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**Bid Receiving - PWGSC / Réception des soumissions
- TPSGC**
11 Laurier St./ 11, rue Laurier
Place du Portage, Phase III
Core 0B2 / Noyau 0B2
Gatineau, Québec K1A 0S5
Bid Fax: (819) 997-9776

**SOLICITATION AMENDMENT
MODIFICATION DE L'INVITATION**

The referenced document is hereby revised; unless otherwise indicated, all other terms and conditions of the Solicitation remain the same.

Ce document est par la présente révisé; sauf indication contraire, les modalités de l'invitation demeurent les mêmes.

Comments - Commentaires

Vendor/Firm Name and Address
Raison sociale et adresse du
fournisseur/de l'entrepreneur

Issuing Office - Bureau de distribution
Clothing and Textiles Division / Division des
vêtements et des textiles
11 Laurier St./ 11, rue Laurier
6A2, Place du Portage
Gatineau, Québec K1A 0S5

Title - Sujet BOOTS	
Solicitation No. - N° de l'invitation M0077-16J112/A	Amendment No. - N° modif. 004
Client Reference No. - N° de référence du client M0077-16J112	Date 2017-05-10
GETS Reference No. - N° de référence de SEAG PW-\$\$PR-761-72789	
File No. - N° de dossier pr761.M0077-16J112	CCC No./N° CCC - FMS No./N° VME
Solicitation Closes - L'invitation prend fin at - à 02:00 PM on - le 2017-05-18	
Time Zone Fuseau horaire Eastern Daylight Saving Time EDT	
F.O.B. - F.A.B. Specified Herein - Précisé dans les présentes Plant-Usine: <input type="checkbox"/> Destination: <input type="checkbox"/> Other-Autre: <input checked="" type="checkbox"/>	
Address Enquiries to: - Adresser toutes questions à: Beaumier, Julie	Buyer Id - Id de l'acheteur pr761
Telephone No. - N° de téléphone (613) 851-9981 ()	FAX No. - N° de FAX (819) 956-3814
Destination - of Goods, Services, and Construction: Destination - des biens, services et construction:	

Instructions: See Herein

Instructions: Voir aux présentes

Delivery Required - Livraison exigée	Delivery Offered - Livraison proposée
Vendor/Firm Name and Address Raison sociale et adresse du fournisseur/de l'entrepreneur	
Telephone No. - N° de téléphone Facsimile No. - N° de télécopieur	
Name and title of person authorized to sign on behalf of Vendor/Firm (type or print) Nom et titre de la personne autorisée à signer au nom du fournisseur/ de l'entrepreneur (taper ou écrire en caractères d'imprimerie)	
Signature	Date

AMENDMENT 004

This amendment 004 is raised to revise the Specification G.S.1045-092 dated **2016-11-08** to G.S. 1045-092 dated **2017-05-09** to correct the thickness values for leather at section 4.1.1.3 Leather, Vamp and Quarter Linings and answer question from a potential bidder.

At Annexe B:

Delete: SPECIFICATION G.S. 1045-092 DATED 2016-11-08

Insert: SPECIFICATION G.S. 1045-092-DATED **2017-05-09**

Question:

Q.2 : In section 4.1.1.3 you are asking for the lining to have a thickness of 1.3 to 1.6 mm. same thickness as the upper leather which is good for upper leather but would be very thick for a lining. In the previous contract document G.S. 1045-326 section 4.3.4 the thickness required was 0.8 to 1.2 mm. which is very good.

My question is: could it be a mistake in this recent document?

A.2: The specification document G.S. 1045-326 is no longer valid. In section 4.1.1.3, the lining thickness shall be 1.0 to 1.2 mm. See revised Specification G.S. 1045-092 dated 2017-05-09 below.

All other terms and conditions remain unchanged.



Royal Canadian Mounted Police
Gendarmerie royale du Canada

Doc. no: G.S. 1045-092

Date: 2017-05-09

Specification

Boots, Congress, Male & Female

This document has 16 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

[illegible]

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
BOOTS, CONGRESS, MALE AND FEMALE

1. Definition

- 1.1 This specification shall govern the manufacture and inspection of Boots, Congress, Male and Female. The specific items covered under this specification with stock numbers are as follows:
- i. 2625 – Boots, Congress, Male / Bottines de cérémonie à élastique latéral pour hommes;
 - ii. 2626-004 – Boots, Congress, Male, Special / Bottines de cérémonie à élastique latéral pour hommes, pointure spéciale;
 - iii. 2630 – Boots, Congress, Female / Bottines de cérémonie à élastique latéral pour femmes;
 - iv. 2631-004 – Boots, Congress, Female, Special / Bottines de cérémonie à élastique latéral pour femmes, pointure spéciale.
- 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 R.C.M.P. Boots, Congress, Male and 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 ALCA, American Leather Chemists Association, Method B4.
- 2.3 A-A-59826A, Thread, Nylon.
- 2.4 ASTM, American Society for Testing and Materials, Method D2210-13, D2211-00 (2010), D2617-12, D2807-93 (2015), D2810-13, D3495-10 (2015) and D4705-13.
- 2.5 FED-STD 311-7011.1, Federal Standard, Textile Test Methods.

3. **General Requirements**

- 3.1 The boots 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** – Boots, Congress shall be constructed of black cow hide uppers, leather soles, heel bases and top lifts, and elastic gore sides. Each pair shall have matching components similar in weight and quality. The boots shall be available in both male and female boot sizing. In all areas not covered by the specification, the viewing sample shall govern.

4. **Detail Requirements**

4.1 **Components**

4.1.1 **Leather**

- 4.1.1.1 **Leather, Vamps** – The vamps shall be cut from high quality black chrome-tanned cow hide leather from the best portion of the butt, as per Table I. It shall have a thickness of 1.3 mm to 1.6 mm. It shall be free from open or healed-over scratches and grub damage. Refer to Table II, Inspection for Defects, for acceptable quality of leather.
- 4.1.1.2 **Leather, Quarters** – The quarters shall be cut adjacent to the vamp area specified in 4.1.1.1 and from parts of the shoulder that are not hinged and are free from excessive fat wrinkles. Light, well healed over scratches that do not affect the serviceability or seriously affect the appearance will be accepted. The quarters shall have a thickness of 1.3 mm to 1.6 mm.
- 4.1.1.3 **Leather, Vamp and Quarter Linings** – The vamp and quarter linings shall be vegetable or chrome vegetable re-tanned leather cut from cowhides, taken from the sides, shoulders or bellies. It shall be grey or beige in colour. No stretchy, spongy or hard bony linings will be accepted. Linings with light, well healed-over scratches and grub holes will be accepted provided they do not affect the wear or seriously affect the appearance. They shall have a thickness of 1.0 mm to 1.2 mm.

- 4.1.1.4 **Leather, Welting** – The welting leather shall be first quality, squared double shoulder leather of 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. It shall be of sufficient width and thickness to properly attach to the upper, lining and insole.
- 4.1.1.5 **Leather, Insoles** – The insoles shall be cut from combination tanned (vegetable tanning followed by chrome re-tannage, or chrome tanning followed by vegetable re-tannage) bends or shoulders of cowhides. The leather shall be mellow and of medium-tight fibres. Loose or pipy leather will not be acceptable. The grain surface and all loose flesh shall be carefully removed by the use of a "Summit" or other similar splitting machine. The removal of the grain or flesh by equipment employing sandpaper or wire brushes shall not be permitted. The de-grained and fleshed insoles shall be firm, free of open grub holes or cuts and shall have a thickness of 3.2 mm to 3.7 mm.
- 4.1.1.6 **Leather, Outsoles** – The outsoles shall be cut from first quality bends. The leather shall be full grain (not buffed or snuffed) and free from imperfections or blemishes that may affect its appearance or serviceability. The leather shall be soft, smooth and pliable. After all excess flesh has been removed and the outsoles are evened, they shall have a minimum thickness of 5.8 mm and a maximum of 6.3 mm. Outsoles graded as "Number One Scratch" will be accepted.

Note: The term "Number One Scratch" denotes a grade of leather that may include grain damage such as healed wire scratches, medium fat wrinkles (not hinged), light healed-over brands and shallow flesh cuts in the shank and under the heel, minor grain blemishes, and soles with some stain or wild grain defects that will not affect the wearing quality of the leather, but shall not include "Butty" toes, soft spots or open grub holes.

- 4.1.1.7 **Leather, Heels** – The leather for the heels shall be full grain (not buffed or snuffed) and free from imperfections or blemishes that may affect its appearance or serviceability. The leather shall be soft, smooth and pliable. The heel base shall be built up with firm whole lifts. The grain side of the lifts may be lightly scoured with a rough sand paper to obtain maximum adhesion after gluing and compression. No soft or spongy lifts shall be used. The lifts shall be glued together with a water-resistant glue and then compressed tightly together with the use of moulds and compressing equipment. The heel base shall be gouged out at the breast to give what is known as a "Full Cup". The compressed heel base when combined with

the lift shall be of sufficient height at the heel breast and heel to cause the boot to tread correctly. The heel base shall be of sufficient length and width to provide the specified extension in the finished boot.

4.1.2 **Counters**

4.1.2.1 **Material** – Material for counters shall be reconstituted leather fibre sheet, made only of leather fibres bound with suitable binders, between 1.6 and 2 mm thick with a suitable density to hold its shape. The finished sheet shall be smooth. Counters shall not bulge or cause a warping of the quarters along their forward edges.

4.1.2.2 **Moulding** – The counters shall be properly skived and moulded on left and right moulds, which shall correspond closely in shape and design to the heel portion of the lasts. The counters shall be available in all sizes and widths.

4.1.3 **Bottom Filler** – The filler shall be a granulated cork bonded by a waterproof and thermo-setting binder which is free from any material subject to rapid deterioration with age. 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 boot. The cantilever movement between the filler surface and the outsole shall not cause squeaking.

4.1.4 **Heel Seat Lift** – The lift shall be good commercial quality, cut from leather.

4.1.5 **Box Toes** – The box toes shall be cut and moulded with a rigid material that forms to the shape of the last at the toe. The finished thickness shall be no less than 1.4 mm or more than 1.5 mm. The box toes shall be skived to a feather edge across the front with a 13 mm scarf. After lasting, the box toe length shall be sized appropriately to the size of the boot. After lasting, this measurement shall be approximately 6 to 7.5 cm in length depending on the boot size, measured with a tape from the welt around the curve of the toe.

4.1.6 **Shanks** – The shanks shall be made of rigid materials such as high-carbon, cold-rolled strip steel, fiberglass and Kevlar. If made of steel, the shank shall be sound and free from roughness, pitting, blisters, limitations, surface defects or edge cracks. The shank shall be appropriately curved to fit the bottom of any designated last. It shall be sized appropriately to the size of the boot. The shanks may be covered with a tape material to reduce the possibility of squeaking.

- 4.1.7 **Spur Boxes** – Spur boxes shall be produced as per the RCMP viewing sample available from the Uniform and Equipment Program.
- 4.1.8 **Pull Tabs** – The pull tabs shall be cut from durable nylon webbing, luggage quality, black in colour measuring 2 cm (¾”) wide and 0.04” ± 0.01” thick. It shall be equal in appearance to the viewing sample.
- 4.1.9 **Gore Fabric** – The gore fabric shall be cut from high quality woven elastic fabric, black in colour, equivalent in all respects to the viewing sample. The elastic fabric shall stretch at least 60 percent of its normal un-stretched length to permit the boot to be pulled on and off the wearer's foot.
- 4.1.10 **Rubber Top Lift** – The rubber top lift shall be black rubber equal in all respects to the viewing sample, with a thickness of 11 to 12 mm. The top lift may alternatively be the kind that has pre-located holes in place with washers inside used to secure nails in place during the heel attachment process.
- 4.1.11 **Heel-Pads** – The heel-pads shall be cut from leather specified in Para. 4.1.1.3.
- 4.1.12 **Nails**
- 4.1.12.1 **Heel Base Attaching** – The heel base attaching shall be steel, half-rough type of sufficient length to burr securely and smoothly on the insole.
- 4.1.12.2 **Heel Seat Nails** – The heel seat nails shall be brass, loose type. Nails shall be of sufficient length to clinch firmly and smoothly on the inner sole.
- 4.1.13 **Thread**
- 4.1.13.1 **Upper** – All upper stitching shall be done with Class A, Type II, size "E", bonded nylon thread (top and bottom) in accordance with specification A-A-59826A. The thread colour shall be black.
- 4.1.13.2 **Welting** – The welting shall be sewn with Class A, Type I, Size 8 (Tex 600), soft filament nylon in accordance with specification A-A-59826A. The thread colour shall be black.
- 4.1.13.3 **Sole Stitching** – The stitching shall be done with Type II, Class B, size 6 (Tex 400) in accordance with specification A-A-59826A. The thread colour may be white or black.

- 4.2 **Size and Dimensions** – The Boots, Congress Male & Female to this specification shall be supplied in the sizes specified by the RCMP. After lasting, the height of the upper shall be 14 cm with a plus tolerance of 3 mm, when measured from the heel seat at the back for size 8D Male Congress. All other sizes and widths shall be in correct proportion. The male boots shall be available in sizes (full and half sizes) ranging from size 7 through 15 in widths of D, E and F. The female boots shall be available in sizes (full and half sizes) ranging from size 5 through 10 in widths of B, C and D.
- 4.3 **Construction**
- 4.3.1 **Cutting Uppers** – The uppers shall be cut from the leather specified in Para. 4.1.1.1 and 4.1.1.2. No open scratches, hard, bony or flanky leather will be accepted. The two portions of the vamps shall be free from all damage. Leather with light, well-healed-over damage that does not affect serviceability or appearance will be accepted in the rest of the upper.
- 4.3.2 **Skiving** – All the upper parts shall be skived on the flesh side with a straight taper skive 5 mm in width. The top edges shall be skived, cemented and turned in with a fold that is no less than 4 mm or more than 5 mm. All seams in the finished boot shall be smooth and serviceable.
- 4.3.3 **Upper Stitching** – All upper stitching shall be lockstitched using the thread specified in Para. 4.1.13.1. There shall be no less than four or more than five stitches per centimeter. The loose ends of all upper stitching are to be trimmed off with the use of scissors or knife. Burning or ‘flaming’ off the loose ends will be permitted providing no damage occurs to upper leather. The needles used shall be the smallest size possible.
- 4.3.4 **Vamp and Quarter Linings** – The vamp and quarter linings shall be cut from material specified in Para. 4.1.1.3. They shall be cemented smoothly to the flesh side of the vamps and quarters.
- 4.3.5 **Quarters and Back Strap** – The quarters shall be butted and seamed at the front and back on a zigzag machine using three to four stitches per centimetre. The seams shall be rubbed out flat. After lasting, the quarters shall show no gaping. The back strap shall be stitched to the back of the quarters by two rows of topstitching on each vertical edge using 1.5 mm gauge and 3 mm gauge. The top edge shall be topstitched using 1.5 mm gauge.

- 4.3.6 **Vamps** – With the vamp overlapping the quarters, the two shall be stitched together with two rows of topstitching using 1.5 mm gauge and 3 mm gauge, starting and stopping at the bottom of the vamps.
- 4.3.7 **Counters** – The counters specified in Para. 4.1.2, shall be dipped in latex counter paste just prior to assembling. The appropriate size of counter to fit the designated upper shall be used. Counters shall be caught with no less than two welting stitches in each wing.
- 4.3.8 **Elastic Gore Fabric** – The elastic gore fabric shall be placed between the quarter and quarter lining and caught by two rows of topstitching using 1.5 mm gauge and 3 mm gauge.
- 4.3.9 **Quarter Lining and Pull Tabs** – The leather quarter lining shall serve as a counter-pocket as well as an inside backstay. The two back pieces shall be sewn together and with the seam rubbed out flat. These seams shall be placed on the inside of each boot directly in line with the outside seams joining the vamps and quarters, using three to four stitches per centimetre. The seams shall be rubbed out flat. The top of the back and front portions of the lining shall be sewn to the top of the vamps and quarters by one row of stitching placed 2 mm from the top edges. This stitching shall secure two pull tabs from webbing specified in Para. 4.1.8 folded and inserted between the lining and the vamp in the front and quarter in the back. The finished pull tab shall be 4 cm \pm 0.5 cm long.
- 4.3.10 **Vamp Lining** – The vamp lining shall be stitched with the quarter lining overlapping it 1 cm and shall be sewn together with two rows of topstitching using 1.5 mm gauge and 3 mm gauge.
- 4.3.11 **Box Toe** – The box toe specified in Para. 4.1.5, shall be positioned between the vamp and the vamp lining in such a way that it will meet the length requirement of the finished boot. The bottom edge of the box toe shall be fully caught by the welting stitches.
- 4.3.12 **Lasting** – The boots shall be made on lasts, the same as the viewing sample or equivalent, by what is known as the Goodyear Welt Process. A “roper/rodeo last has been found acceptable. Lasts used shall be in the correct sizes and widths in accordance with the sizes and widths of the uppers. Insoles shall be evenly tacked to the lasts with one tack at the toe, two at the ball, and one in the shank and heel. The uppers shall be lasted 14 mm \pm 1.5 mm over and all around the heel seat. The

heels and toes shall be smoothly, firmly and evenly wiped in against the shoulder of the insole. The uppers shall be pulled down tight to the lasts. The back seams shall be straight. Lasts shall not be pulled until after edge and heel finishing operations are completed. Boots shall remain on the lasts until completely dry, approximately one to two days.

- 4.3.13 **Welting** – The welting leather specified in Para. 4.1.1.4 shall be sewn level and close to the shoulder of the channel with the welt thread specified in 4.1.13.2, positioned at the root of the shoulders. Dropped or broken stitches, broken or torn channel lips will not be accepted. Either 270 degree welting or 180 degree welting is acceptable. There shall be no more than one joint in the welting for each boot. Tension on the stitches shall be tight with no less than one nor more than 1.5 stitches per centimetre. The ends of the welt shall be trimmed with a 15 mm \pm 1.5 mm bevel, pulled in, tacked down and pounded. The welt shall be beaten out while in temper.
- 4.3.14 **Removal of Tacks** – All lasting tacks shall be removed following the welting operation.
- 4.3.15 **Inseam Trimming** – The excess part of the upper and insole shoulder shall be trimmed off. Care should be taken to not trim too close to the welting stitches.
- 4.3.16 **Shanks** – The shanks shall be as specified in 4.1.6. They shall be tacked to the insole with two tacks, under the heel, in such a position that the shank shall not extend too far forward and interfere with the tread across the ball. Alternatively, the shanks may be set in position using a suitable thermoplastic adhesive. The shanks shall be sized appropriately to fit the size of the boot.
- 4.3.17 **Bottom Filler** – The bottom filler shall be as specified in 4.1.3. The filler shall be applied by heat and mechanical pressure to ensure level and uniform bottoms. The bottoms including the open space in the heel seat, shall be completely filled.
- 4.3.18 **Sole Laying** – The outsole specified in Para. 4.1.1.6 shall be fully scoured on a rapidly revolving steel wire brush. The steel wire bristles in the brush shall have a diameter of 3 mm \pm 0.025 mm. The outsole shall be cemented and laid with the aid of a sole laying machine using correct pressure and suitable, shaped pads. The use of temporary tacks or nails while sole rounding and stitching is not permitted.
- 4.3.19 **Rough Rounding** – The edges of the sole and welt shall be rounded on a rough rounding machine to provide the required extension for edge trimming.

- 4.3.20 **Sole Stitching** – The outsole shall be stitched to the welt by lockstitch in a groove on the outsole. The thread specified in Para. 4.1.13.3 shall be thoroughly coated with hot wax and be sewn using a needle and awl of the smallest combination for the specified threads. The number of stitches shall be no less than 2.5 nor more 2.75 stitches per centimetre. The lockstitch shall be embedded in the outsole to approximately 1/3 of the depth below the surface. A tight tension shall be used on the thread. The distance between stitching and the edge shall be minimal to allow for edge trimming and shaping operations. The sole stitching shall continue to at least 1 cm to the back of the breast of the heel. The stitches shall be neatly and lightly separated with the use of a stitch separating machine.
- 4.3.21 **Bottom Levelling** – The outsoles shall be levelled in order to conform to the shape of the bottom of the last. The seats shall be pounded down firmly and evenly.
- 4.3.22 **Heel Seat Fastening** – The seats shall be nailed with brass nails as specified in 4.1.12.2, spaced 13 mm \pm 1.5 mm apart. They shall be clinched firmly and smoothly on the heel seat part of the insole. The fastening shall be on the outside of the lasting tacks. They are to start and to stop approximately 13 mm behind the breast of the heel.
- 4.3.23 **Heeling**
- 4.3.23.1 **Heel Base** – The heel base and heel part of the outsole shall be scoured with the steel wire brush used in sole laying, and cemented firmly together. Heel bases shall be attached with nine to eleven nails as specified in Para. 4.1.12.1. Alternatively, the heel base may be attached using 6 steel nails of an appropriate type through the top lift and four inside nails with washers.
- 4.3.23.2 **Rubber Top Lift** – The top lift specified in Para. 4.1.10 shall be securely cemented to the heel base with a suitable cement. Alternatively, the top lift may be attached with up to six steel nails of an appropriate type through the top lift and four inside nails.
- 4.3.23.3 **Spur Boxes** – The spur boxes shall be inserted into the centre of the back of each heel during the heeling operation and secured by two steel nails as in the viewing sample.
- 4.3.24 **Trimming**

- 4.3.24.1 **Heels** – The heels shall be trimmed to form a heel shaped as in the viewing sample. The heel seat shall be trimmed with no more than 1.5 mm extension all around. The heel breast shall be curved as represented in the viewing sample. Heels shall not be under seated and shall tread flat.
- 4.3.24.2 **Sole Edges** – Boots shall be trimmed in pairs, square around the forepart and shank. Edges shall have the following extensions, measured at right angles to the upper; 6 mm at outside ball, gradually decreasing to 5 mm at the end of the toe and inside ball. Edges shall be smoothly trimmed with a correct size cutter. No ragged or wavy edges will be accepted.
- 4.3.25 **Finishing**
- 4.3.25.1 **Sole Edges** – The sole edges shall be filled with best quality filler and set up with a hot oscillating iron the same size and shape as the edge trimming cutter. The edges shall then be inked in with best quality edging ink, and set up again with the same iron to produce a solid, smooth edge that shall then be padded and brushed to a bright finish.
- 4.3.25.2 **Heels** – The heels shall be scoured with two scouring operations, using a fine Grit (No. 120) paper in the second scouring operations, and then stained black. Heels shall be hot waxed, padded and brushed to a bright finish, then wheeled and brushed again. The heel breast shall be scoured with one paper, using no stain.
- 4.3.25.3 **Bottoms** – The outsole bottoms shall be clean and free from stains. They shall not be buffed, painted or stained. After cleaning, the bottoms shall be brushed.
- 4.3.25.4 **Insoles** – All tacks or nails shall be smoothly clinched and there shall be no roughness to the hand when examined.
- 4.3.25.5 **Upper Finishing** – Uppers shall be thoroughly cleaned, then dressed with one coat of semi-bright dressing. No filler shall be used on the uppers.
- 4.3.25.6 **Sole Stitching** – Sole stitches shall be inked in black on the welt side. The welt and stitches shall be cleaned and brushed.
- 4.3.26 **Heel Pads** – The heel pads shall be cut from the leather specified in Para. 4.1.1.3. They shall be skived at the breast with a 1 cm straight taper skive. The heel pad shall be at least 4 cm in length from the centre of the breast to the back

- 4.3.27 **Marking** – The marking shall be done in one of three ways depending on the manufacturing preference of the vendor. These markings are to remain for the life of the boot. The stock number and size shall be in a font no less than size 8. All other marking shall be in a font size 6. The marking options are as follows:
- a. Inscribed on the shaft of the boot.
 - b. On a durable label captured in the quarter lining stitched in a position visible to the wearer.
 - c. On the outsole near the heel breast.
1. RCMP stock number - reference contract documents. (Ex. 2625 000)
 2. Size of the article, combining the size designation referenced in the English and French contract documents. (Ex. 8E Male/ Homme)
 3. Date of manufacture, in numeric format year/month (Ex. 2001/11)
 4. Your manufacturer identification (Company name or number).

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.

TABLE I
Chemical and Physical Properties of Upper, Calfskin, Chrome Tanned

REQUIREMENTS			TEST METHODS
1	Thickness	for Upper – 1.3 mm – 1.6 mm	• Woburn Gauge
2	Chloroform extract	3.5 – 6%	• ALCA B4 • ASTM D3495-10 (2015)
3	pH Value	3.5 minimum	• ASTM D2810-13
4	Ash	8.5% maximum	• ASTM D2617-12
5	Chrome Oxide	4% minimum	• ASTM D2807-93 (2015)
6	Burst Strength (Mullen)	350 psi (min.)	• ASTM D2210-13
7	Stitch Tearing Strength	40 lb (min.)	• ASTM D4705-13
8	Shrinkage Temperature	100°C	• FED-STD-311/7011.1
9	Elongation at 2000 psi.	50% maximum	• ASTM D2211-00 (2010)

TABLE II
Inspection for Defects

CLASS OF DEFECT	ACCEPTABLE	NOT ACCEPTABLE
Fibre Quality	Tight Fibre	Loose Fibre
Brands	Not acceptable	Not acceptable
Fat wrinkles	Medium wrinkles	Heavy wrinkles
Ticks and Fly bites	Minor scars and bites	Severe scars or bites
Grain Damage	Slight grain damage	Deep grain cuts, or extensive grain damage
Appearance (Salt Stains, Iron Stains, Unremoved hair and discolouration)	Good Appearance	Salt or iron stains, unremoved hair or serious discolouration
Slaughter cuts	Slight slaughter cuts	Deep slaughter cuts
Fleshiness	Clear	Excessively fleshy

Dwg. 1

