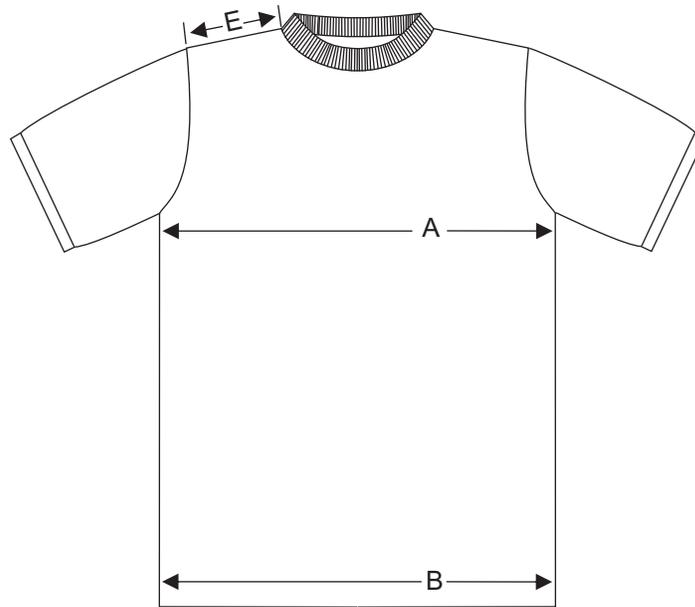


Left Sleeve Embroidery  
 (French Language First)

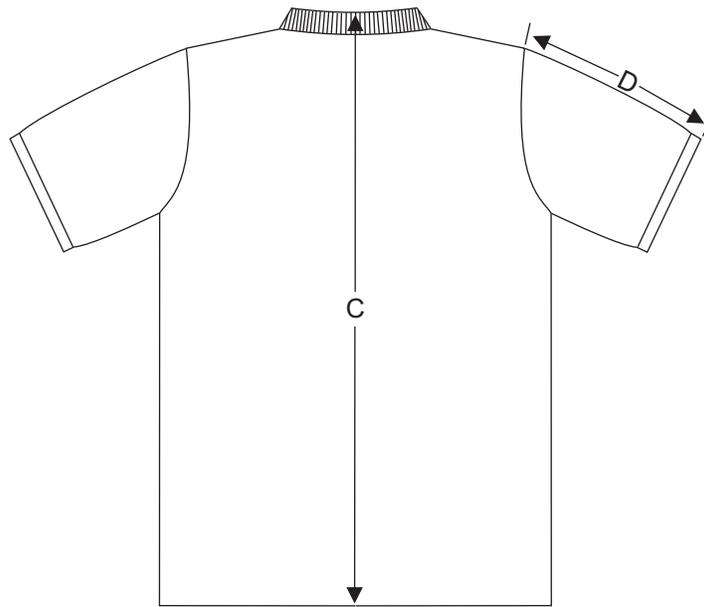


- Blue: Background including shield segments  
PANTONE 532C
- Grey: Shield segments  
PANTONE COOL GREY 2C
- Gold: Leaves, rope, crown, Latin text, inner shield, portcullis  
PANTONE 123C
- Used to identify area in rope outline where no yarn is required
- Red: Canada Flags, crown, red jewels  
PANTONE 186C
- Green: Green jewels  
PANTONE 349C
- Blue: Blue jewel  
PANTONE BLUE 301C
- Black: Highlights, crown outlines
- White: Crown base, circles, accents  
Canada Wordmark, Agency Signature

NOT TO SCALE



Front View



Back View

NOT TO SCALE