



Royal Canadian Mounted Police  
Gendarmerie royale du Canada

Doc. no: G.S. 1045-351  
Date: 2017-03-14

# Specification

## Case, Carrying, Rifle Plate

This document has 13 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
2010-03-25		Original Specification
2014-10-17	Para. 1.1 Para. 1.4 Para. 2.3-2.6 Para. 3.3 Deleted Para. 4.1.1-4.1.7  Para. 4.1.8  Para. 4.2.1- 4.2.1.3 Para. 4.2.2 Para. 4.3 Para. 5 Deleted  Table I Drawings	Added item with MMR number to paragraph. Added paragraph relating to translation. Added relevant standards. Paragraph deleted. Updated information according to current industry standards. Added paragraph referring to grosgrain ribbon. Added supplementary construction details. Modified paragraph. Labeling paragraph modified. Delivery and Marking paragraphs deleted and subsequent paragraph renumbered. Table added for shell material requirements. Added detail to divider and additional dimensions added to drawings.
2014-10-24	Drawing #2	Drawing titles modified.
2015-07-29	Para. 1.1 Para. 2.5 Para. 4.1.6  Para. 4.1.7 Para. 4.2.1.2 & 4.2.1.3  Drawings	Listed item name in both English & French. Updated and added test methods. Made two sub paragraphs to specify thread for shell material and thread for lining. Hook and loop tape requirements updated. Paragraphs modified to clarify placement of loop tape in the case and the correct placement of the divider within the case. Drawings modified to show correct placement of centre divider.
2017-03-14	Para. 2.2-2.5 Para. 4.1.6.1 & 4.1.6.2 Para. 4.1.7 Drawings	Standards updated. Updated thread paragraphs. Modified hook and loop requirement. Drawings modified.

## **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**  
**CASE, CARRYING, RIFLE PLATE**

**1. Definition**

- 1.1 This specification shall govern the manufacture and inspection of Case, Carrying, Rifle Plate. The specific item covered under this specification with stock number is as follows:
- i. 120653 – Case, Carrying, Plate, Rifle/ Étui de transport pour gilet pare-balles
- 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 Case, Carrying, Rifle Plate.
- 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; 5.1-M90 (2013), 6-2013, 9.1-M90 (R2013), 12.1-M90 (R2004), 22-2004 (R2013), 23-M90 (2013), 26.2-94 (R2012).
- 2.3 Federal Standard A-A-59826A, Thread, Nylon.
- 2.4 ASTM, American Society for Testing and Materials, Method D3776/D3776M-09a (2013), D5169-98 (2015) and D5170-98 (2015).
- 2.5 ISO, International Standards Organization; 105-E04:2013, 4920:2012 and 7211-2:1984.

**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 Case, Carrying, Rifle Plate shall be of nylon fabric material with carrying handles, foam padding and slide fastener closure, of one size only, to carry one set of RCMP Rifle Plate Carrier with two General Duty Rifle Plates.

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

##### 4.1 **Components**

- 4.1.1 **Shell Material** – The shell material shall be a dark navy, 100% nylon 1000 denier fabric meeting the requirements outlined in Table I.
- 4.1.2 **Lining Material, Interior** – The lining material shall be a 100% nylon 200 denier fabric. It shall be black or navy in colour.
- 4.1.3 **Slide Fastener** – The slide fastener shall be a heavy duty coil-type, with two reverse non-locking single long pull sliders, head-to-head, black in colour. 10CF chain ¾” tape width, YKK #61801 with two Sliders 10CF DFBL E, YKK #77810.
- 4.1.4 **Foam Padding** – The foam padding shall be polyethylene closed cell foam, LD45, with a density of 45 kg/m<sup>3</sup> with a thickness of 20 mm ± 2 mm.
- 4.1.5 **Nylon Webbing** - The webbing shall be a durable nylon webbing, luggage quality, black in colour measuring 3.8 cm (1.5”) wide and 0.043” ± 0.01” thick. It shall have a minimum tensile strength of 1500 lbs. as per Federal Standard 191-5206 test method #4108 and be equal in appearance to the viewing sample. Tape Craft #N0015S is known to meet the requirements.
- 4.1.6 **Thread**
- 4.1.6.1 **Thread, Shell Material** - The thread shall be twisted multifilament bonded nylon, Type II, Class A, size F (Tex 90), in accordance with U.S. government standard A-A-59826A, black in colour.

- 4.1.6.2 **Thread, Lining Material** - The thread shall be twisted multifilament bonded nylon, Type II, Class A, size B (Tex 45), in accordance with U.S. government standard A-A-59826A, black in colour.
- 4.1.7 **Hook and Loop Tape** – The hook and loop tape shall be black in colour, with a high life cycle. 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 ASTM D5169-98 (2015), standard test method for shear strength [dynamic method] of hook and loop touch fasteners and ASTM D5170-98 (2015), standard test method for peel strength ["T" method] of hook and loop touch fasteners." Dimensions shall be as per this specification and drawings.
- 4.1.8 **Binding Tape** – The binding tape shall be heavy duty nylon grosgrain binding tape, black in colour 0.3 mm thickness, width as per application, and be equal in all respects to viewing sample.
- 4.2 **Construction**
- 4.2.1 **General** - The Rifle Plate Carrying Case shall be made from the shell material specified in Para. 4.1.1. It shall be a top-opening case, closed by means of the heavy duty slide fastener specified in Para. 4.1.3 and have two carrying handles made of the webbing specified in Para. 4.1.5. It shall have foam cushioning of the material specified in Para. 4.1.4 for impact resistance. The case interior shall be lined with the material specified in Para. 4.1.2. It shall have a removable padded divider made with the material specified in para. 4.1.4 and interior lining material, specified in Para. 4.1.2 and shall be secured in place by hook and loop tape.
- 4.2.1.1 **Case Exterior** - The exterior of the Rifle Plate Carrying Case shall be made from the shell material specified in Para. 4.1.1. The dimensions shall be 36 cm wide x 44 cm high and 13.5 cm deep. All dimensions are subject to a tolerance of  $\pm 0.5$  cm. The case shall be closed with a heavy duty coil slide fastener with two sliders as specified in Para. 4.1.3 starting from the bottom of one side and continuing up, across and down the other side. There shall be a card holder made of clear plastic encased on all sides with grosgrain ribbon as specified in Para. 4.1.8. The finished edge of the binding shall be 1 cm. The outer dimensions of the card holder shall measure 12 cm wide by 8.5 cm high with a tolerance of  $\pm 0.5$  cm. The clear plastic window shall a minimum usable clearance of 10 cm wide by 6 cm high with a tolerance of  $\pm 0.5$  cm. The card holder shall be positioned on each side of the case 7.5 cm  $\pm 0.5$  cm down from the top edge and centered across the side of the case

and stitched with thread specified in Para. 4.1.6.1, at 3 mm gauge on three sides, leaving left side open.

- 4.2.1.2 **Case Interior** - The interior of the Rifle Plate Carrying Case shall be made from the foam padding specified in Para. 4.1.4 and completely covered with lining material as specified in Para. 4.1.2. Care shall be taken that the corners of the foam cushioning be rounded at joins and corners with a radius of 2.5 cm minimum to reduce wearing of the shell material. The foam padding shall extend to the line established by the slide fastener, in order to create a suitably protective barrier for the rifle plates and carrier along the opening when the case is closed. There shall be a piece of loop tape as specified in Para. 4.1.7 measuring 5 cm by 28 cm  $\pm$  0.5 cm sewn to one side of the base on the inside of the case for attaching the removable padded divider.
- 4.2.1.3 **Removable Padded Divider** - The removable padded divider shall be constructed with foam padding specified in Para. 4.1.4 and completely covered with lining material as specified in Para. 4.1.2. It shall measure 28 cm wide and 32 cm high with a tolerance of  $\pm$  0.5 cm. The bottom edge seam of the padded divider shall have a piece of grosgrain material as specified in Para. 4.1.8 folded in half and sewn over the raw edge to measure 1 cm wide. A piece of hook tape measuring 5 cm by 28 cm  $\pm$  0.5 cm shall be attached on one side to the grosgrain ribbon extension to attach the pad to the inside of the case. The foam divider shall be attached by hook and loop tape into the case in such a way so that the divider is equally centred within the case as per the viewing sample and drawing #1.
- 4.2.2 **Carrying Handles** - The carrying handles shall be made of the webbing specified in Para. 4.1.5. The webbing shall be secured in the seam at the bottom of the case starting at 3 cm  $\pm$  0.5 cm from the side edge. The carrying handles shall be sewn to the outside of the case stopping 5 cm  $\pm$  0.5 cm from the top edge, allowing 53 cm  $\pm$  1 cm to be unattached to form the handle before continuing to be stitched down other side of the case 3 cm  $\pm$  0.5 cm from the edge. Bar tacks and/or reinforcing box stitching shall secure the handle material to the top of the case at starting at 5 cm  $\pm$  0.5 cm from the top edge of the case. The carrying handles shall be constructed as per drawing #1 and viewing sample.
- 4.3 **Labelling** - A permanent label shall be placed on the inside of each case. The label information shall be as outlined below in a font no less than size 12. The text shall be permanent ink in a black white background material. The label shall measure 8 cm wide by 8 cm long with a tolerance of  $\pm$  0.5 cm in each direction. The label shall be completed in accordance with the following information in English and French.

**Note:** The printing on the label shall be positioned appropriately so when inserted into the lining of the case, all lines of print are clearly legible.

1. Print information as shown below.
2. Print information as shown below.
3. Print information as shown below.
4. Print information as shown below.
5. Date of manufacture, in numeric format year/month (Ex. 2001/11)
6. Your manufacturer identification (Company name or number).

1	Case, Carrying, Plate, Rifle
2	Étui de transport pour gilet pare-balles
3	RCMP #/N° GRC 120653
4	One Size – Taille unique
5	
6	

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 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 R.C.M.P., Uniform and 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 and Equipment Program.

5.2 The R.C.M.P., 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.

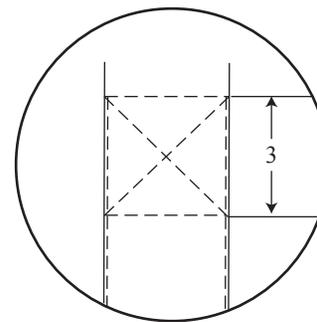
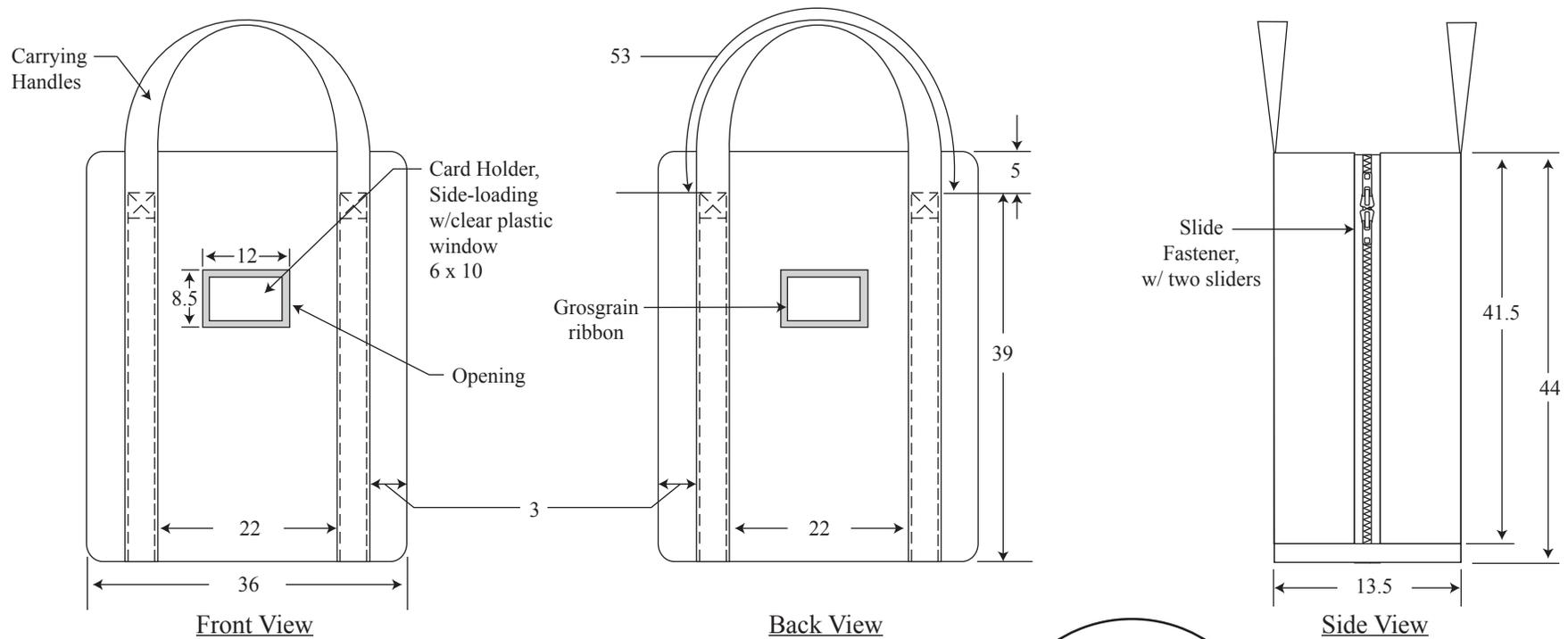
**TABLE I**  
**Shell Material**

REQUIREMENT		ACCEPTABLE TEST METHODS
1	Colour	Dark Navy, to match swatch available from RCMP Uniform & Equipment Program
2	Fibre Content	100% Nylon 1000 denier
3	Weave	Plain
4	Mass	Fabric: 285 g/m <sup>2</sup> - 363 g/m <sup>2</sup> (8.4 oz/yd <sup>2</sup> -10.7 oz/yd <sup>2</sup> ) Coating: 34 g/m <sup>2</sup> (1oz/yd <sup>2</sup> ) minimum
5	Yarns per cm	Warp: 13 min. Weft: 10 min.
6	Breaking Strength - Grab Method	Warp: 1300 N min. Weft: 1300 N min.
7	Tearing Strength - Tongue Method	Warp: 180 N (40.8 lbs) min. Weft: 180 N (40.8 lbs) min.
8	Resistance to Surface Wetting - Spray Method	100 initial
9	Colourfastness - To Crocking	Dry: Grade 4 or better Wet: Grade 3 or better
10	Colourfastness - To Perspiration	Grade 4 or better

CASE, CARRYING, RIFLE PLATE

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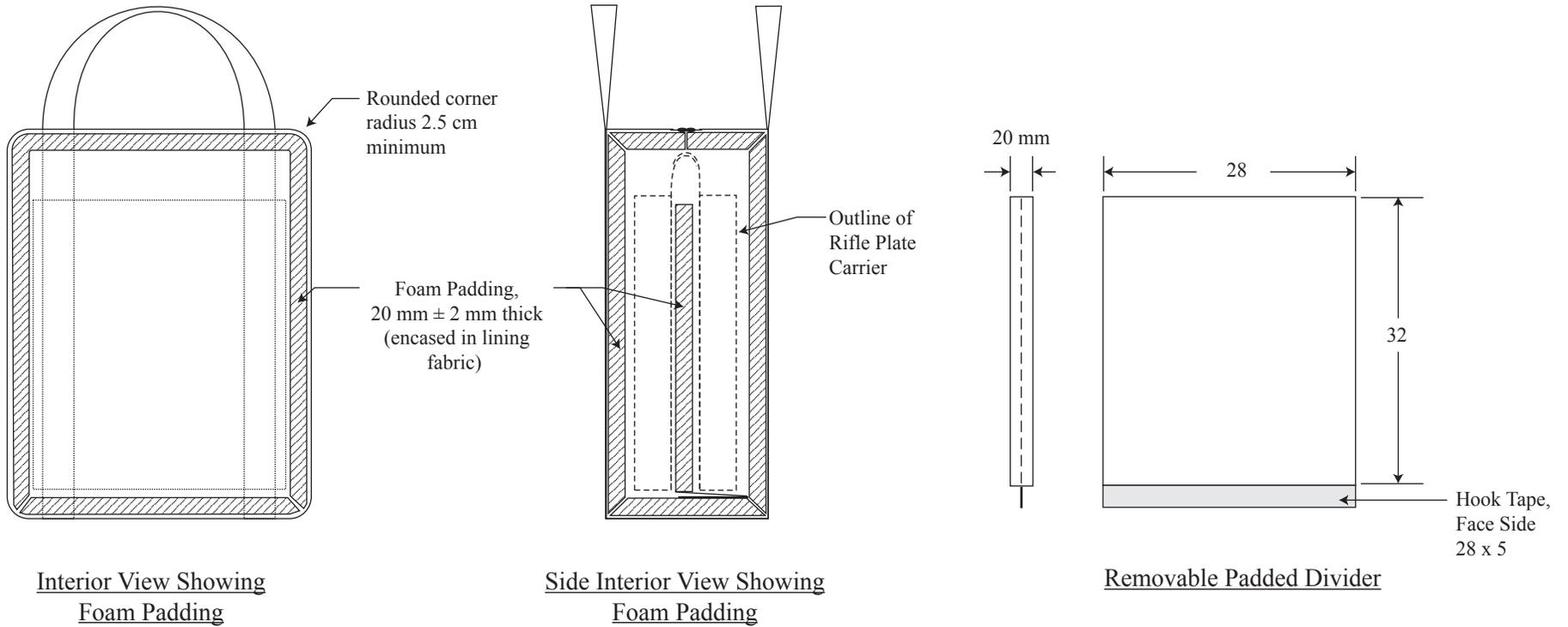
Dwg. 1



Stitching Detail of Carrying Handles

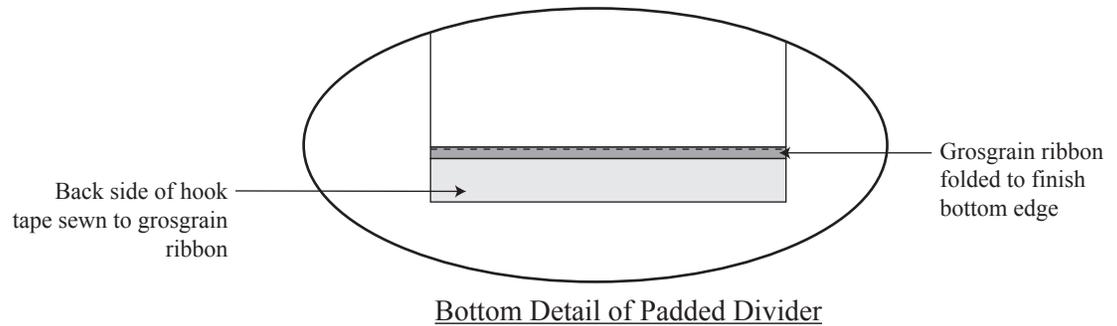
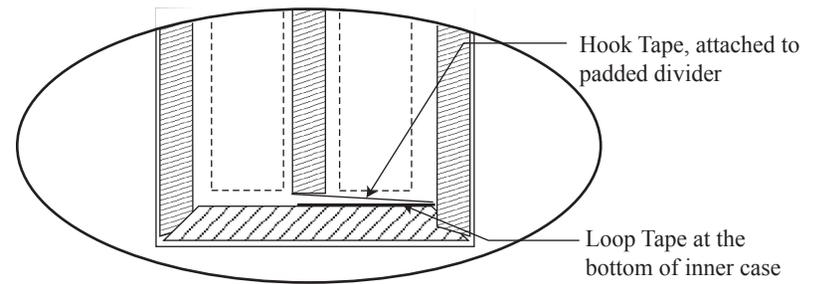
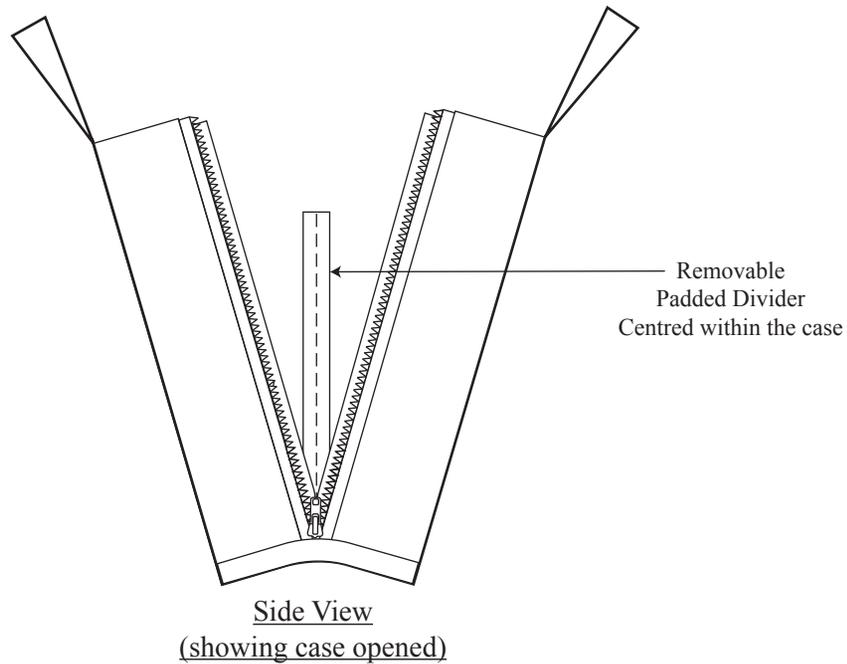
All Measurements in Centimetres unless otherwise indicated.  
Unless otherwise stated all measurements are subject to  $\pm 0.5$  cm tolerances.  
NOT TO SCALE

Dwg. 2



All Measurements in Centimetres unless otherwise indicated.  
Unless otherwise stated all measurements are subject to  $\pm 0.5$  cm tolerances.  
NOT TO SCALE

Dwg. 3



All Measurements in Centimetres unless otherwise indicated.  
Unless otherwise stated all measurements are subject to  $\pm 0.5$  cm tolerances.  
NOT TO SCALE