



Royal Canadian Mounted Police  
Gendarmerie royale du Canada

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## Specification

# Gloves, Lined, Black, Male & Female

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 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**

### **GLOVES, LINED, BLACK, MALE & FEMALE**

#### **1. Definition**

- 1.1 This specification shall govern the manufacture and inspection of Gloves, Leather, Black, Lined, Male & Female. The specific items covered under this specification with stock numbers are as follows:
- i. 3550 Gloves, Black, Lined, Male / Gants en cuir noirs, doublés pour hommes;
  - ii. 3525 Gloves, Black, Lined, Female / Gants en cuir noirs, doublés pour femmes.
- 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 Gloves, Leather, Black, Lined, Male & Female.
- 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 CAN/CGSB 4.2, Textile Test Methods.
- 2.3 A-A-59826, Thread, Nylon.

#### **3. General Requirements**

- 3.1 The article or material covered by this specification shall be free from material and manufacturing defects that 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 gloves shall be a slip-on type with a knitted lining in accordance with the viewing sample.

4. **Detail Requirements**

4.1 **Components**

- 4.1.1 **Leather** - The combined palm and back, thumb and fourchettes shall be cut from chrome tanned leather from hair sheepskins (or equivalent). The finished leather shall be thoroughly tanned, mellow and soft, smooth and pliable. The leather shall be full grain (not buffed or snuffed) and free from imperfections or blemishes that may affect the appearance or serviceability. The leather shall have a minimum thickness of 0.6 mm and a maximum thickness of 0.8 mm for male gloves. The leather shall have a minimum thickness of 0.45 mm and a maximum thickness of 0.6 mm for female gloves. No pipy or bony leather shall be used. Leather with light well healed-over scratches which do not affect the serviceability or seriously affect the appearance will be accepted. The leather shall be drum dyed to a fast black colour, in accordance with the viewing sample.

- 4.1.2 **Lining** - The lining shall be knitted of a 100% worsted spun wool yarn, 2 ply 9s worsted count, light fawn mix in shade, not less than 56s in quality. The yarn shall be treated for shrink resistance in accordance with good commercial practice.

4.1.3 **Thread**

- 4.1.3.1 **Silking** - The silking thread shall be Class A Type II, size "AA" meeting the requirements of A-A-59826.

- 4.1.3.2 **Closing & Hemming** - The closing and hemming thread shall be Class A Type II, size "B" top and bottom meeting the requirements of A-A-59826.

- 4.2 **Sizes and Trank Measurements** - Gloves to this specification shall be supplied in the sizes specified by the R.C.M.P. and the trank measurement shall be in accordance with the following tables:

MALE SIZES	TRANK MEASUREMENT IS WIDTH (FRENCH RULER) WHEN THE LEATHER IS STRETCHED COMPLETELY	
7½	9 INCHES	AND 9 LINES
8	10 INCHES	AND 3 LINES
8½	10 INCHES	AND 9 LINES
9	11 INCHES	AND 3 LINES
9½	11 INCHES	AND 9 LINES
10	12 INCHES	AND 3 LINES
10½	12 INCHES	AND 9 LINES
11	13 INCHES	AND 3 LINES
11½	13 INCHES	AND 9 LINES
12	14 INCHES	AND 3 LINES

FEMALE SIZES	TRANK MEASUREMENT IS WIDTH (FRENCH RULER) WHEN THE LEATHER IS STRETCHED COMPLETELY	
6	7 INCHES	AND 6 LINES
6½	8 INCHES	AND 0 LINES
7	8 INCHES	AND 6 LINES
7½	9 INCHES	AND 0 LINES
8	9 INCHES	AND 6 LINES
8½	10 INCHES	AND 0 LINES
9	10 INCHES	AND 6 LINES
9½	11 INCHES	AND 0 LINES
10	11 INCHES	AND 6 LINES

### 4.3 **Construction**

- 4.3.1 **Cutting** - The gloves shall be cut from the leather specified in Para. 4.1.1 with dies in accordance with the patterns of the viewing sample. The fourchette patterns may be the one-piece or the two-piece type. The gloves shall be "Table Cut" with 24 lines (French ruler) added to the size, ie. Size 8 shall be "Table Cut" 10 inches and 3 lines in width. All stretch in the lengthwise direction shall be pulled out before cutting to avoid undue lengthening of the fingers of the finished gloves and to ensure sufficient stretch in the width of the gloves.
- 4.3.2 **Stitching** - With the exception of the silking described in Para. 4.3.3 all the stitching shall be lockstitch, using the thread specified in Para. 4.1.3.2. Where the stitching is done on a trimmer-equipped machine, the trimmer shall be adjusted in such a

manner that no more than 1.5 mm of the original material shall be removed. There shall be not less than 3.5 nor more than four stitches per centimetre. The smallest sized needle possible shall be used. The beginning and ending of all stitching shall be backstitch tacked for at least 13mm.

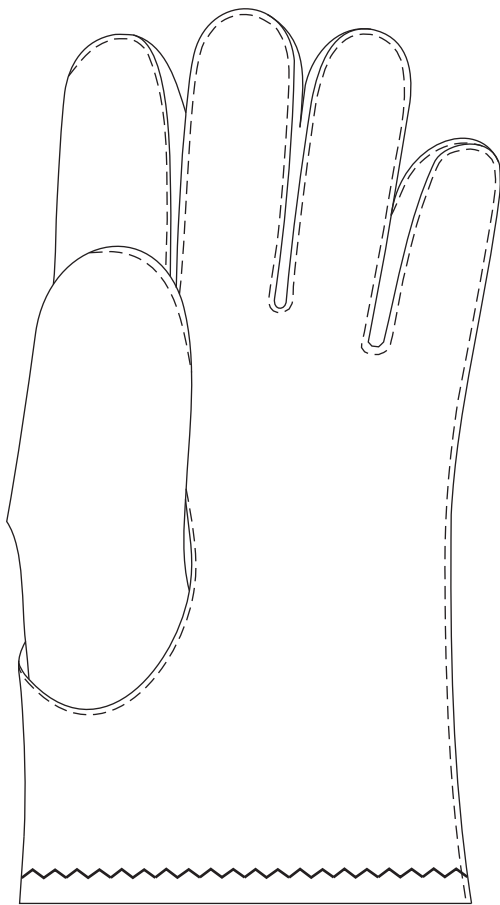
- 4.3.3 **Silking** - The three rows of silking shall be done on a two-needle machine using the thread specified in Para. 4.1.3.1. The rows of silking shall start and end on the back of the glove as shown on the drawing. All silking thread ends shall be pulled through to the flesh side and securely tied.
- 4.3.4 **Closing of Shell** - The thumb, fourchettes and side closing of the shell shall be outseam sewn with one row of stitching specified. The row of stitching shall be placed not less than 0.8 mm nor more than 1.5 mm from the edges. If two-piece Fourchettes are used they shall be joined at the base of the fingers with a row of outseam stitching.
- 4.3.5 **Lining** - The lining shall be seamless, plain knit from the yarn specified in Para. 4.1.2. There shall be not less than four courses and three wales per centimetre. The lining shall be finished with hand-tipped fingers and thumb. The surface of the lining that comes in contact with the hand shall be brushed. The fingertips of the lining shall be permanently joined to the leather shell during the lining and leather shell assembly operation.
- 4.3.6 **Hemming** - After the lining is assembled in the glove, the top end of the shell shall be self-hemmed. The leather shall be folded inwardly over the lining for a distance of  $8 \text{ mm} \pm 1.5 \text{ mm}$  and then stitched with one row zig-zag stitching. The row of stitching shall be positioned at the raw edge of the hem in accordance with the viewing sample. The loose ends of the thread shall be pulled to the inside of the glove, then tied and trimmed. Care shall be taken that the linings are not wrinkled or stretched in the hemming operation.
- 4.3.7 **Finishing** - The gloves shall be dampened and then laid-off on heated forms which correspond to the size and shape of the glove. The gloves shall be brushed on a cloth-type of revolving brush.
- 4.3.8 **Pairing** - The gloves shall be paired and tacked together at approximately 13 mm from the end of the closing seam at the gore side of the glove.
- 4.3.9 **Marking** - A label shall be attached to the inside of the glove by the hemming row of stitching, containing the following information in English and French:
1. Manufacturer's Identification
  2. Size
  3. RCMP Stock Number (3550-000)
  4. Date of Manufacture, in numeric format year/month (Ex. 2001/11)

## 5. **Quality Assurance Provisions**

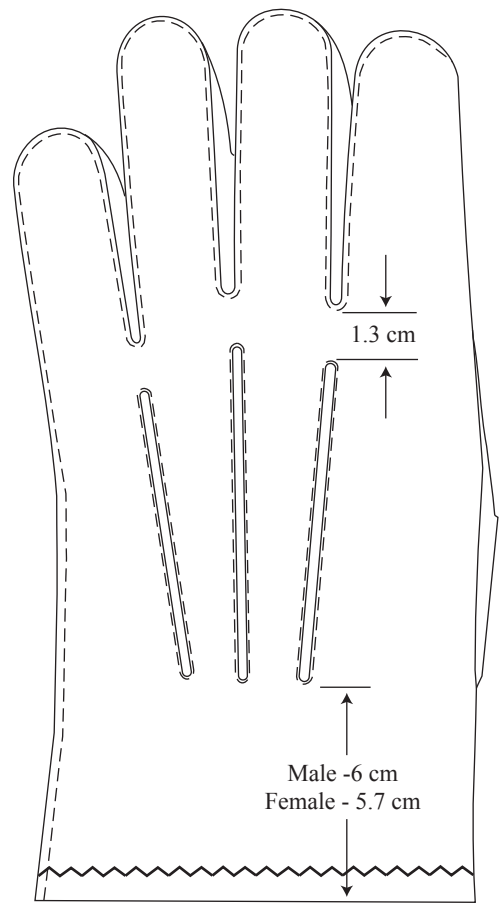
- 5.1 **Responsibility for Inspection** - Unless otherwise stipulated in the contract, it is the prime contractor's responsibility to satisfy the R.C.M.P., Uniform & Equipment Program that the material and services being supplied conform to this specification. This may be accomplished by performing the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



Dwg. 1



Palm



Back