



Royal Canadian Mounted Police
Gendarmerie royale du Canada

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Specification

Equipment, Sam Browne

This document has 26 pages including the drawings.

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Français/French

The photograph on this page is for reference only.



Modifications

Date	Para. No's	Modifications
1995-09-20		Original Specification
1996-06-12	Dwg. 5, para. 4.3.3.7	Reinforcement rivet added to holster; para. 4.3.3.7 Renumbered, new para. 4.3.3.7
1997-05-16	Page 6, para. 4.3.3.8	Plug to be glued in bottom; spacer detail added.
1997-05-16	Dwg. 4 and 5	Leather spacer detail added; position of stud moved; belt loop detail and dimensions added
1997-07-04	Paras. 4.3.2.3, 4.3.2.6, and 4.3.2.10, Dwgs. 1 and 2	Removable keepers deleted from specification.
2007-07-11	Para. 4.3.2.1, 4.3.2.8, 4.3.2.10, Dwgs. 1, 2, 3 and 8, Table I added.	Double 'D' ring loop piece replaces separate 'D' ring loops; holster stud hole position adjusted; sliding keeper detail added; handcuff pouch belt loop with added spacer.
2008-09-15	Para. 4.2, Dwg. 3	'Long' Shoulder strap dimension added to specification.
2014-04-25	Paras. 2.2 – 2.5 Para. 4.1.1 Para. 4.1.2 Para. 4.1.3 Para. 4.2 Paras. 4.3.2, 4.3.2.2, 4.3.2.6 and 4.3.2.7 Paras. 4.3.2.7 and 4.3.2.8 Para. 4.3.2.8 Para. 4.3.2.10 Paras. 4.3.4.3, 4.3.5.3 Para. 5 (deleted) Table I (new) Scale of Measurements Drawings #2 and 3 Drawings # 9 and 10 All Drawings Appendix A	New ASTM and thread standards. Leather and Certification of Compliance requirements. New Table I for characteristics Thread requirement and Certification of Compliance. Items 3 and 7 added to list of RCMP-supplied hardware. Shoulder Strap size reference added to Para. 4.3.2.7. Double 'D' ring loop piece reference added. Paras. 4.3.2.7 and 4.3.2.8 combined, following paragraphs renumbered. Dimension definitions added. Marking details amended. Four shoulder strap sizes specified, and new marking added. Shoulder strap removable loop paragraph added. Bevelling detail amended. Para. 5 deleted, Para. 6 renumbered. Leather characteristics. Dimensions for shoulder strap and belt sizes added. Measurement details amended; shoulder strap detail amended; removable loop details added. Dimension identifiers changed to 'E' and 'F' Tolerances added. Imperial measurements deleted. Certification and evaluation criteria added.
2014-05-02	Para. 4.1.3	Item 3 name corrected to 'Buckle, Loose Roller, Single Prong'.

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 and 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

1. Definition

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

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** - The design shall be a military-style Sam Browne belt complete with shoulder strap, pistol holster, handcuff pouch and double magazine holder as shown in the attached drawing, forming part of this specification and the viewing sample.

- 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 **Materials**

- 4.1.1 **Leather** – The leather shall be 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 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 fast. The colour shall match the viewing sample. Unless otherwise stated, the thickness shall be from 2.7 to 3.5 mm. See Table I below for leather characteristic requirements.
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
3	Buckle, Loose Roller, Single Prong
5	'D' Ring, Large
7	Swivel, Snap
10	Stud, Round Head, Flange
12	Fastener, Snap
Items 1, 2, 3 and 7 are to be purchased from the RCMP. All other items shall be acquired by the manufacturer.	

4.2 **Size and Dimensions** - Equipment, Sam Browne to this specification shall be supplied in the sizes specified by the R.C.M.P. and to the dimensions given in the Scale of Measurements and attached drawings forming part of this specification, and the viewing sample.

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 two nor more than three stitches per centimetre.

4.3.1.2 **Cutting** - The component leather parts of the Sam Browne shall be cut from the leather specified in para. 4.1.1. The belt and shoulder strap shall be cut parallel to the backbone of the "back". The pattern dimensions for all components shall be strictly in accordance with the applicable drawings. Care shall be taken to see that the best part of the leather is cut into the belt and shoulder strap. Loose or pipy leather will not be accepted.

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

4.3.1.4 **Stud Retainers** - All studs shall be secured by the use of a circular piece of leather stitched to the backside of the leather, unless secured by other layers of leather, in accordance with the viewing sample.

4.3.1.5 **Sealing** - All open flesh parts of the leather shall be sealed with "Super-Clear Lacquer".

4.3.2 **Belt, Shoulder Strap and Double 'D' Ring Loop Piece**

- 4.3.2.1 **Skiving** - The claw end of the belt shall be taper skived to reduce the end to a thickness of 2.4 to 2.6 mm. The skiving shall start at the back end of the claw. The buckle end of the shoulder strap shall be taper skived to reduce the end to a thickness of 2.4 to 2.6 mm. The skiving shall start approximately 4 cm beyond the back end of the buckle tongue slot. The shoulder strap shall come with two sliding keepers, which shall be skived to a thickness of 2.4 to 2.6 mm and shall have a pre-assembly length of 6.3 cm to ensure a good friction fit on the shoulder strap.
- 4.3.2.2 **Bevelling** - The belt, shoulder strap and double 'D' ring loop piece 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.
- 4.3.2.3 **Creasing** - Each edge of the shoulder strap shall be creased on the grain side. The crease shall be not less than 1 mm nor more than 1.2 mm in width and shall be located 3 mm, +/- 1 mm from the edges. The curved end portion of the shoulder strap shall be creased as per the viewing sample.
- 4.3.2.4 **Belt Lining** - The belt shall have a leather lining 0.8 mm to 1 mm in thickness, of a type of 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.
- 4.3.2.5 **Stitching** - The stitching shall be lockstitch using the thread specified in para. 4.1.2. The assembled belt and shoulder strap shall be stitched in accordance with Drawings #1, 2 and 3 and the viewing sample.
- 4.3.2.6 **Edge Finishing** - All edges, including those of the Double 'D' ring loop piece, shall be stained and filled with a wax type of matching brown edging ink and then burnished to a solid smooth and durable edge. Lacquer or varnish type edge finishes shall not be used.
- 4.3.2.7 **Size and Dimensions** - The dimensions of finished belts, shoulder straps and Double 'D' ring loop pieces shall conform to the Scale of Measurements, Drawings # 2 and 3, and the viewing sample. All loops which the belt passes through shall be sized to be compatible with the thickness of the finished belt. The finished belt shall extend 26 cm beyond the third double prong holes for all sizes. There shall be five double prong holes spaced 3.8 cm, +/- 1.5 mm apart. There shall be three single stud holes spaced 3.8 cm, +/- 1.5 mm apart used for holster placement. There shall be four sizes of Shoulder Strap - Small, Medium, Large and Extra Large - dimensioned and sized in accordance with the Scales of Measurements and Drawing #3.

The following dimensions shall be defined as:

Dimension 'A' – Shall be the distance from the edge of the belt to the third set of double buckle prong holes.

Dimension 'B' – Shall be the distance on the belt from the middle set of double prong holes to the third holster stud hole furthest from the tongue end of the belt.

Dimension 'C' – Shall be the distance on the shoulder strap from the top roller buckle prong hole to the stud hole used to attach the removable loop.

Dimension 'D' – Shall be the distance on the shoulder strap from the middle slot to the first roller buckle hole.

Dimension 'E' – Shall be the distance on the double magazine pouch from the centre of the male portion of the snap fastener to the bottom edge of the double magazine pouch.

Dimension 'F' – Shall be the inside depth of the magazine pocket of the double magazine pouch.

- 4.3.2.8 **Marking** - 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. Shoulder strap sizes, Small, Medium, Large and Extra Large, shall be legibly stamped on the flesh side of the shoulder strap leather, using the upper case letters 'S/P' for Small, 'M' for Medium, 'L/G' for Large and 'XL/TG' for Extra Large.
- 4.3.2.9 **Assembling** - The claw shall be carefully and correctly assembled on the belt as shown in the drawing. There shall be a riveted type stud positioned at the claw end of the belt in accordance with Drawing #2. Using the thread specified in para. 4.1.2, the buckle backing shall be securely stitched to the belt. The stud shall be attached to the tab of the shoulder strap with one row of stitching as shown in the drawing and the buckle and swivel snap assembled on the shoulder strap. The Double 'D' ring loop piece shall be assembled in accordance with Drawing #2 and the ends of each loop stitched together with two rows of stitching.
- 4.3.2.10 **Shoulder Strap Removable Loop** – There shall be three sizes of removable loop available for the shoulder strap. It shall be dimensioned as per Drawing #3.
Note: All Equipment, Sam Browne shoulder straps will come equipped with the Standard Size Removable Loop only.

4.3.3 **Pistol Holster**

- 4.3.3.1 **Design** - The design shall be the same in all respects to Drawings #4 and 5 and the viewing sample. The holster must securely hold a Smith and Wesson model No. 5946 semi-automatic (full size) pistol or a Smith & Wesson model 3953 semi-automatic (compact size) pistol. It shall be available in right or left hand configuration and shall be equipped with a fastener for flap closure.
- 4.3.3.2 **Bevelling** - The finished holster's edges shall be bevelled on both sides all around, in accordance with the viewing sample, with a bevel of 1 mm in width, with a plus tolerance of 0.5 mm.
- 4.3.3.3 **Creasing** - The flap and top edges of the holster belt loop shall be creased on the grain side. The crease shall be not less than 1 mm nor more than 1.2 mm in width and shall be located 3 mm, +/- 1 mm from the edges, in accordance with the viewing sample.
- 4.3.3.4 **Edge Finishing** - All edges shall be stained and filled with 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.
- 4.3.3.5 **Stitching** - The stitching shall be lockstitch using the thread specified in para. 4.1.2. The assembled holster shall be stitched in accordance with Drawings #4 and 5 and the viewing sample.
- 4.3.3.6 **Dimensions** - The dimensions of the assembled holster shall conform to Drawings #4 and 5 drawing and the viewing sample.
- 4.3.3.7 **Reinforcements** - The top corner of the rear edge of the holster shall be reinforced with a two-piece type brass rivet, positioned in accordance with Drawing #5 and the viewing sample.
- 4.3.3.8 **Assembly** - The 'D' rings shall be assembled on the holster body and stitched in place with one row of stitching in accordance with the drawing. The stud shall be positioned on the holster and attached with one row of stitching. The fastener specified in para. 4.1.3 for flap closure shall be the extra firm type, positioned in the holster body and flap and securely set. The holster shall be closed with one row of stitching and the plug inserted and glued in the holster bottom. There shall be a spacer made of 2 layers of leather specified in para. 4.1.1, minimum 1 cm total thickness, stitched to the inside of holster body closest to the wearer's body shaped and designed as per Drawing #5 and the viewing sample to protect the pistol magazine release button from being activated accidentally. There shall be a leather welt inserted on the rear edge seam of the holster, minimum thickness 1 cm, shaped and designed as per viewing sample to hold the pistol in the correct position in the holster.

4.3.4 **Handcuff Pouch**

- 4.3.4.1 **Design** - The design must be similar in all respects to Drawings #6, 7, and 8 and the viewing sample.
- 4.3.4.2 **Skiving** - The leather in the moulded portion of the handcuff section shall be 2.2 mm to 2.8 mm in thickness.
- 4.3.4.3 **Bevelling** - The finished case's edges shall be bevelled on both sides all around in accordance with the viewing sample, with a bevel of 1 mm in width with a plus tolerance 0.5 mm.
- 4.3.4.4 **Creasing** - The flap, top edge of the handcuff section and all around the belt loop shall be creased on the grain side. The crease shall be not less than 1 mm nor more than 1.2 mm in width and shall be located 3 mm, +/- 1 mm from the edges in accordance with Drawing #6 and the viewing sample.
- 4.3.4.5 **Edge Finishing** - All edges 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.
- 4.3.4.6 **Stitching** - The stitching shall be lockstitch using the thread specified in para. 4.1.2. The assembled pouch shall be stitched in accordance with Drawings 6 and 7 and the viewing sample.
- 4.3.4.7 **Dimensions** - The dimensions of the assembled handcuff pouch shall be in accordance with Drawings #6, 7 and 8 and the viewing sample.
- 4.3.4.8 **Reinforcements** - The top two corners of the belt loop and both corners of the handcuff section shall be reinforced with a two piece type brass rivet, positioned in accordance with Drawings #6 and 7 and the viewing sample.
- 4.3.4.9 **Moulding** - The leather in the handcuff section shall be moulded to conform to the shape of the viewing sample.
- 4.3.4.10 **Assembly** - The belt loop shall be assembled on the combined back and flap and attached with one row of stitching top and bottom. There shall be spacers top and bottom of the loop. The snap fastener specified in para. 4.1.3, for flap closure shall be positioned in the body and flap and securely set. The assembled handcuff section body, fully moulded, shall be attached to the combined back and flap with one row of stitching.

4.3.5 **Double Magazine Holder**

- 4.3.5.1 **Design** - The double magazine holder shall come in two separate designs: Type I (full size magazines) to hold two magazines for the Smith & Wesson model no. 5946 semi-automatic pistol, and Type II (compact size magazines) to hold two magazines for the Smith & Wesson model 3953 semi-automatic pistol. It shall be equipped with flap closure.
- 4.3.5.2 **Skiving** - The leather in the side and bottom piece shall be 1.6 mm to 2.0 mm in thickness.
- 4.3.5.3 **Bevelling** - The finished pouch's edges shall be bevelled on both sides all around in accordance with the viewing sample, with a bevel of 1 mm in width with a plus tolerance of 0.5 mm.
- 4.3.5.4 **Creasing** - The flap and side edges of the belt loops shall be creased on the grain side. The crease shall be not less than 1 mm nor more than 1.2 mm in width and shall be located 3 mm, +/- 1 mm from the edges in accordance with Drawing #9 and the viewing sample.
- 4.3.5.5 **Edge Finishing** - All edges 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.
- 4.3.5.6 **Stitching** - The stitching shall be lockstitch using the thread specified in para. 4.1.2. The assembled pouch shall be stitched in accordance with Drawing #9 and the viewing sample.
- 4.3.5.7 **Dimensions** - The dimensions of the assembled double magazine holder shall be in accordance with Drawings #9 and 10 and the viewing sample.
- 4.3.5.8 **Assembly** - The belt loops shall be assembled on the combined back and flap and attached with two rows at the top and one row of stitching at the bottom. The snap fastener specified in para. 4.1.3 for flap closure shall be positioned in the body and flap and securely set. The combined back and flap, and front shall be attached to the combined side and bottom piece by one row of stitching in accordance with Drawing #9 and the viewing sample. The holder shall have a piece of leather added to the inside and stitched as per Drawing #10 and the viewing sample in such a manner as to create an inner sleeve that will hold both magazines securely in place.

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 and

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 and 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 and Equipment Program,

- 5.2 The R.C.M.P., Uniform and 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.

Table I
Leather Requirements

Property	Requirement	Test Method
Crocking	'Good'	ASTM 5053-03 [2009]
Cracking, 11mm mandrel	None	ASTM D6075-13
Grain Crack index, at RH of 65%	25 psi min.	ASTM D2210-00 [2012]

Certificate of Compliance required.

Scales of Measurements

Belt Length & Holster Stud Hole Measurement

Belt Size	Dimension “A” cm	Dimension “B” cm
26	65.25	25
28	70.25	30
30	75.5	
32	80.5	
34	85.5	
36	90.75	35
38	95.75	
40	100.75	
42	106	
44	111	40
46	116	
48	121	
50	126.25	
52	131.25	45
54	136.25	
56	141.5	
Tolerance	+/- 0.5cm	+/- 0.25cm

Shoulder Strap

Shoulder Strap Size	Dimension “C”	Dimension “D”
Small	64 cm	12cm
Medium	74 cm	15cm
Large	84 cm	21.5cm
Extra Large	94cm	28cm
Tolerance	+/- 0.25cm	

Appendix A

Certification and 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 and 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 document, as a signed and dated certification to confirm that a specified component (e.g. slide fastener, hook and loop, webbing, thread etc.) or requirement adheres to the specification. The certification must be prepared, signed and dated by an official representative of the component manufacturer using company letterhead making reference to the specification number and paragraph number. It must specifically address the component or requirement and compliance can be shown by referring to a part number, by providing the component values, by providing a manufacturing data sheet to show technical compliance or by a description stating compliance to the requirement. In-house testing is acceptable to show compliance. Copying the specification word for word is not acceptable.

A separate certificate of compliance is required for each individual component or requirement. Multiple components supplied by the same component manufacturer may be submitted on one certificate of compliance as long as the paragraph numbers and components are clearly identified. With this document, the bidder certifies that the product for which the certificate of compliance is 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.

The Bidder is to note that copies of invoices, purchase orders, packing slips and certificates of compliance for products or components that are not manufactured by the certifier are not suitable for use as a certificate of compliance.

Test Report: Test report documents signed and dated by an independent, third-party accredited laboratory acceptable to the RCMP shall include the test method, test conditions and test results performed to verify requirements as specified in this specification.

Certification and Evaluation Criteria

Para. Title/Test	Certification of Compliance	Test Report	Pass/Fail
Leather (Para. 4.1.1)	Required		
Leather (Table I)	Required		
Thread (Para. 4.1.2)	Required		