



Royal Canadian Mounted Police  
Gendarmerie Royale du Canada

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# Specification

## Belt, Waist, Leather

This document has 9 pages including the drawing.

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.



## Modifications

Date	Para. No's/N <sup>o</sup> de par.	Modifications
1983-09-22	Page 5, para. 4.3	3 sizes added.
1989-04-18	Page 3, paras. 4.1.1.6	Colour changed to black.
2004-11-09	Para. 4.1.1.6	Flesh side to natural or black in colour.
2007-09-25	Para. 4.1.4, Dwg. 1	Buckle dimension
2014-09-02	Para. 1.1 Para. 1.4 Paras. 2.2 - 2.5 Para. 3.2 (new) Para. 3.3 (deleted) Paras. 4.1.1, 4.1.1.2, 4.1.1.3, 4.1.1.4 Para. 4.1.2  Paras. 4.1.4, 4.1.4.1  Para. 4.4.3 Para. 4.4.5 Para. 5 (deleted) Dwg. 1  Appendix A added	RCMP stock number added. New paragraph – Translation. New leather and thread standards. Design paragraph added. Paragraph deleted. Leather requirements amended; Certificate of Compliance required. New thread requirement; Certificate of Compliance required. Buckle detail amended; Certificates of Compliance required for metal content and finish. Creasing distance tolerance added. Stitch count added. Para. 5 deleted, following paragraphs renumbered. Measurement tolerances added; dimension detail amended. Appendix A, Certifications of Compliance.
2015-07-03	Para. 2.4 (Deleted) Para. 3.2 Paras. 4.1.1, 4.1.1.1, 4.1.1.2, 4.1.1.3 and 4.1.3(Deleted)  Para. 4.1.4.1 (Deleted) Para. 4.4.1 to 4.4.4 (Combined)  Para. 4.2 Para. 4.4.5  Para. 4.5 (Deleted) Para. 5 (Deleted) Appendix A (Deleted)  Scale of Measurements (New)	Removed non-applicable Test Method. Reworked design description. All leather properties for belt and keeper were combined into Leather para. 4.1.1 & Table 1(added). Subsequent para. renumbered. All buckle requirements were joined into para. 4.1.3 Skiving, beveling, creasing and edge finishing were grouped into para. 4.3.1 entitled Cutting & Finishing. Size and Dimensions para. modified. Renumbered/Renamed to para. 4.3.2 Stitching & Assembly. All subsequent para. renumbered. Updated Marking information - now para.4.4 All subsequent para. renumbered. Appendix A, information for Certificates of Compliance deleted. A Scale of Measurement page was added.

## **RCMP VIEWING SAMPLE**

A viewing sample, when available, will be supplied to the successful bidder.

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.

## **SPECIFICATION**

### **BELT, WAIST, LEATHER**

#### **1. Definitions**

- 1.1 This specification shall govern the manufacture and inspection of Belt, Waist, Leather. The specific item covered under this specification with stock number is as follows:
  - i. 2460 – Belt, Waist, Leather
- 1.2 This specification, viewing sample, drawing or other information issued in connection therewith, may only be used for specific enquiries, solicitations, or orders placed on behalf of the Royal Canadian Mounted Police.
- 1.3 This specification supersedes all previous specifications for Belt, Waist, Leather.
- 1.4 This specification has been translated into French from this original English language document.

#### **2. Applicable Specifications**

- 2.1 The following publications are applicable to this specification and to the issues in effect on the date of the solicitation, 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 Colourfastness of Crocking of Leather.
- 2.4 Federal Standard A-A-59826, Thread, Nylon.

#### **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 Belt, Waist, Leather, shall be a black leather dress belt with a metal single prong belt buckle, seven adjustment prong holes and a permanent keeper.

#### 4. **Detail Requirements**

##### 4.1 **Components**

- 4.1.1 **Leather** - The leather shall be vegetable 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 fibered and mellow. Loose or pipy leather will not be accepted. Materials used in tanning and finishing shall not have any injurious effects on the leather or the ultimate user of the leather. The leather shall be only of backs, defined as sides, with the belly trimmed off and the head trimmed off behind the horn holes. 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 serviceability or seriously affect the appearance, will be accepted in the finished unit. The grain side of the leather shall be lightly corrected by buffing. The corrected leather shall be printed with a smooth "hair seal" type of print as shown in the viewing sample. The leather shall be dyed black with a stain that will penetrate below the grain surface and left natural or black on the flesh side. 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 and flesh side shall be durable and colourfast, as per Table 1. The finished leather shall be firm and tight fibered with no signs of cracking, as per Table 1. The flesh side shall be free from loose flesh and shall be buffed to a smooth natural finish. The leather thickness shall measure from 2.75 mm to 3.25 mm for the belt and from 2 mm to 2.5 mm for the keeper. The leather shall meet the following physical requirements:

**Table I**

<b>Property</b>	<b>Requirement</b>	<b>Test Method</b>
Crocking	'Good'	ASTM 5053-03 [2009]
Cracking, 11 mm mandrel	None	ASTM D6075-13

- 4.1.2 **Thread** - The thread shall be twisted multifilament 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, black in colour.

Bonded polyester may be substituted for nylon provided the other general performance requirements are met.

- 4.1.3 **Buckle** - The buckle shall be made of zinc and shall be a single square frame single prong type, equal in all respects to the drawing and viewing sample. The buckle finish shall be electroplated in accordance with the best commercial standards. The hardware shall be adequately cleaned and polished prior to plating and have an acid-nickel plating as an undercoating for the gold plating. The gold plating shall be rack plated in a cyanide solution. The anodes shall be 24 carat gold. The plating shall be non-porous, continuous and unbroken over the entire plated surface. There shall not be cut through, shaded, peeled or blistered plating, and it shall match the colour of the viewing sample.
- 4.2 **Size & Dimensions** - The Belt, Waist, Leather, to this specification shall be supplied in the sizes specified in the contract and shall be the distance from the inside edge of the buckle to the fourth prong hole, as illustrated in the drawing. The finished belt shall conform to the dimensions given in the scale of measurements and drawing forming part of this specification.
- 4.3 **Construction**
- 4.3.1 **Cutting and Finishing** – The belt and keeper shall be cut from leather as specified in para. 4.1.1. The buckle end of the belt shall be taper skived reducing the end thickness from 1.2 mm to 1.4 mm. The skiving shall start at the back end of the buckle tongue slot. The belt shall be bevelled on both edges and both sides with a bevel of 0.8 mm in width with a plus tolerance of 0.4 mm. The finished width of the belt shall measure 3 cm with a 1 cm wide keeper. Each edge of the belt and keeper shall be creased on the grain side. The crease shall be no less than 1 mm or more than 1.5 mm from the belt edge. The end portion and tip of the tongue shall not be creased in accordance with the drawing. The edges of the belt and keeper shall be stained and filled with a wax type of black edging ink and then burnished to a solid smooth and durable edge, in full conformance with the viewing sample. Lacquer or varnish-type edge finishes shall not be used.
- 4.3.2 **Stitching and Assembly** - The stitching shall be lockstitch using the thread specified in para. 4.1.2. The assembled belt shall be stitched between crease lines, as shown in the drawing. The number of stitches shall be between 3 and 4 per centimeter. The loose thread ends shall be trimmed off close to the leather. Burning or "flaming off" the thread ends is not permitted. The rows of stitching shall be pounded down by means of a smooth flat faced riveting type of hammer.

- 4.4 **Marking** - Each belt is to be identified by stamping or printing using contrasting permanent inks, on the body side of the belt; or alternatively by adding a permanent label affixed by stitching, at the buckle end of the belt; with the following information legibly marked:
1. The size, using only Imperial Designation. (Ex: 34)
  2. The RCMP stock number – reference the contract document (Ex: 2460 343)
  3. The manufacturer's identification (Company name or number)
  4. The date of manufacture - in numeric format year/month (Ex.: 2001/11)

## 5. **Quality Assurance Provisions**

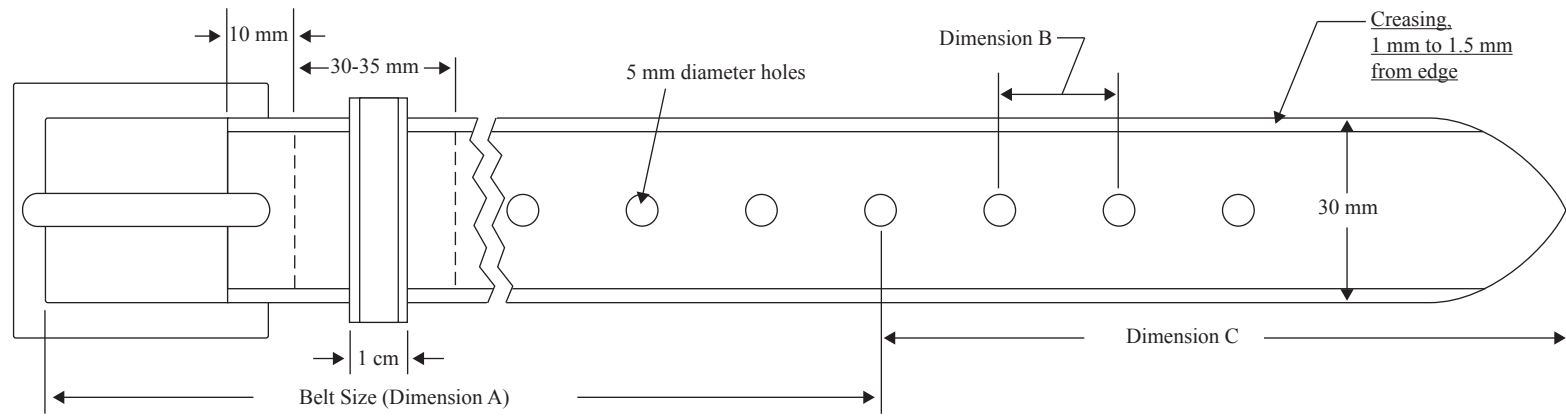
- 5.1 **Responsibility for Inspection** - Unless otherwise stipulated in the contract, it is the prime contractor's responsibility to satisfy the R.C.M.P., Uniform & Equipment Program that the material and services being supplied conform to this specification. This may be accomplished by performing the tests specified in this specification or by demonstrating to the satisfaction of the R.C.M.P., Uniform & 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 & Equipment Program.
- 5.2 The R.C.M.P., Uniform & 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.

**SCALE OF MEASUREMENTS FOR BELT, WAIST, LEATHER**

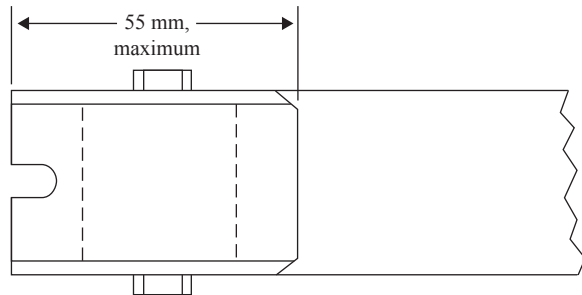
<b>Belt Size</b>	<b>Dimensions</b>		
<b>Imperial Designation</b>	<b>The distance measured from the inside of the buckle to the fourth prong hole</b>	<b>The distance between prong holes</b>	<b>The distance measured from the center prong hole to the end of the tongue</b>
<b>inches</b>	<b>cm</b>	<b>cm</b>	<b>cm</b>
24	62	2	13
26	67	2	13
28	72	2	13
30	77	2	13
32	82	2	13
34	87	2	13
36	92	2.5	15
38	97	2.5	15
40	102	2.5	15
42	107	2.5	15
44	112	2.5	15
46	117	3	17
48	122	3	17
50	127	3	17
52	132	3	17
54	137	3	17
56	142	3	17
58	147	3	17
60	152	3	17
<b>TOLERANCES ±</b>	<b>2 mm</b>	<b>1 mm</b>	<b>1.5 mm</b>
<b>MEASUREMENT LOCATION</b>	<b>A</b>	<b>B</b>	<b>C</b>



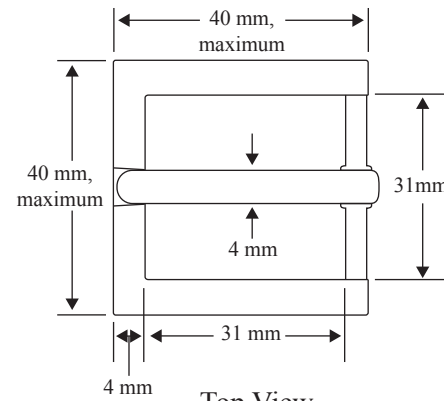
Dwg. 1



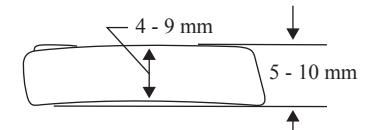
Front View



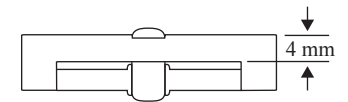
Back View



Top View



Side View



Front View

Buckle

Tolerance for all measurements where not indicated:  $\pm 1$  mm  
 NOT TO SCALE