



Royal Canadian Mounted Police
Gendarmerie royale du Canada

Doc. no: G.S. 1045-318
Date: 2015-06-03

Specification

Trousers, Special Duty, Blue

This document has 19 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.



Modifications

| Date | Para. No's | Modifications |
|------------|--------------------------------|--|
| 2007-11-14 | | Original Specification |
| 2009-08-06 | Page 5, Para. 4.1.3.2 | Modification to Buttonhole & bar-tack thread. |
| 2012-11-14 | Para. 4.1.3.1 & 4.1.3.2 | Updated the thread requirement as per industry recommendation and added Certificate of compliance required. |
| 2013-01-22 | Para. 4.1.7 Para. 4.1.9 | Changed Validation requirement to Certificate of compliance Increased the zipper length by ½” and added Certificate of compliance |
| 2015-06-03 | | Specification reformatted. |
| | | |
| | | |
| | | |

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 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

TROUSERS, SPECIAL DUTY, BLUE

1. Definitions

- 1.1 This specification shall govern the manufacture and inspection of Trousers, Special Duty, Blue. The specific items covered under this specification with stock numbers are as follows:
 - i. 6925 – Trousers, Special Duty, Blue / Pantalon bleu de fonction spéciale
- 1.2 This specification, pattern, drawing, viewing sample, 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 R.C.M.P. Trousers, Special Duty, Blue
- 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 invitation to tender, unless otherwise specified.
- 2.2 CAN/CGSB 4.2, Textile Test Methods.
- 2.3 ISO 4915:1991 Textiles – Stitch Types.
- 2.4 ISO 4916:1991, Textiles – Seam Types.
- 2.5 CAN/CGSB 4.131-93, Thread, Polyester, Polyester Covered.
- 2.6 RCMP Specification, G.S.1045-284 Cloth, Twill Poly/Cotton.
- 2.7 CAN/CGSB-86.1-2003 Care Labelling of Textiles.

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 pattern and viewing sample.
- 3.2 **Design** - The design shall be a trouser, navy blue in colour, constructed from a poly/cotton material. It shall come complete with front hip pockets, back hip pockets, thigh bellow pockets and a fly front with slide fastener. The back pockets and bellow pockets shall have flaps with hook and loop closure. The trousers shall be designed in accordance with the patterns and drawings which form part of this specification.

4. **Detail Requirements**

4.1 **Components**

- 4.1.1 **Shell Material** - Shall be made of Cloth, Twill, Poly/Cotton, navy blue in colour, meeting the requirements of RCMP specification G.S.1045-284, and shall be purchased from the R.C.M.P.
- 4.1.2 **Fusing** - The interlining shall be woven, fusible interlining, $85 \text{ g/m}^2 \pm 10 \text{ g/m}^2$ in accordance with the viewing sample.
- 4.1.3 **Thread** - Shall be polyester wrap, polyester core, Tex 40, of matching colour, meeting CAN/CGSB 4.131-93.
- 4.1.4 **Buttons** - Shall be 19mm, 4-hole buttons of nylon composition, black or dark navy colour, matching the shell material.
- 4.1.5 **Hook and Loop Tape** - Shall be black in colour, 2cm wide hook & loop tape. The combined hook and loop shall have no less than 8 P.S.I length-wise shear strength with initial peel strength of not less than 1 P.I.W when tested to AASTM 5169, standard test method for shear strength [dynamic method] of hook and loop touch fasteners and ASTM 5170, standard test method for peel strength ["T" method] of hook and loop touch fasteners.
- 4.1.6 **Slide Fasteners** - Shall be a closed ended, brass slide fastener with Y type teeth and 4.5mm chain width. The slide fastener shall come complete with one bottom

stop and a minimum of one top stop. The top stop shall be visible, positioned below the waistband. There shall be a semi-locking slider with stainless steel locking pin, and brass pull tab. The tape shall be comprised of a polyester yarn and shall be black in colour. YKK YGC-459 ½ is known to meet this requirement.

| Rise: | Slide Fastener Length (inches): |
|---------|---------------------------------|
| Short | 6½" |
| Regular | 7" |
| Tall | 7½" |

4.2 **Size and Dimensions** - Trousers, Special Duty, Blue 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 drawings, forming part of this specification. The garment components shall be shaped, dimensioned and positioned in accordance with the pattern requirements as outlined in Appendix A forming part of this specification.

4.3 **Construction**

4.3.1 **Cutting and Assembly** - All components of the trousers shall be cut in the direction indicated on the patterns. All garment pieces cut from the specified material shall be cut from the same dye-lot.

4.3.2 **Stitching & Seams** - Using the specified thread, there shall be not less than 3 and no more than 4 stitches per cm except for the front stitched crease which shall be 4 stitches per cm. All stitching shall be lock or lockchain stitch except the seat seam which shall be lockchain stitch. The beginning and ending of all stitching shall be securely backstitched and tacked unless secured by other stitching. Where seaming, turning and stitching are required the edges shall be properly worked out before stitching. Side seams shall be stitched, serged and double topstitched in accordance with serging type #6.01.01(edge finishing) and seam type #2.02.04 of ISO 4916:1991. Inseams shall be stitched and serged only.

4.3.3 **Waistband** - The cut-on waistband shall be equipped with four small belt loops, 1 cm wide, tacked and securely caught by stitching used to join together the trousers and waist facing. The bottom end shall be bar-tacked in position over the second row of topstitching used in the construction of the waist and facing as per paragraph 4.3.4 and drawing #2. The bar-tack should penetrate all layers of

material including the waist facing. There shall be five large belt loops dimensioned as per the patterns and drawings with hook tape, 6cm by 2cm, and loop tape, 8cm by 2cm as per para. 4.1.5. The large belt loops are placed on top of the waistband in an open position and topstitched and bar-tacked at the top and bottom as per drawing #1 and viewing sample. When the belt loop is applied, it shall have a raised center loop so the opening distance from the top to the bottom stitching and bar tacking is 6 - 6.5cm. The loop shall be raised and measure 7.5cm as per pattern and drawing #1.

4.3.4 **Waist Facing** - The waist facing shall be 5.5cm wide (+1cm tolerance), constructed from material specified in para. 4.1.1, complete with fusing as specified in para. 4.1.2. Once joined, the waist facing shall be top-stitched, using a 3mm gauge from the top edge. A second row of top-stitching shall run 5cm parallel to the first, as per drawing #2 and the viewing sample.

4.3.5 **Pockets & Flaps**

4.3.5.1 **Flaps** - All components of the pocket flaps shall be constructed from shell material as specified in para. 4.1.1. The loop tape shall be attached to the inside ply of the pocket flap and the corresponding hook tape shall be attached below the welt. The flap shall have a bar tack at each end to secure the opening. The completed flaps shall conform in all respects to the pattern, drawings and viewing sample.

4.3.5.2 **Front Hip Pockets** - There shall be two front hip pockets constructed from shell material as specified in para. 4.1.1. The pockets shall have slanted openings as per pattern and shall be reinforced with additional material such as twill tape or a woven material used on the straight of grain to stabilize the pocket opening. The pocket bags shall be constructed from shell material as specified in para. 4.1.1; it shall be stitched and turned on all raw edges. Both ends of the pocket opening shall be bar tacked as shown in the drawings and the pocket opening that extends into the waistband shall be sewn closed. The completed front hip pockets shall be shaped and dimensioned as per the pattern and viewing sample.

4.3.5.3 **Back Hip Pockets** - The back hip pockets shall have a 15.5 cm long single welt opening with the flap inserted at the top of the welt with hook and loop for closure. The welt shall be fused with material as specified in para. 4.1.2. The pocket bag shall be constructed from shell material as specified in para. 4.1.1 and shall be stitched and turned on all raw edges. Both ends of the pocket opening and flaps shall be bar tacked as shown in the drawings. The completed back hip

pockets shall be shaped and dimensioned as per the pattern, drawings and viewing sample.

- 4.3.5.4 **Bellow Pockets** - The thigh bellow pockets shall be constructed from shell material as specified in para. 4.1.1 and shall be shaped and dimensioned as per pattern. There shall be flaps with hook and loop tape as per the pattern templates and drawings. The pockets shall be bar tacked as shown in the drawings. All raw edges of the pockets shall be serged. The pockets shall be applied so the bellow is facing towards the back of the trouser in accordance with drawing #3.
- 4.3.6 **Fly Opening** - The fly front shall be made with shell material as specified in para. 4.1.1 and fused with material as specified in para. 4.1.2. It shall be equipped with a slide fastener in accordance with para. 4.1.6, which shall be supported by three, 4-hole buttons, as specified in para. 4.1.4. Two buttons shall be positioned on the fly front with corresponding buttonholes on the fly curtain and one button and corresponding buttonhole shall be applied to the cut-on waistband fly front and fly curtain respectively. At the end of the fly curtain extending below the bottom of the fly opening, the fly curtain shall be tacked to the fly front. Care shall be taken to ensure that the shell material is not caught during this operation. The fly shall conform in all respects to the pattern, drawing #2 and viewing sample.
- 4.3.7 **Seat Seam** - The seat seam shall be stitched using 401 lockchain stitch finished so that alterations of the waistband can be performed without opening the waistband. The seam allowance shall be a minimum of 2 cm at the crotch, widening gradually to 4 cm each side at the waistband after seaming and turning. All raw seams shall be serged. When finished, the seat shall conform in all respects to the patterns, drawings and viewing sample.
- 4.3.8 **Leg** - Each front panel shall be stitched with a stitch length of 4 stitches per cm using a 1.6mm gauge from the hem notch to the waist notch to form a permanent crease.
- 4.3.9 **Hem** - The bottom of the leg shall be serged and left unfinished. The completed leg shall conform in all respects to the pattern, drawings and viewing sample.
- 4.3.10 **Buttonholes** - Buttonholes shall be eyelet type, gimp reinforced, with a bar tacked or fish-tailed end and having a minimum of 28 stitches per inch or 11.2 stitches per centimetre. The buttonholes may be “cut first” or “cut after”, and shall fit a button as specified in 4.1.4. When “cut after” buttonholes are used, the cut shall be clean, close to the stitches so they are equal in appearance to the “cut first” buttonholes.

4.3.11 **Bar Tacks** - Bar tacks shall be 13 mm in length and be made with no less than 18 cover stitches per tack.

4.3.12 **Pressing and Shaping** - The trousers shall be pressed and shaped in accordance with good commercial practice to conform with the shaping and style of the viewing sample.

4.3.13 **Marking & Cleaning Instructions and Identification Labels** - Each pair of trouser shall have two labels sewn separately to the right back pocket bag. The label information shall be as outlined below in a text no less than a size 8 font. The text shall be of permanent inks of a contrasting colour and shall withstand at least 50 washes showing no apparent change in appearance. The label shall be completed in accordance with the following information in English and French.

1. Item name in English as written in para. 1.1.
2. Item name in French as written in para. 1.1.
3. RCMP stock number - reference contract documents. (Ex. 6925 635)
4. Size of the article, combining the size designation referenced in the English and French contract documents. (Ex.: 34 T/L)
5. Date of manufacture, in numeric format year/month (Ex.: 2001/11)
6. Your manufacturer identification (Company name or number).
7. Enter the care information as written below.

| | |
|---|--|
| 1 | |
| 2 | |
| 3 | |
| 4 | |
| 5 | |
| 6 | |
| 7 | <p>Machine wash - cool (30C) / Laver à la machine - eau froide (30C). Do Not use fabric softener or chlorine bleach / Ne pas utiliser d'agent adoucissant ou d'agent de blanchiment. Tumble dry- low (Do Not use dryer sheets) / Séchage par culbutage – à basse température (Ne pas utiliser d'assouplissant en feuilles). Steam iron – medium / Repassage à vapeur - à température moyenne. Do not dry clean / Ne pas nettoyer à sec</p> |

Identification label (Sewn on only): As illustrated below.

| |
|-----------|
| Name/Nom: |
|-----------|

Note: The manufacturers identification shall not appear anywhere on the garment except on the garment label as indicated.

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 RCMP, 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 RCMP, Uniform and Equipment Program that conformity to this specification of manufacturing processes is assured. The contractor must use a commercial testing establishment acceptable to the RCMP, Uniform and Equipment Program.
- 5.2 The Royal Canadian Mounted Police, 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.

6. **Scale of Measurement Definitions and Location References**

(Refer to the Scale of Measurements and Drawing #5)

- 6.1 **Waist Circumference** - When the waist is closed, it shall be measured along the top edge of the waist opening. The result shall be doubled to measure the total circumference. (A)
- 6.2 **Seat Circumference** - When placed flat, fly facing up, the seat shall be measured across the width of the trouser from side to side, level with the base of the front hip pocket flap. The result shall be doubled to measure total circumference. (B).
- 6.3 **Inseam Length** - The length shall be the distance measured from the crotch to the unfinished hem. (C).
- 6.4 **Outseam Length** - The length shall be the distance measured from the top, at waist, to the unfinished hem. (D).
- 6.5 **Front Rise** - The measurement from the top edge of the front waist/fly opening, along the crotch seam, to the intersection with the inseam. (E).
- 6.6 **Back Rise** - The measurement from the top back waist at seat seam, along the crotch seam, to the intersection with the inseam. (F).
- 6.7 **Bottom Circumference** - When placed flat, the bottom circumference shall be measured across the width at the bottom of the leg. The result shall be doubled to measure the total circumference. (G).

APPENDIX A

Sealed Pattern Identifier

Pattern #: G.S. 1045-318
 Title: Trousers, Special Duty, Blue

Paper Patterns - Paper patterns are available from the RCMP, Uniform and Equipment Program, Ottawa Ontario, under Pattern # G.S. 1045-318. Firms requested to produce Pre-contract Award Samples will be provided with the base pattern only. The full set of patterns either in individual sizes or as a graded nest will be provided to the successful bidder after the contract is awarded.

The paper patterns include seam allowances, drill holes and/or placement templates. Drill holes mark the edge of the placement. Contractors may make changes required to suit their production process, however, the design and grade shall not be affected or changed. **Material shrinkage/stretch may vary and it is the responsibility of the manufacturer to make allowances in order to meet the scale of measurements included in this specification.**

All patterns are the property of the RCMP and must be returned upon completion of the contract.

| | |
|-----------------------|---------------|
| <u>Legend:</u> | |
| Shell Material = | Para. 4.1.1 |
| Fusing = | Para. 4.1.2 |
| Cut 1 Single = | Cut 1 |
| Cut 1 Paired = | Cut 2 |
| (RSU) = | Right Side Up |

| Pattern Components | Nomenclature | Quantity to be cut | Material |
|---------------------------|----------------------------|---------------------------|--------------------------------|
| # 1 of 22 | Back | 1 Paired | Shell Material |
| # 2 of 22 | Front | 1 Paired | Shell Material |
| # 3 of 22 | Waist Facing - Front Right | 1 Single | Shell Material (RSU) Fusing |

| Pattern Components | Nomenclature | Quantity to be cut | Material |
|---------------------------|---------------------------|---------------------------|--------------------------------|
| # 4 of 22 | Waist Facing - Back Right | 1 Single | Shell Material (RSU) Fusing |
| # 5 of 22 | Waist Facing - Front Left | 1 Single | Shell Material (RSU) Fusing |
| # 6 of 22 | Waist Facing - Back Left | 1 Single | Shell Material (RSU) Fusing |
| # 7 of 22 | Fly Front - A | 1 Single | Shell Material (RSU) Fusing |
| # 8 of 22 | Fly Front - B | 1 Single | Shell Material (RSU) Fusing |
| #9 of 22 | Fly Curtain - A | 1 Single | Shell Material (RSU) Fusing |
| #10 of 22 | Fly Curtain - B | 1 Single | Shell Material (RSU) Fusing |
| #11 of 22 | Fly Curtain - C | 1 Single | Shell Material (RSU) |
| #12 of 22 | Belt Loops - Large | 5 Single | Shell Material (RSU) |
| #13 of 22 | Belt Loops - Small | 1 Single | Shell Material (RSU) |
| #14 of 22 | Pocket - Bellow | 1 Paired | Shell Material |
| #15 of 22 | Pocket - Inner Bellow | 1 Paired | Shell Material |
| #16 of 22 | Pocket Flap - Bellow A | 1 Paired | Shell Material |
| #17 of 22 | Pocket Flap - Bellow B | 1 Paired | Shell Material |
| #18 of 22 | Pocket - Back Welt | 1 Paired | Shell Material Fusing |
| #19 of 22 | Pocket Bag - Back Welt | 1 Paired | Shell Material |
| #20 of 22 | Pocket Flap - Back Welt A | 1 Paired | Shell Material |
| #21 of 22 | Pocket Flap - Back Welt B | 1 Paired | Shell Material |
| #22 of 22 | Pocket Bag - Front | 1 Paired | Shell Material |

SCALE OF MEASUREMENTS - Trousers, Special Duty, Blue

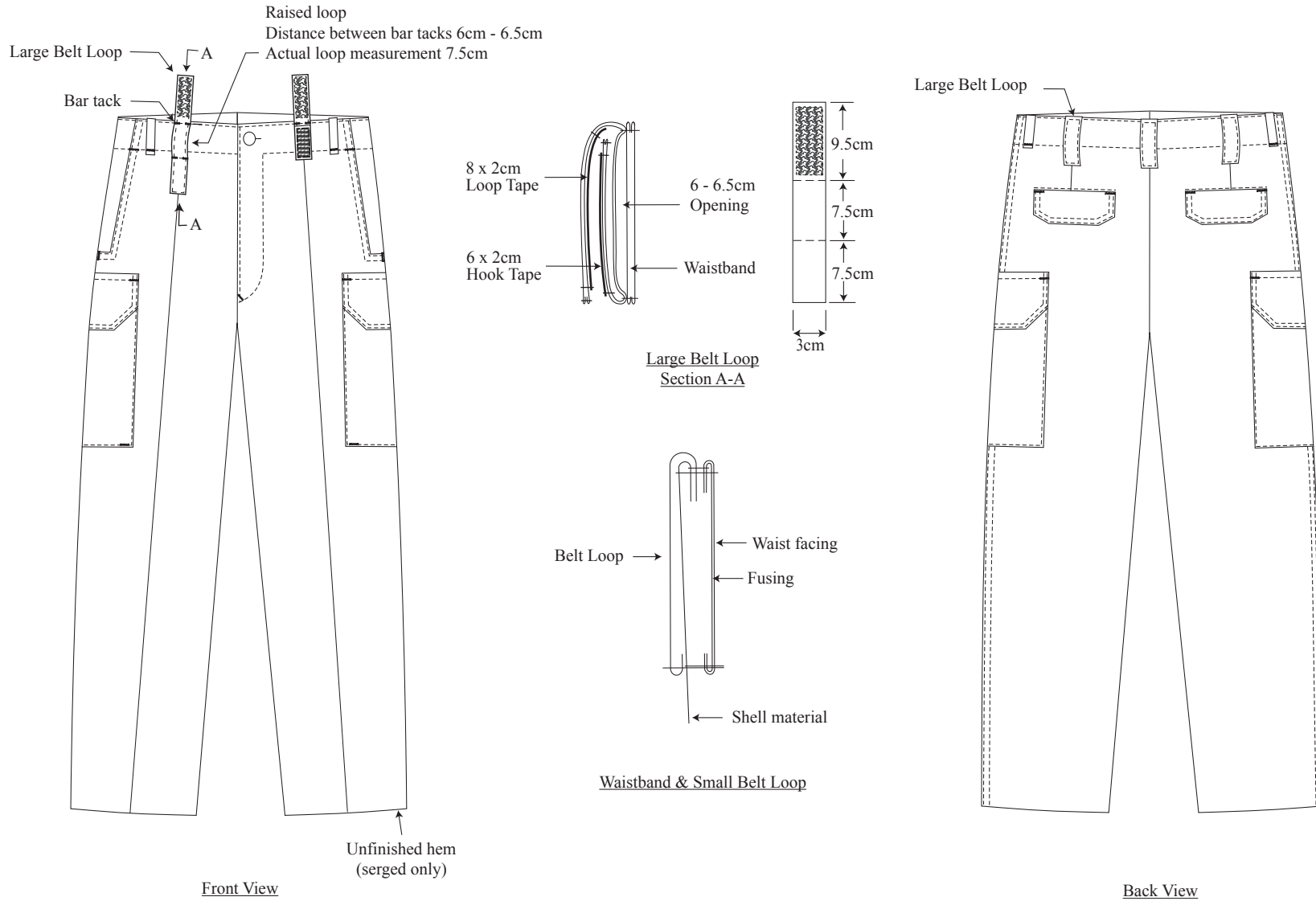
| SIZE DESIGNATION | | GARMENT MEASUREMENTS | | | | | | |
|----------------------------|---------------|----------------------|------------|--------|--|------------|-----------|--------------|
| Height | Size (Inches) | Waist Circ. | Seat Circ. | Inseam | Outseam (Top of cut-on waistband to hem) | Front Rise | Back Rise | Bottom Circ. |
| <u>SHORT RISE</u> | 30 S | 77.5 | 99 | 88.25 | 115.5 | 30 | 41 | 52 |
| | 32 S | 82.5 | 104 | 88.25 | 116 | 30 | 41 | 52 |
| | 34 S | 87.5 | 109 | 88.5 | 116.5 | 30 | 41 | 52 |
| | 36 S | 92.5 | 114 | 88.5 | 117 | 30.25 | 41.25 | 52 |
| | 38 S | 97.5 | 119 | 88.5 | 117.5 | 30.25 | 41.5 | 52 |
| | 40 S | 102.5 | 124 | 88.75 | 118 | 30.5 | 41.5 | 52 |
| | 42 S | 107.5 | 129 | 88.75 | 118.5 | 30.5 | 41.75 | 52 |
| | 44 S | 112.5 | 134 | 88.75 | 119 | 30.5 | 41.75 | 52 |
| <u>REGULAR RISE</u> | 30 R | 77.5 | 99 | 93.25 | 122.5 | 32 | 42.25 | 52 |
| | 32 R | 82.5 | 104 | 93.25 | 123 | 32 | 42.25 | 52 |
| | 34 R | 87.5 | 109 | 93.5 | 123.5 | 32 | 42.5 | 52 |
| | 36 R | 92.5 | 114 | 93.5 | 124 | 32.25 | 42.5 | 52 |
| | 38 R | 97.5 | 119 | 93.5 | 124.5 | 32.25 | 42.75 | 52 |
| | 40 R | 102.5 | 124 | 93.75 | 125 | 32.5 | 43 | 52 |
| | 42 R | 107.5 | 129 | 93.75 | 125.5 | 32.5 | 43 | 52 |
| | 44 R | 112.5 | 134 | 93.75 | 126 | 32.5 | 43.25 | 52 |
| <u>TALL RISE</u> | 30 T | 77.5 | 99 | 98.25 | 129.5 | 34 | 43.5 | 52 |
| | 32 T | 82.5 | 104 | 98.25 | 130 | 34 | 43.5 | 52 |
| | 34 T | 87.5 | 109 | 98.5 | 130.5 | 34 | 43.75 | 52 |
| | 36 T | 92.5 | 114 | 98.5 | 131 | 34.25 | 44 | 52 |
| | 38 T | 97.5 | 119 | 98.5 | 131.5 | 34.25 | 44 | 52 |
| | 40 T | 102.5 | 124 | 98.75 | 132 | 34.25 | 44.25 | 52 |
| | 42 T | 107.5 | 129 | 98.75 | 132.5 | 34.5 | 44.5 | 52 |
| | 44 T | 112.5 | 134 | 98.75 | 133 | 34.5 | 44.75 | 52 |
| TOLERANCES ± | | 1.5cm | 1.5cm | 1.5cm | 1.5cm | 1cm | 1cm | 1cm |
| MEASUREMENT LOCATION | | A | B | C | D | E | F | G |

Note: All dimensions are in centimetres unless otherwise indicated.

TROUSERS, SPECIAL DUTY, BLUE

G.S.1045-318

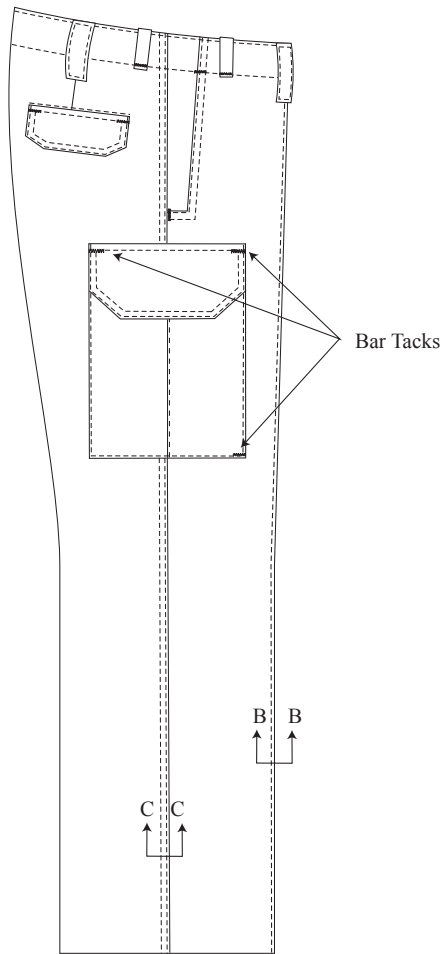
Dwg. 1



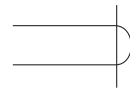
Dwg. 1

All Measurements in Centimeters
Unless otherwise stated all measurements are subject to ± 0.5 cm tolerance
NOT TO SCALE

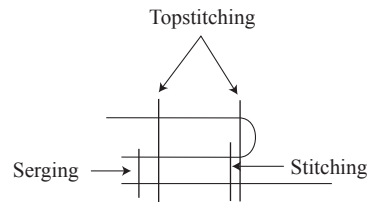
Dwg. 2



Side View

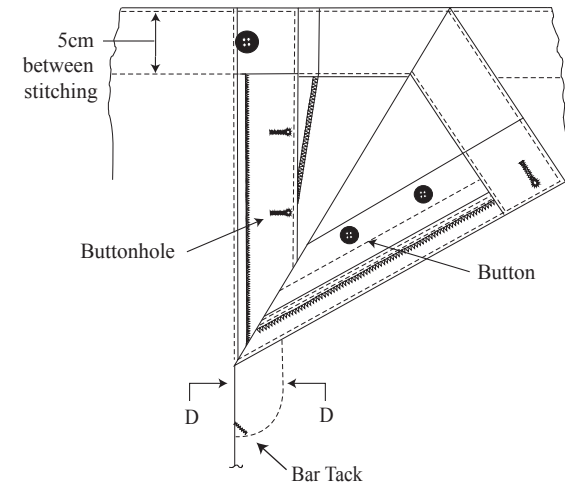


Section B-B
Sewn Permanent Crease

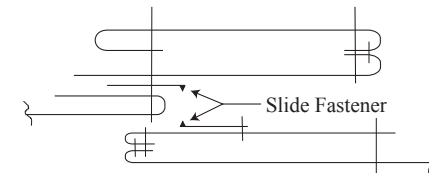


Note: Stitching and serging may be underneath topstitching

Section C-C
Side seam construction



Fly Detail

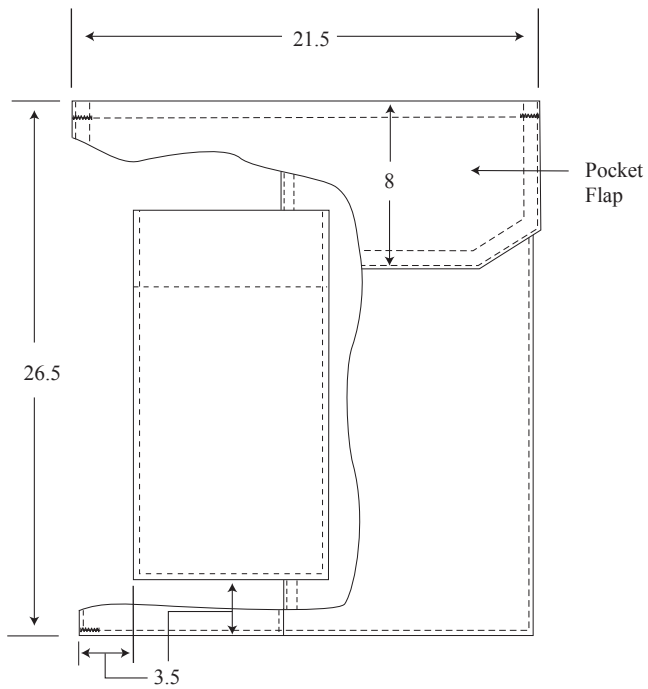


Section D-D
Fly Opening

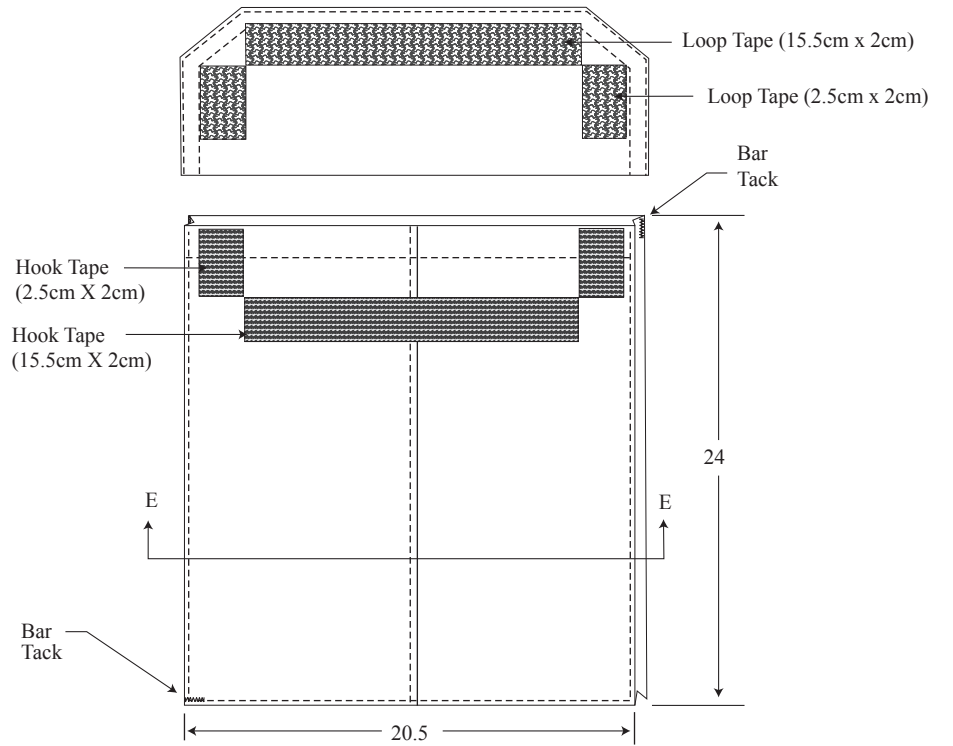
Dwg. 2

All Measurements in Centimeters
Unless otherwise stated all measurements are subject to ± 0.5 cm tolerance
NOT TO SCALE

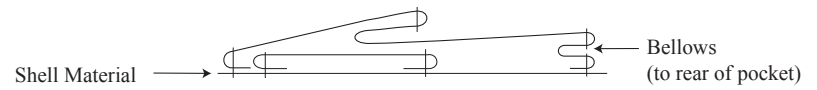
Dwg. 3



Left Thigh Pocket Detail



Left Thigh Pocket shown with Flap open

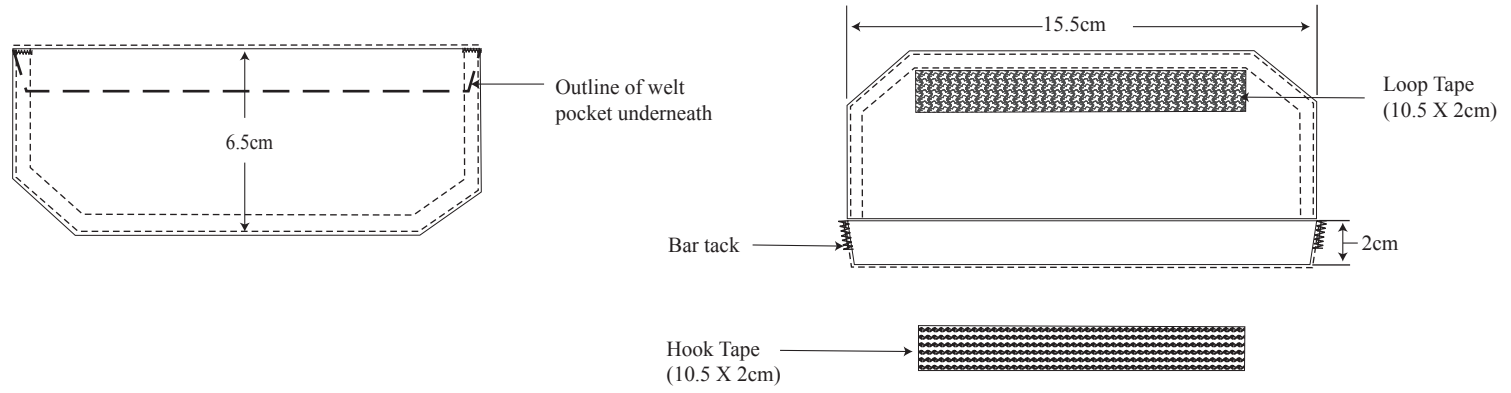


Section E-E
Left Thigh Pocket & Trouser leg

Dwg. 3

All Measurements in Centimeters
Unless otherwise stated all measurements are subject to ± 0.5 cm tolerance
NOT TO SCALE

Dwg.4



Back Pocket Flap

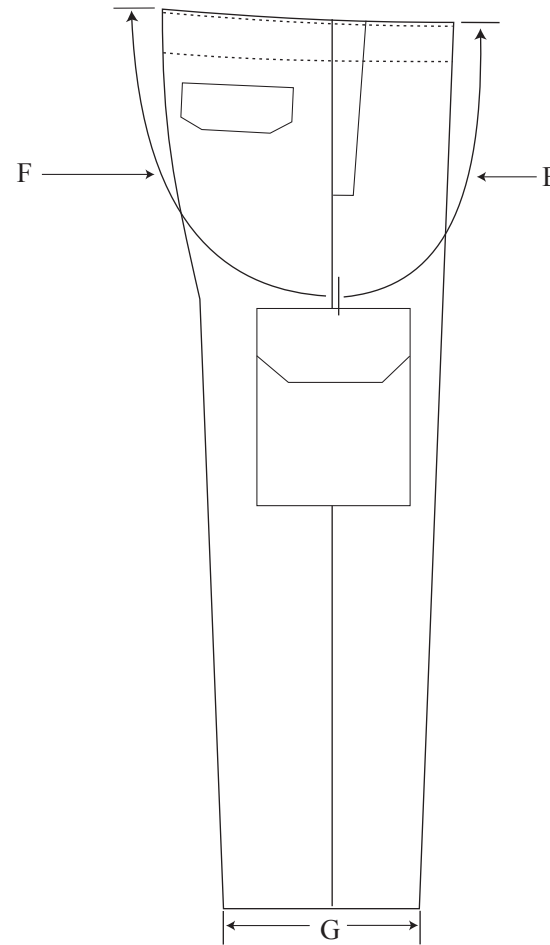
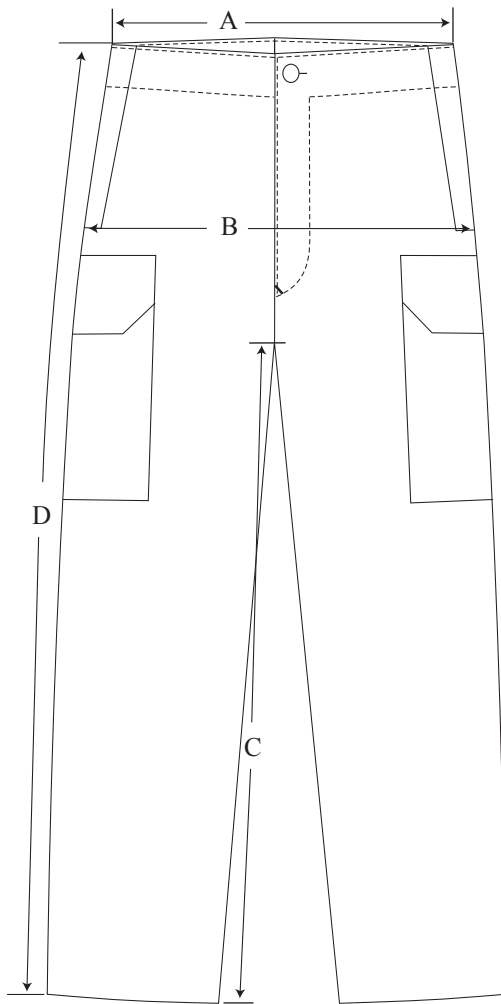
Back Pocket with Flap Open

Dwg.4

All Measurements in Centimeters
Unless otherwise stated all measurements are subject to ± 0.5 cm tolerance
NOT TO SCALE

Measurement Location Chart

Dwg. 5



Dwg. 5

NOT TO SCALE