



Shoulder Insignia, Large & Small

Purchase Description



File no. CBSA/ASFC-2013-08-128
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PURCHASE DESCRIPTION

SHOULDER INSIGNIA, LARGE & SMALL

1. SCOPE

This purchase description describes the requirement for materials, design, construction and inspection of a large and small size, English and French, woven shoulder insignia to be used by Border Service Officers (BSO) within the Canada Border Services Agency (CBSA).

2. GENERAL REQUIREMENTS

- 2.1. **DESIGN** - The large and small size, English and French shoulder insignia shall be of a woven type badge. This woven shoulder insignia shall be backed with a non-woven fusible, with all outer edges finished with merrow edge stitching. The Shoulder insignia shall be designed in accordance to the attached drawings and sealed sample 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 when 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.

5. DETAILED REQUIREMENTS

- 5.1. **Materials** - 100% polyester equivalent to the sealed samples.

Note: For information purposes, sealed samples are produced from yarns supplied from Formosa Textiles. Equivalent products may be used, provided they resemble all aspects of the sealed samples.

- 5.2. **Warp Yarns:**

- 100 Denier
- Raw black polyester

- 5.3. **Ground Yarns:**

- Dark navy blue
- Weft woven on double
- Total of 736 picks of 75 denier yarn
- Formosa Textile colour #946 is known to meet

- 5.4. **Yarn: Merrowing Edge:**
- 150 Denier
 - Grey; Colour Formosa Textile #817
- 5.5. **Design Yarns:** All design yarns must be equivalent in to the sealed sample. They shall be a combination, as applicable for the individual badges in the following colours:
- 5.5.1. **Grey (Shield segments):**
- PANTONE 2C
 - 100 Denier yarn
 - 162 picks
 - Formosa Textile colour #817 is known to meet
- 5.5.2. **Yellow (Leaves, ropes, Latin text, inner shield, portcullis, crown):**
- PANTONE 123C
 - 150 Denier yarn
 - 442 picks
 - Formosa Textile colour #21172 is known to meet
- 5.5.3. **Red (Canada Flags, crown, jewels):**
- PANTONE 186C
 - 150 Denier yarn
 - 92 picks
 - Formosa Textile colour #11290 is known to meet
- 5.5.4. **Green (Jewels):**
- PANTONE 349C
 - 150 Denier yarn
 - 8 picks
 - Formosa Textile colour #63518 is known to meet
- 5.5.5. **Blue (Jewels):**
- PANTONE 301C
 - 100 Denier yarn
 - 8 picks
 - Formosa Textile colour #322 is known to meet
- 5.5.6. **White (Crown, Canada Wordmark, Agency Signature):**
- PANTONE WHITE
 - 150 Denier yarn
 - 346 picks
 - Formosa Textile colour #00310 is known to meet

- 5.5.7. **Density:**
- Weft - 72 picks per inch
 - Warp - 144 picks per inch
 - Total - 1706 woven picks, 8 colors
- 5.6. **Backing Material:**
- Non-woven fusible
 - 100% Polyester
 - 75 g/m² ± 5%
- 5.7. **Colour Fastness:**
- **To Light** - At least equal to AATCC Standard L5 (CAN/CGSB-4.2 Method 18.3-97)
 - **To Washing** - No more change in shade and no more staining than grey scale 4 (CAN/CGSB-4.2 Method 19.1-M90 Test 2)
 - **To Perspiration** - No more change in shade and no more staining than grey scale 4. (CAN/CGSB-4.2 Method 23-M90)
- 5.8. **Weaving:** 1x3 Twill. Equivalent to the Sealed Sample.
- Note:** For information purposes, sealed samples are woven on a Dornier air-jet loom (Germany). Equivalent products may be used, provided they provide the same appearance.
- 5.9. **Cutting:** The shoulder insignia shall be laser cut to the dimensioned outlined in the drawings and sealed sample. The Agency Signature, Heraldic Crest and Canada Wordmark must be centered within the insignia. The overall shape must be symmetrical and must not be skewed.
- 5.10. **Finishing (Merrow edge):** Applied manually, following the laser contour cut of the badges. The badges shall be finished with a merrow edge, overlapping at the centre bottom. The resulting end tail, shall not be cut off, but glued to the back.
- 5.11. **Overall Dimensions: (reference drawings attached)**
Large: 120mm x 136mm
Small: 108mm x 123mm

- 5.12. **Language Requirement:** Four (4) options: large and small size, English and French. As specified in the contract documents.

OPTION 1 SMALL (English - Drawing 1):	English First French second
OPTION 2 SMALL (French - Drawing 2):	French first English second
OPTION 3 LARGE (English - Drawing 1):	English First French second
OPTION 4 LARGE (French - Drawing 2):	French first English second

6. 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.

7. 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. Within each box, the shoulder insignia shall come packaged in plastic bags in units of 50.

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

8. APPENDICES

DRAWINGS - Appendix A

APPENDIX A
 Shoulder Insignia, Large & Small
 OPTION 1 - SMALL ENGLISH
 CBSA/ASFC-2013-08-128
 Dwg 1



- Blue (Ground Yarns): Background including shield segments
PANTONE 532 C
- Grey: Merrow edge, shield segments
PANTONE COOL GREY 2C
- Yellow: Leaves, rope, Latin text, inner shield, portcullis, crown
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 349 C
- Blue: Blue jewel
PANTONE BLUE 301C
- Black: Highlights, crown outlines
- White: Crown base, circles, accents
Canada Wordmark, Agency Signature

NOT TO SCALE
 All measurements are shown in millimetres.
 Tolerance is $\pm 3\text{mm}$

APPENDIX A
 Shoulder Insignia, Large & Small
 OPTION 2 - SMALL FRENCH
 CBSA/ASFC-2013-08-128
 Dwg 2



- Blue (Ground Yarns): Background including shield segments
PANTONE 532 C
- Grey: Merrow edge, shield segments
PANTONE COOL GREY 2C
- Yellow: Leaves, rope, Latin text, inner shield, portcullis, crown
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 349 C
- Blue: Blue jewel
PANTONE BLUE 301C
- Black: Highlights, crown outlines
- White: Crown base, circles, accents
Canada Wordmark, Agency Signature

NOT TO SCALE
 All measurements are shown in millimetres.
 Tolerance is ± 3 mm

APPENDIX A
 Shoulder Insignia, Large & Small
 OPTION 3 - LARGE ENGLISH
 CBSA/ASFC-2013-08-128
 Dwg 3



- Blue (Ground Yarns): Background including shield segments
PANTONE 532 C
- Grey: Merrow edge, shield segments
PANTONE COOL GREY 2C
- Yellow: Leaves, rope, Latin text, inner shield, portcullis, crown
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 349 C
- Blue: Blue jewel
PANTONE BLUE 301C
- Black: Highlights, crown outlines
- White: Crown base, circles, accents
Canada Wordmark, Agency Signature

NOT TO SCALE
 All measurements are shown in millimetres.
 Tolerance is ±3mm

APPENDIX A
 Shoulder Insignia, Large & Small
 OPTION 4 - LARGE FRENCH
 CBSA/ASFC-2013-08-128
 Dwg 4



- Blue (Ground Yarns): Background including shield segments
PANTONE 532 C
- Grey: Merrow edge, shield segments
PANTONE COOL GREY 2C
- Yellow: Leaves, rope, Latin text, inner shield, portcullis, crown
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 349 C
- Blue: Blue jewel
PANTONE BLUE 301C
- Black: Highlights, crown outlines
- White: Crown base, circles, accents
Canada Wordmark, Agency Signature

NOT TO SCALE
 All measurements are shown in millimetres.
 Tolerance is ± 3 mm