



Royal Canadian Mounted Police  
Gendarmerie Royale du Canada

Doc. no: G.S. 1045-044  
Date: 2018-03-26

## Specification

# Gloves, Brown, Leather, Unlined, 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, BROWN, LEATHER, UNLINED, MALE & FEMALE**

**1. Definition**

- 1.1 This specification shall govern the manufacture and inspection of Gloves, Brown, Leather, Unlined, Male & Female. The specific items covered under this specification with stock numbers are as follows:
- i. 3675 Gloves, Brown, Leather, Unlined, Male / Gants en cuir bruns non doublés pour hommes;
  - ii. 3575 Gloves, Brown, Leather, Unlined, Female / Gants en cuir bruns non doubles pour femmes.
- 1.2 This specification, drawing, viewing sample, 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, Brown, Leather, Unlined, 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 **US Government Mil-Spec;**  
A-A-59826A 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 an unlined, slip-on type of glove with a snap fastener at the wrist for closure, equal in all respects to 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 0.8 mm and a maximum thickness of 1.0 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 brown colour, in accordance with the viewing sample.

- 4.1.2 **Thread** – The thread shall be nylon, meeting the requirements of U.S. government standard A-A-59826A. The colour shall match as closely as possible that of the leather.

- 4.1.2.1 **Silking** – The silking thread shall be Class A Type II, size "AA" meeting the requirements of U.S. government standard A-A-59826A.

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

- 4.1.3 **Snap Fasteners** – The snap fasteners shall be spring style, four piece, equal in all respects to the viewing sample.

- 4.2 **Sizes and Trank Measurements** – Gloves to this specification shall be supplied in the sizes specified by the RCMP and the trank measurement shall be in accordance with the following table:

MALE SIZES	TRANK MEASUREMENT IS WIDTH (FRENCH RULER) WHEN THE LEATHER IS STRETCHED COMPLETELY	
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
10½	12 INCHES	AND 0 LINES
11	12 INCHES	AND 6 LINES
11½	13 INCHES	AND 0 LINES
12	13 INCHES	AND 6 LINES

FEMALE SIZES	TRANK MEASUREMENT IS WIDTH (FRENCH RULER) WHEN THE LEATHER IS STRETCHED COMPLETELY	
6	6 INCHES	AND 9 LINES
6 ½	7 INCHES	AND 3 LINES
7	7 INCHES	AND 9 LINES
7 ½	8 INCHES	AND 3 LINES
8	8 INCHES	AND 9 LINES
8 ½	9 INCHES	AND 3 LINES
9	9 INCHES	AND 9 LINES
9 ½	10 INCHES	AND 3 LINES
10	10 INCHES	AND 9 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 style of the viewing sample. The fourchette patterns may be the one-piece or the two-piece type. The gloves shall be "Table Cut" with 18 lines (French ruler) added to the size, i.e. size 8 shall be "Table Cut" 9 inches and 6 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 Paras. 4.1.2.2. Where the stitching is done on a trimmer-equipped machine, the trimmer shall be adjusted in such a manner that not more than 1.5 mm of the original material shall be removed. There shall be not less than 3.5 or more than 4 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 13 mm.
- 4.3.3 **Silking** – The three rows of silking shall be done on a two-needle machine using the thread specified in Para. 4.1.2.1. 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 Glove** – The thumb, fourchettes and side closing of the glove shall be with outseam sewn with one row of stitching specified. The row of stitching shall be placed not less than 0.8 mm or 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 **Hemming** – After the glove is closed, the top shall be self-hemmed 6 mm. For the wrist opening on the palm portion of the glove, an extra strip of leather shall be inseam stitched to the shell and inwardly folded over and then stitched in place all around with two rows of stitching in accordance with the drawing and viewing sample. The fold shall be sufficiently wide where the snap fastener is located to have a double thickness of leather for snap reinforcement, in accordance with the viewing sample.
- 4.3.6 **Snap Fastener** – A four piece fastener in accordance with Para. 4.1.3, shall be positioned on the inside wrist in accordance with the drawing and viewing sample.
- 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 leather must be the same colour in all parts of both right and left glove in a pair. The gloves shall be paired and tacked together at approximately 13 mm from the end of the closing seam at the 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 (3675-000)
4. Date of Manufacture, in numeric format year/month (Ex. 2001/11)

5. **Quality Assurance Provisions**

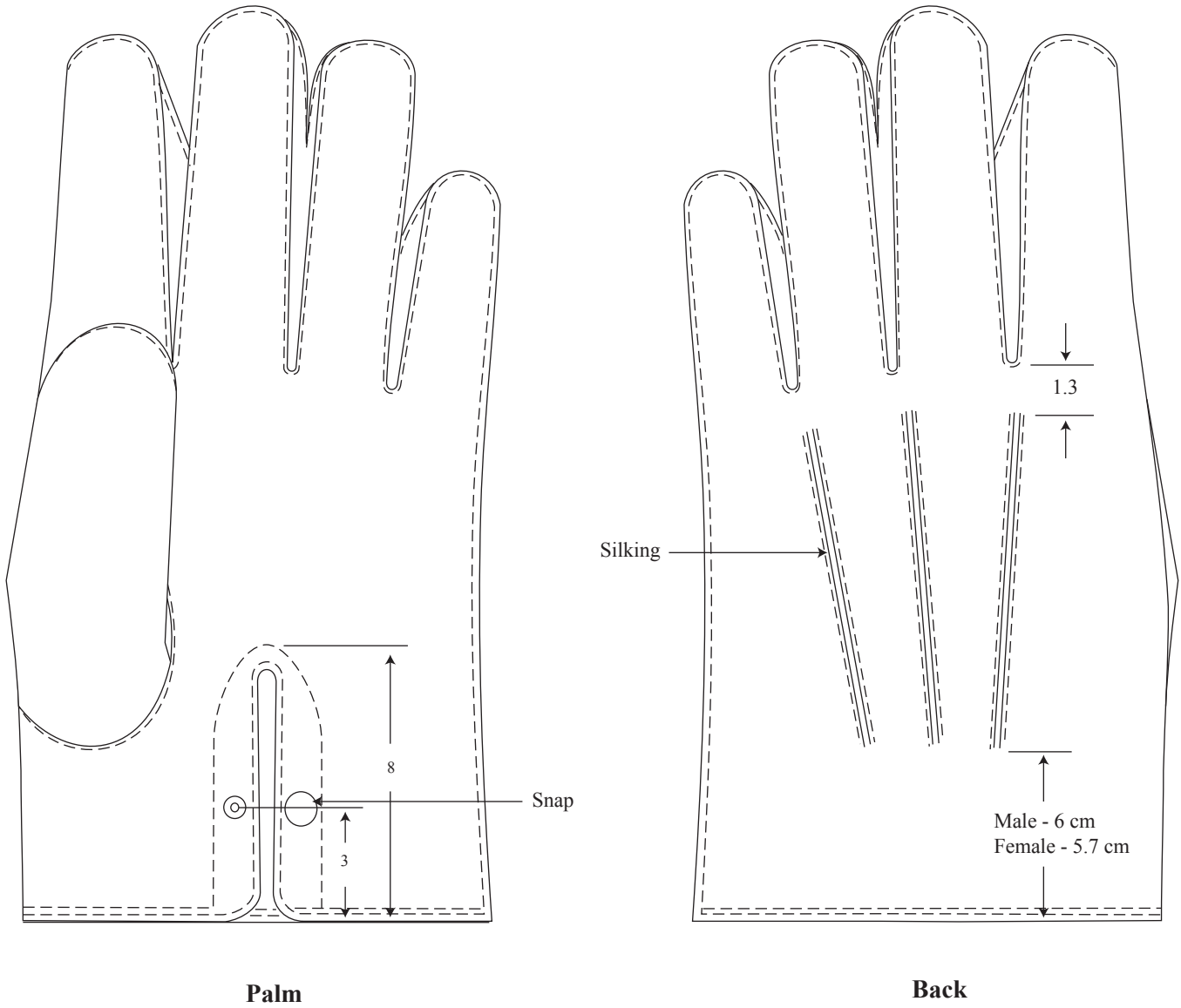
- 5.1 **Responsibility for Inspection** – Unless otherwise stipulated in the contract, it is the prime contractor's responsibility to satisfy the RCMP, Uniform and Equipment Program that the material and services being supplied conform to this specification. This may be accomplished by performing the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



# Drawing 1

G.S. 1045-044

Gloves, Brown, Leather, Unlined Male & Female



NOT TO SCALE

All measurements are shown in centimeters.

± 0.5 cm tolerance acceptable unless otherwise indicated.