



Royal Canadian Mounted Police
Gendarmerie royale du Canada

Doc. no: G.S. 1045-195
Date: 2017-11-14

Specification

Case, Identification Badge

This document has 11 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 must 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 must be returned to the RCMP in the same condition as received by the manufacturer. Lost or damaged viewing samples must be replaced by an identical item or the RCMP must be reimbursed for the cost of an acceptable replacement.

SPECIFICATION
CASE, IDENTIFICATION BADGE

1. Definition

- 1.1 This specification must govern the manufacture and inspection of Case, Identification Badge. The specific item covered under this specification with stock numbers are as follows:
- i. 8631-100 Case, Identification Badge/Étui pour plaque d'identité
 - ii. 8504-100 Backing, Leather/Dessous en cuir
- 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, Identification Badge.
- 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 **American Society for Testing and Materials (ASTM)**
- | | |
|-----------------|--|
| D6075-13 | Standard Test Method for Cracking Resistance of Leather. |
| D5053-03 (2015) | Standard Test Method for Colorfastness of Crocking of Leather. |
| D2210-13 | Standard Test Method for Grain Crack and Extension of Leather. |
- 2.3 **US Government Mil-Spec**
- | | |
|------------|---------------|
| A-A-59826A | Thread, Nylon |
|------------|---------------|

3. General Requirements

- 3.1 The article or material covered by this specification must 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 must be equivalent in all respects to the viewing sample.
- 3.2 **Design** – The case must be constructed in leather designed to hold the RCMP Identification Badge in one section and an RCMP Identification Card in another section. The window of the Identification Card section must be protected by a piece of leather. The case must be designed in accordance with the drawings forming part of this specification and the viewing sample.

4. **Detail Requirements**

4.1 **Components**

- 4.1.1 **Leather** – The leather must be full grain vegetable tanned from fresh or cured packer steer hides. Dry hides must not be used. The finished leather must be thoroughly tanned and be firm, tight fibred and mellow. Loose or pipy leather will not be accepted. It must 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 appearance will be accepted in the finished leather. The grain side must be stained brown with a stain that will penetrate below the grain surface. A durable and colourfast finish must be applied on top of the stain. The colour and finish must match the viewing sample. Unless otherwise stated, the leather thickness must be from 2.3 to 2.7 mm. See Table I for leather characteristic requirements.
- 4.1.2 **Window Protection Flap Leather** – The leather must be a split pigskin, brown in colour, equal in all respects to the viewing sample. It must be 0.75 to 1.00 mm in thickness.
- 4.1.3 **Thread** – The thread must be twisted multifilaments bonded nylon, left twist, Tex 70, Type II, Class A, size E, with a minimum breaking strength of 9 pounds in accordance with U.S. government standard A-A-59826A, brown in colour to match the leather.
- 4.1.4 **Identification Card Window** – The window must be made of a clear scratch resistant polycarbonate film with a thickness of 0.254 mm (0.010”). The film Lexan* 8010 is known to meet this requirement.

- 4.2 **Dimensions** – The case must be shaped and dimensioned in accordance with the drawing.
- 4.3 **Construction**
- 4.3.1 **Stitching** – The stitching must be lockstitch using the thread specified in para. 4.1.3. The assembled case must be stitched in accordance with the drawing and viewing sample. The loose thread ends must be trimmed off close to the leather. Burning or "Flaming Off" the thread ends is not permitted. The beginning and ending of all stitching must be securely backstitch tacked, unless secured by other stitching. There must be no less than three nor more than 3.5 stitches per centimetre.
- 4.3.2 **Edge Finishing** – All edges must be stained and filled with a wax-type of matching brown edging ink and then burnished to a solid smooth and durable edge. Lacquer or varnish type edge finishes must not be used.
- 4.3.3 **Badge Cut-out** – One section must have a cut-out, shaped in accordance with the badge, and positioned 2.5 cm from the bottom edge in accordance with the drawing. The leather in which the cut-out is made must be must be from the leather specified in para. 4.1.1. The badge must fit within the cut-out firmly but not tightly.
- 4.3.4 **Identification Card Window** – A piece of plastic specified in para. 4.1.4 must be secured in the identification card section by two rows of stitching all around the inside frame edge, with no more than three stitches per centimeter using a 2 mm gauge from the edge.
- 4.3.5 **Window Protection Flap** – The flap must be the leather specified in para. 4.1.2, dimensioned 7.5 x 10 cm and attached with one row of stitching across the top end of the window section in accordance with the drawing and viewing sample.
- 4.4 **Leather Backing** – This item is a stand-alone item and is not required as part of the Case, Identification. It shall be purchased separately as 8504-100 Backing, Leather.
- 4.4.1 **Leather Backing** – The backing leather must made using leather specified in para. 4.1.1, but with a thickness of 1.25 mm to 1.35 mm. It must be dimensioned 6 x 8 cm in accordance with the drawing. The leather must be dye-cut with two square holes and one small circular hole in accordance to drawing 3.

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 may use his own facilities or any commercial testing establishment acceptable to the R.C.M.P., Uniform & Equipment Program.
- 5.2 The RCMP, 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 must 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.

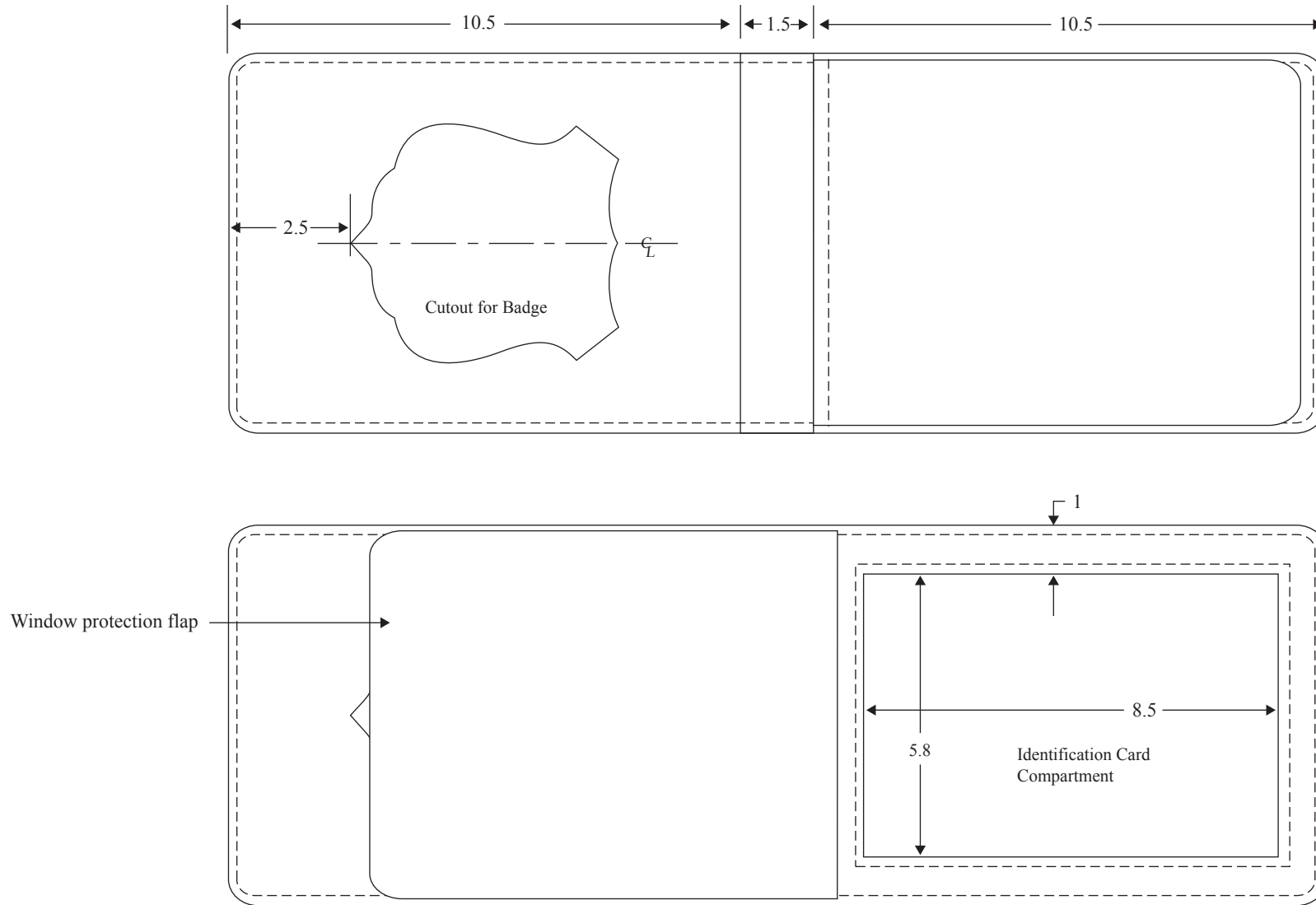
Table I
Leather Requirements

Property	Requirement	Test Method
Crocking	Good	• ASTM D5053-03 (2015)
Cracking, 11mm mandrel	None	• ASTM D6075-13
Grain Crack index, at RH of 65%	25 psi min.	• ASTM D2210-13

Drawing 1

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Case, Identification Badge Interior View



NOT TO SCALE

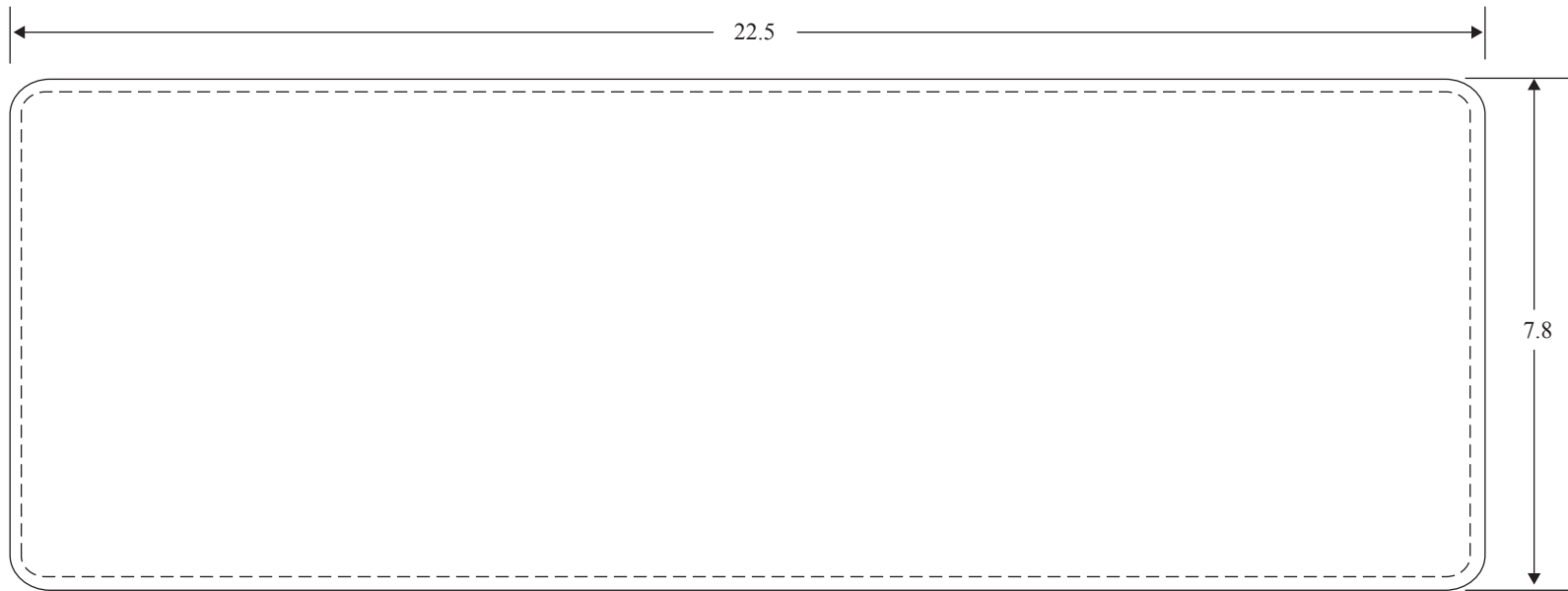
All measurements are shown in centimeters unless otherwise indicated.

Unless otherwise indicated all measurements are subject to ± 0.25 cm tolerances.

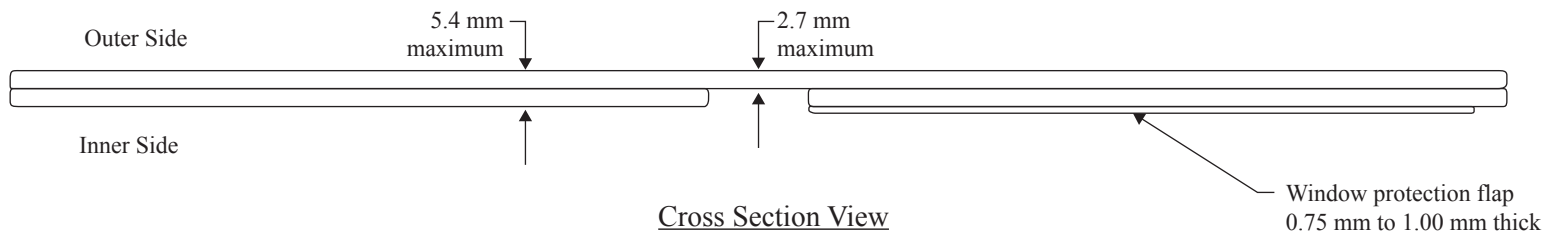
Drawing 2

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Case, Identification Badge



Outside View



Cross Section View

NOT TO SCALE

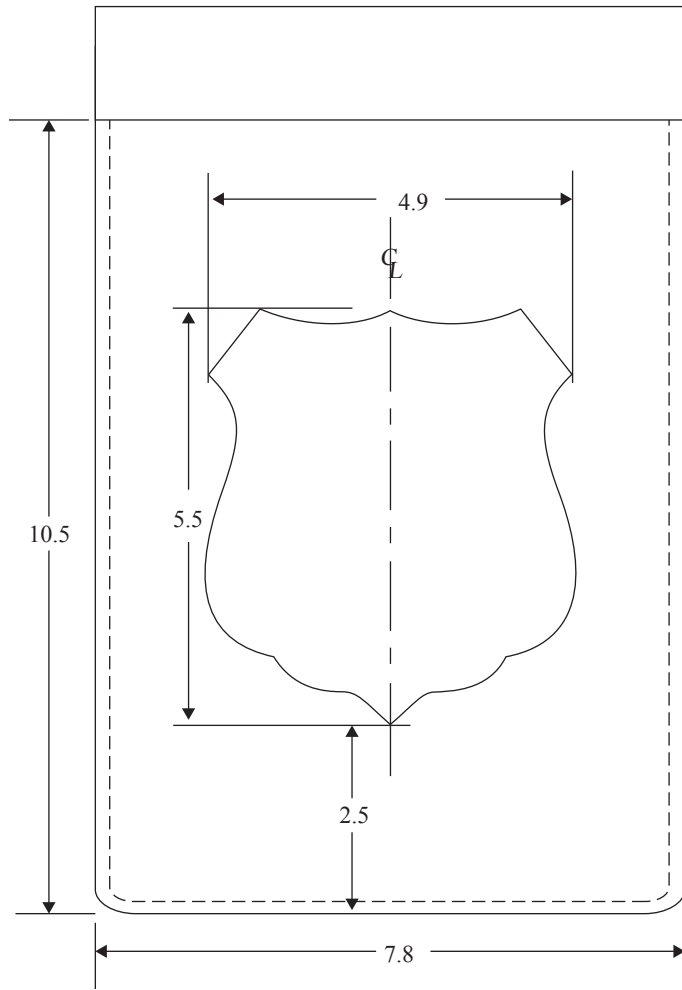
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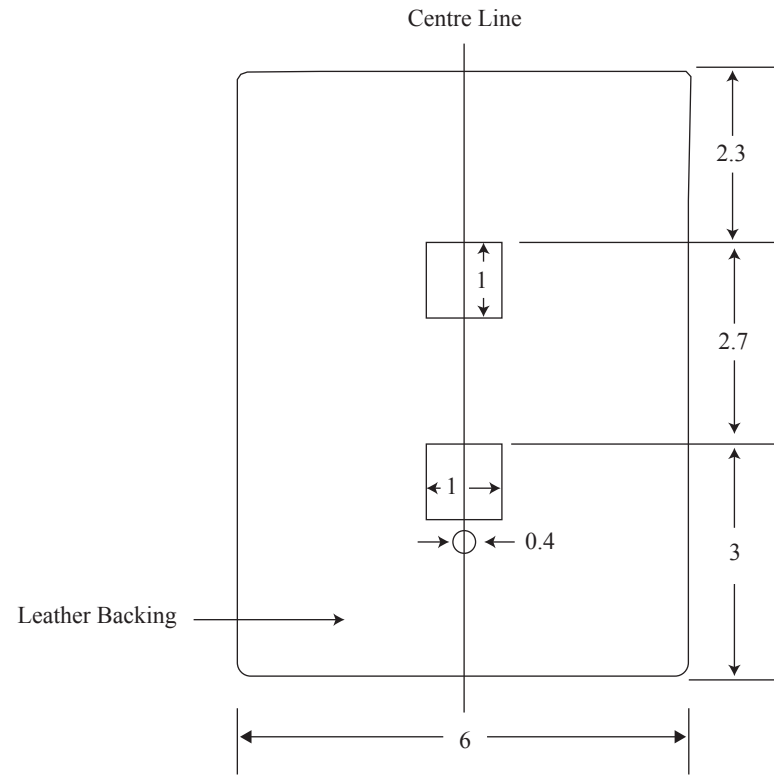
Drawing 3

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Case, Identification Badge



Cutout for Badge



Leather Backing Detail

TO SCALE IN ADOBE ILLUSTRATOR

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Unless otherwise indicated all measurements are subject to ± 0.25 cm tolerances.