



Royal Canadian Mounted Police
Gendarmerie Royale du Canada

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Purchase Description

Shoes, Oxford, Black

This document has 9 pages including the drawings.

This document was created in English.

The document is available in English and French.

English/Anglais
Français/French

The photograph on this page is for reference only.



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 & 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.

PURCHASE DESCRIPTION

SHOES, OXFORD, BLACK

1. **SCOPE**

This purchase description describes the requirements for "Shoes, Oxford, Black" for use by Royal Canadian Mounted Police personnel.

2. **DETAILED DESCRIPTION**

2.1 **General Requirements** - Shoes, Oxford, Black, shall be a Balmoral-style dress Oxford shoe, with toe cap, 5 pairs of eyelets, leather outsole and half rubber heel, as shown in the viewing sample and in Drawing No. 1. It shall be available in male and female, full and half sizes.

2.2 **Manufacture** - The shoes shall be made with a full or three quarter Goodyear welt, on a United last No. 84 or equivalent. United last 436 is an acceptable last for female Oxford shoes.

2.3 **Basic Dimensions** - The height of the upper shall be 7 cm, with a plus tolerance of 1.5 mm, when measured from the heel seat at the back after lasting. All dimensions referred to in this purchase description are for male size 8D. All other sizes and widths shall be in correct proportion.

2.4 **Upper Leather** - The Upper Leather shall be high quality, firm French black calf as per the viewing sample. The vamp shall be cut from the best portion of the butt and have a minimum thickness of 1.45 mm and a maximum of 1.65 mm; the toe cap to be 1.7 mm minimum to 2.0 mm maximum. Vamp and toe cap shall be free from open or healed-over scratches or other grain damage. Quarters and tongues shall be cut adjacent to the vamp and from parts of the shoulder that are not hinged and are free from excessive fat wrinkles. Quarters and tongues shall have a minimum thickness of 1.3 mm and a maximum of 1.65 mm. Light well-healed over scratches that do not affect serviceability or appearance shall be acceptable for the quarters and tongues.
Certification of Compliance for the calfskin leather is required.

2.5 **Vamp Lining, Quarter Lining, Eyelet Facings and Tongue Lining** - The vamp and quarter lining, eyelet facings and tongue lining shall be full grain bovine leather, cut from the side, shoulder or bellies, black or light brown in colour, colourfast to perspiration. Vamp lining shall be between 1.0 and 1.10 mm thick. Quarter lining, eyelet facings and tongue lining shall be between 1.0 mm and 1.4 mm thick. Counter pocket lining shall be split leather, between 1.2 mm and 1.4 mm thick. Light well-healed over scratches and grub holes that do not affect serviceability and appearance will be acceptable.

2.6 **Quarter Doublers** - The doublers shall be cut from an unbleached, plain weave, cotton flannelette, napped on one side. The fabric shall be free from starch, glue or other water soluble

sizing materials. It shall show no growth of fungus when subjected to the test shown in Method 28.4-91 of CAN/CGSB-4.2 'Resistance to Micro-organisms'.

Certification of Compliance is required.

- 2.7 **Insoles** - Shall be Summumtex® (manufactured by Texel) with cowhide leather covering 1 mm thick, attached by stitching and suitable adhesive. Combined thickness shall be 6.0 - 6.2 mm. Products other than the above may be considered if they can be shown to be equivalent or superior in performance, and information on the alternate material must be provided to the RCMP.

Certification of Compliance is required.

- 2.8 **Soles** - First quality bends, graded as 'number one scratch', minimum thickness of 5 mm and maximum of 6 mm. Slipsoles to be cut from firm but pliable shoulders, minimum thickness of 4 mm to maximum 4.5 mm. Welting leather to be of an appropriate thickness and quality.

- 2.9 **Bottom Filler** - The bottom filler shall be granulated cork bonded by a waterproof and thermosetting plastic binder that is free from any material subject to rapid deterioration with age. The weight of the cork shall be not less than 50 nor more than 52 kilos per cubic meter. The filler shall be compatible with the specified soling adhesive and shall not stain nor bunch and shall retain flexibility throughout the life of the shoe. The cantilever movement between the filler and the outsole shall not cause squeaking. **Such noise will be considered grounds for rejection.**

Certification of Compliance is required.

- 2.10 **Counters** - Material for counters shall be reconstituted leather fibre sheet, made with suitable binders. Other materials may be considered provided they meet with the approval of the Uniform & Equipment Program of the RCMP. Counters shall not bulge or cause a warping of the quarters along their forward edges. **Such bulging will be considered grounds for rejection.**

- 2.11 **Box Toes** - To be of high quality material, thickness to be 1.40 mm +/- 0.1 mm. Box toes of pyroxylin or styrene-butadiene type shall be acceptable. The box toe shall be skived to a feather edge across the front with a 13 mm 'scarf'.

- 2.12 **Rubber Heel Top** – 13 mm in thickness, black in colour.

- 2.13 **Welting** - Shall be of first quality squared doubled shoulders, welting tannage. It shall be firm but flexible, with no soft, spongy or loose fibred leather accepted. No hide or mechanical defects shall be allowed. Thickness 3.2 to 4.0mm, width a minimum of 14.4mm.

- 2.14 **Heel Pads** - The heel pads shall have a minimum thickness of 0.8 mm and a maximum of 1 mm, natural or light russet in colour. Each heel pad shall have a cushioning foam interlining, 2.5 mm, +/- 0.1 mm, thick, securely and permanently glued to the insole and heel pad so as to prevent movement during wear.

- 2.15 **Shanks** - The shanks shall be steel type, suitable in length for each size.

- 2.16 **Laces** - The laces shall be braided flat tube type, 6.25 mm wide maximum, 100% polyester material or poly/cotton blend, length as appropriate, equivalent to the viewing sample.
- 2.17 **Eyelets** - The eyelets shall be made from aluminium sheet, 0.5 ± 0.04 mm in thickness. The inside barrel hole diameter before setting, shall be $3.4 \text{ mm} \pm 0.07$ mm. The outside diameter of the flange shall be $7.5 \text{ mm} \pm 0.07$ mm. The barrel shall be of sufficient length to produce a firm split clinch on the eyelet facing.
3. **Construction**
- 3.1 **Skiving** - The top edges of the quarters shall be skived, cemented and turned in with a fold that is not less than 4 mm or more than 5 mm in width. The lower front edges of the quarters shall be skived. The edges of the tongue and wings of the vamp shall be skived having an approximate width of 5 mm. The top, front, lower and side joining edges of the quarter linings shall be skived having an approximate width of 4 mm.
- 3.2 **Stitching** - All upper stitching shall be lockstitch. The lock shall be positioned approximately 3/4 down from the surface. Not less than four nor more five stitches per centimetre shall be used. The quarters shall be butted and seamed at the back with one row of stitching. Three to four rows of stitching shall be used for the box toe and the attachment of the upper to the vamp. Single or double rows for the eyelet, tongue and opening stitching shall be used.
- 3.3 **Eyelets** - There shall be five pairs of eyelets, as specified in para. 2.17, in each quarter. The eyelets shall be positioned 10 mm from the edge of the quarter to the centre of the eyelet with a plus tolerance of 1.5 mm. The top and bottom eyelets shall be placed approximately 12 mm from the top and bottom edges of the quarters and the remainder spaced evenly between the two. All eyelets shall be smoothly and firmly clinched on the eyelet stay.
- 3.4 **Welting** - The welting shall be sewn level and close to the shoulder of the channel with the welt thread positioned at the root of the shoulders. Dropped or broken stitches, broken or torn channel lips will not be accepted. There shall be not more than one joint in the welting for each shoe. Tension on the stitches shall be tight. The ends of the welt shall be trimmed with a $16 \text{ mm} \pm 1.5$ mm bevel, pulled in, tacked down and pounded. The welt shall be beaten out while in temper.
- 3.5 **Sole Stitching** - The outsoles shall be stitched to the welt by lockstitching in a groove on the outsole. The threads shall be thoroughly coated with hot wax. The number of stitches per 2.5cm shall be not less than six nor more than seven. The lock shall be positioned in the outsole approximately 1/3 of the way below the grain surface. Tight tension shall be used on the thread. The stitching shall be placed only sufficiently far from the edge to allow the edge-trimming operator to shape the edges without cutting into the stitches. The sole stitching shall continue to at least 10mm back of the breast of heel (unless the shoe is 100% welted). The stitches shall be neatly and lightly separated with the use of a stitch-separating machine. Sole stitching shall be inked in black on welt side. Welt and stitches shall be cleaned and brushed.

- 3.6 **Heeling** - The heelbase shall be nailed to the outsole. The rubber heel shall then be nailed to the heelbase with a minimum of seven (7) heeling nails. All tacks or nails shall be smoothly clinched so there will be no roughness when felt by hand.
- 3.7 **Heel Finishing** - The heels shall be square trimmed to provide an extension of 1.5 mm all around the heelseat, with a plus tolerance of 1 mm. Heels and soles shall tread flat. The heel part of the outsole shall be stained black. The rubber heeltop edges shall be cleaned from stain or wax and left natural.
- 3.8 **Sole Edges** - Sole edges shall be trimmed in pairs, square around the forepart and shank, in and out, with a custom cutter to provide an extension $4 \text{ mm} \pm 1 \text{ mm}$ on the inside forepart, and gradually increasing around the toe and outside forepart to $6 \text{ mm} \pm 1 \text{ mm}$ at the outside ball. Joints shall be cut and lined up straight and level with the heel. No ragged or wavy edges will be accepted. The all around welt option shall have a maximum $6 \text{ mm} \pm 1 \text{ mm}$ extension. The sole edges shall be filled with best quality filler and shall than be inked in with best quality black edging ink, to produce solid smooth edges. The edges shall be padded and brushed to a bright finish.
- 3.9 **Uppers** - The uppers shall be thoroughly cleaned, then dressed with one light coat of black semi-bright dressing. No filler shall be used on uppers. The counter pocket shall be lined with a split leather lining, flesh side out. The counter and the back of the shoe shall be sufficiently and properly shaped so as to hold the heel of the wearer in the shoe during walking. **Oxford shoes that are not sufficiently well shaped to hold the heel in place may be rejected.**
- 3.10 **Marking of Uppers** - The size and width of the shoe (e.g. 8E), the manufacturer's identification, and the RCMP stock number shall be inscribed on the inside quarter lining near the top with an indelible and contrasting ink. The letters and numerals shall be at least 6 mm in height. A label with the information indelibly and permanently marked in black letters on white label material may also be used.

Appendix A

Certification & Testing 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 & Equipment Program to ensure proper documentation is received and meets the requirements outlined in this specification.

Certification of compliance: Compliance certification documents must be based on testing from a raw goods manufacturer from an in-house or independent, third-party accredited laboratory acceptable to the RCMP to verify performance requirements as specified in this specification or where indicated an invoice from the raw good supplier is also acceptable.

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

Certification & Evaluation Criteria

Para. Title/Test	Certification of Compliance	Test Report	Pass/Fail
Upper Leather (Para. 2.4)	Required		
Quarter Doubler (Para. 2.6)	Required		
Insole (Para. 2.7)	Required		
Bottom Filler (Para. 2.9)	Required		