



## PURCHASE DESCRIPTION

### SHIRT, TURTLENECK, UNISEX

#### 1. SCOPE

This purchase description describes the requirement for materials, design, construction and inspection of a 100% cotton, unisex fit, Turtleneck to be used by Border Service Officers (BSO) within the Canada Border Services Agency (CBSA).

#### 2. GENERAL REQUIREMENTS

- 2.1. **DESIGN** - The turtleneck shall be dark blue in colour made from a jersey knit material. The overall design shall be a loose silhouette that incorporates a fold-down turtleneck with long sleeves and knitted cuffs. All turtlenecks shall be designed 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. Dark blue in colour to match the sealed sample.
- 5.1.2. **Ribbing** - As specified in TABLE I attached. Dark blue in colour to match the shell material.

- 5.1.3. **Thread** - The thread for all operations shall be dark navy 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.

## 5.2. GENERAL CONSTRUCTION:

- 5.2.1. **Cutting** - The turtleneck 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.
- 5.2.2. **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 shall be cover stitch type 406. 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.

## 5.3. CONSTRUCTION:

- 5.3.1. **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 to prevent stretching.
- 5.3.2. **Collar** - The collar shall be constructed from one ply of rib material, as specified in para. 5.1.2, folded lengthwise, serged to the neckline then coverstitched. The completed collar shall measure 12cm when unfolded.
- 5.3.3. **Sleeves** - The sleeves shall be constructed from shell material as specified in para. 5.1.1 and set into the arm hole and coverstitched. The sleeve cuff constructed from one ply of rib material as specified 5.1.2, folded lengthwise, serged to the sleeve bottom and coverstitched. The completed cuff shall measure 5cm when finished. The completed sleeves shall be equivalent in all respects to the sealed sample.

- 5.3.4. **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.
- 5.3.5. **Hem** - The bottom of the turtleneck, front and back shall be hemmed by turning in the raw edge and finishing using a cover stitch Type 406. Care shall be taken to ensure that no more than 4mm of raw edges is left uncovered.

## 6. LABELLING

- 6.1. 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.
- 6.2. **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)
- 6.3. **Cleaning Instructions**
  - a. Machine wash - cold (30°C)
  - b. Do not bleach
  - c. Tumble dry - low
  - d. Steam Iron - medium

## 7. 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.

## **8. 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

## **9. APPENDICES**

TABLE I - Shell Material Requirements

SCALES OF MEASUREMENTS

DRAWINGS - Appendix A

TABLE I - SHELL MATERIALS

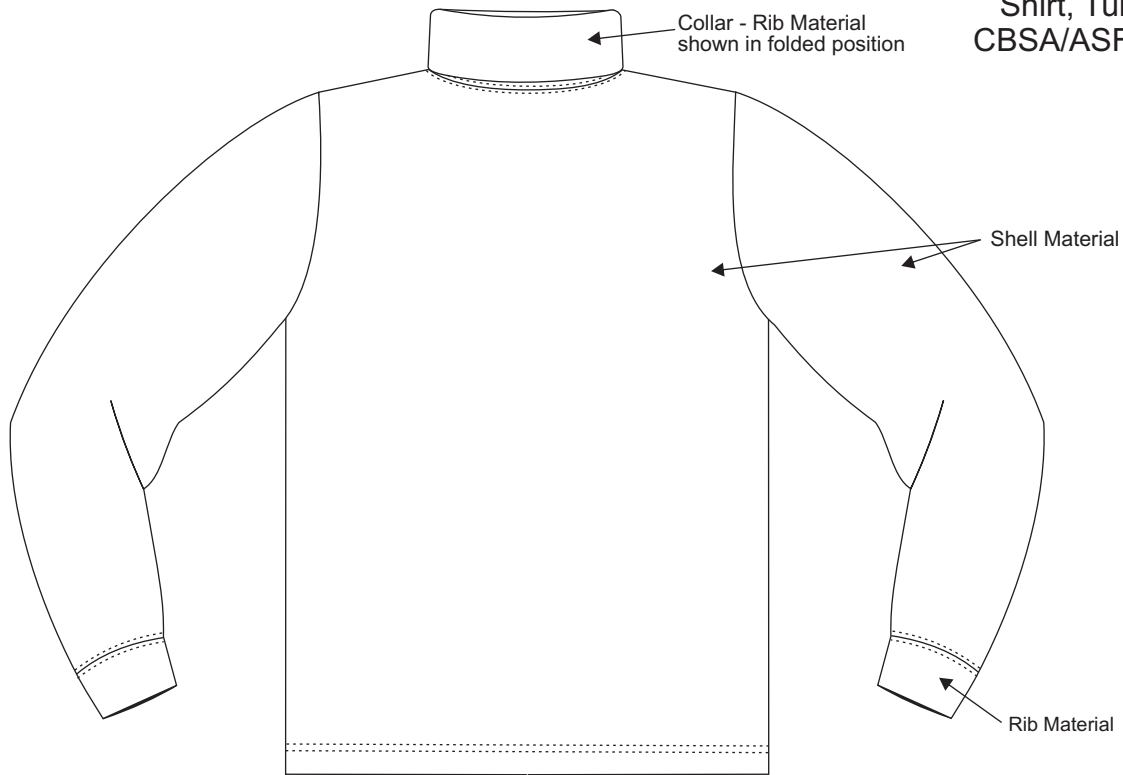
REQUIREMENTS	SPECIFICATION	TESTED BY CAN-2-4.2
Colour	Dark Blue To match sealed sample	
Fiber Content	100% Cotton	
Knit Construction: Body	Jersey	
Knit Construction: Collar & Cuffs	1x1 Rib	
Mass	190 g/m <sup>2</sup> - 210g/m <sup>2</sup>	Method 5.1-M90
Dimensional Change to Domestic Washing <i>After 5 cycles</i>	Warp 5% (max.) Weft 5% (max.)	Method 58-2004,3,E,2
Colorfastness to Light	equal to or better than AATCC Standard L4	Method 18.3-97
Colorfastness to Washing	Colour change and staining - Grey Scale 3 or better	Method 19.1-2004 Test #2
Colorfastness to Perspiration	Colour change and staining (Acid & Alkaline) - Grey scale 3 or better	Method 23-M90
Pilling	No less than 3 after 30 minutes	Method 51.2-M87

**SCALE OF MEASUREMENTS - SHIRT, TURTLENECK, UNISEX**

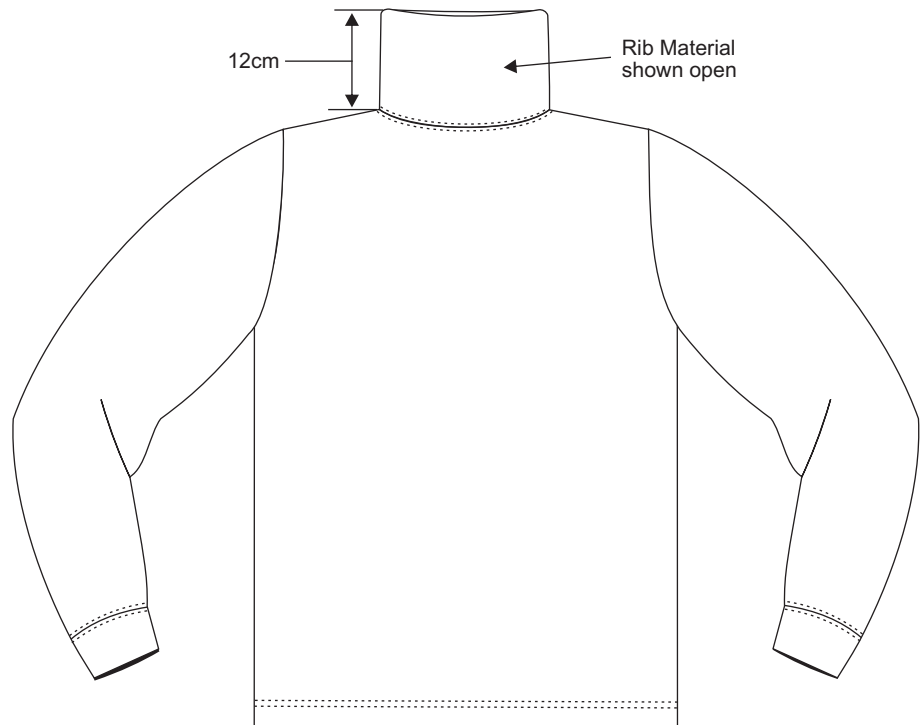
SIZE DESIGNATION	BODY MEASUREMENTS		GARMENT MEASUREMENTS											
	CHEST		CHEST WIDTH (½ ONLY)		SHIRT WIDTH - At bottom (½ ONLY)		BACK LENGTH - From center back neckline to hem		SLEEVE LENGTH - From center back at neck to bottom of sleeve cuff		SHOULDER LENGTH		COLLAR LENGTH (RELAXED)	
	INCHES	CM	INCHES	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	34	86.25	6	15.25	13	33
SMALL	34"-36"	86.25 - 91.5	18	45.7	18	45.7	28	71	34	86.25	6 ¼	15.75	13 ¾	35
MEDIUM	38"-40"	96.5 - 101.5	20	50.8	20	50.8	29	73.5	35	89	6 ½	16.5	14 ½	37
LARGE	42"-44"	106.5 - 111.75	22	55.8	22	55.8	30	76	35	89	7	17.75	15 ¼	38.75
X-LARGE	46"-48"	116.75 - 122	24	61	24	61	31	78.5	36	91.5	7 ¼	18.5	16 ¾	42.5
2X-LARGE	50"-52"	127 - 132	26	66	26	66	32	81	36	91.5	7 ½	19	17 ½	44.5
3X-LARGE	54"-56"	137 - 142.25	28	71	28	71	33	83.75	36	91.5	7 ¾	19.75	18 ¼	46.5
4X-LARGE	58"-60"	147.25 - 152.5	30	76	30	76	34	86.25	36	91.5	8	20.25	19	48.25
5X-LARGE	62"-64"	157.5 - 162.5	32	81.25	32	81.25	35	89	36	91.5	8 ¼	21	19 ¾	50
DRAWING LOCATION			A		B		C		D		E		F	
TOLERANCE ±			½	1.3	½	1.3	½	1.3	¼	.6	¼	.6	¼	.6



APPENDIX A  
Shirt, Turtleneck, Unisex  
CBSA/ASFC-2013-05-122  
Dwg 1

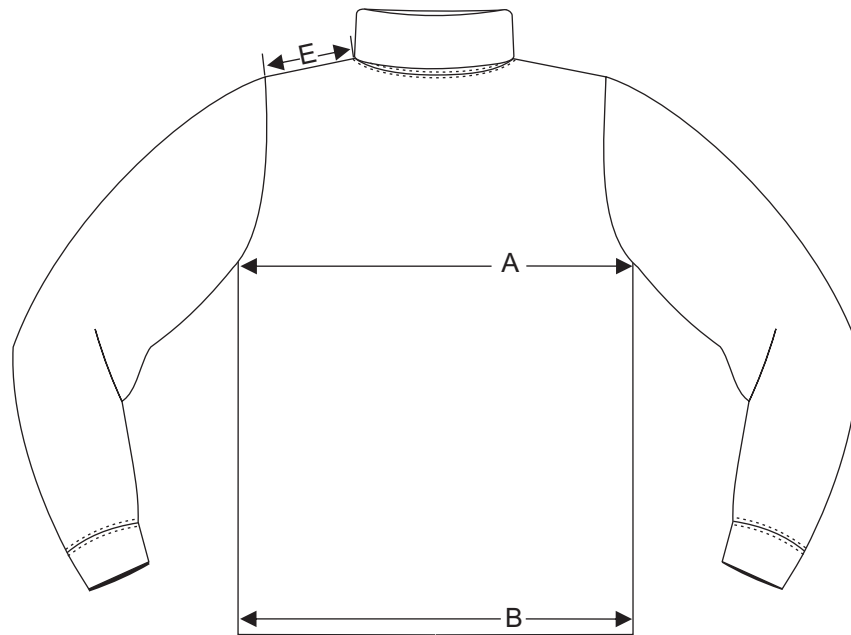


Front View

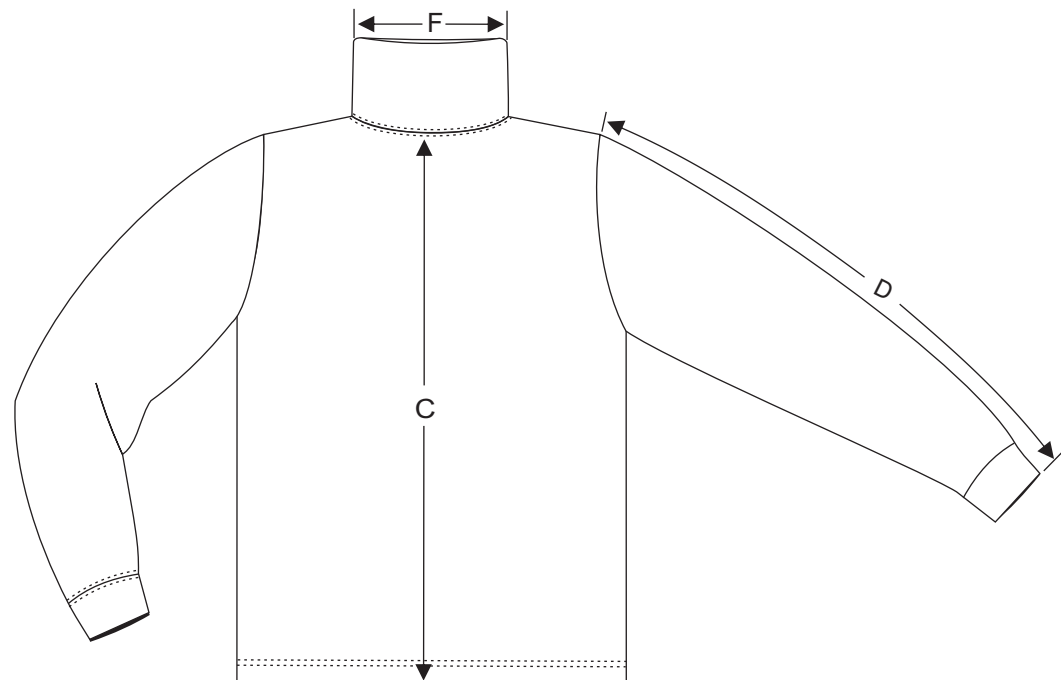


Back View

NOT TO SCALE



Front View



Back View

NOT TO SCALE