

**EPAULETTES, SLIP-ON STYLE, FOR SERVICE DRESS AND
WORK DRESS UNIFORMS ITEMS 100 TO 199
CANADIAN COAST GUARD**



Petty Officer



No Braid No Cloth



Distinctive Cloth



1/2 Braid Stripe



1 Braid Stripe with
Distinctive Cloth



1 1/2 Braid Stripes



2 Braid Stripes



2 1/2 Braid Stripes



3 Braid Stripes



4 Braid Stripes



Broad Plain



Broad
with Heraldic Pin



Broad +1
with Heraldic Pin



Broad +2
with Heraldic Pin

1.0 GENERAL

1.1 SCOPE

1.1.1 STATEMENT OF WORK

1.1.1.1 This specification covers the fabrication and packaging of the Canadian Coast Guard epaulettes, slip-on style, for service dress and work dress uniforms, Items 100 to 199. The order form will identify the required rank braid and / or the Distinctive cloth (Occupation) for each pair of epaulette.

1.1.1.2 DESCRIPTION

Canadian Coast Guard epaulettes - Slip-on style – Work and Service Dress Uniforms

Epaulettes made of wool / polyester blend base fabric

All epaulettes are embroidered with a gold maple leaf with the exception of the Petty Officer epaulette.

1.2 APPLICABLE DOCUMENTS

1.2.1 CODES AND STANDARDS

AATCC-66-1994 Wrinkle Recovery of Fabrics: Recovery Angle Method

AATCC-135-1995 Dimensional Changes in Automatic Home Laundering of Woven or Knit Fabrics

CAN/CGSB-4.141-2001 Polyester/Cotton Twill Fabric, 255 g/m²

CAN/CGSB-4.131-93 Cotton-Covered or Polyester-Covered Polyester Thread

CAN/CGSB-4.139-94 Polyester Staple Thread

CAN/CGSB-4.2 Textile and Test Methods

CAN/CGSB-54.1-M90 Parts 1 and 2 - Stitches and Seams

1.2.2 ABBREVIATIONS

AATCC: American Association of Textile Chemists and Colourists

CGSB: Canadian General Standards Board

2.0 MATERIALS

The various components of the epaulettes shall be composed of the materials meeting or exceeding the minimum requirements as detailed in this specification.

2.1 BASE FABRIC

The shell material shall be in strict accordance with CAN/CGSB-4.141-2001, Polyester/Cotton Twill Fabric, 255 g/m².

2.1.1 FABRIC – FOR EPAULETTE ITEMS

Colour: Midnight blue as per sealed sample

Fisheries and Oceans
PSPC/CCG-100 TO 199
01-2018

PROPERTY PROPRIÉTÉ	Test Method Épreuves	Specified Spécifié	Minimum Minimum	Maximum Maximum
Weave Armure		2X2 twill, Serge Sergé à 2 x 2		
Yarn Fil		Warp: 2 ply Weft: 2 ply Chaîne: 2 plis Trame: 2 plis		
Mass Masse	5.1-M90*	256 g/m2	230 g/m2	
Woven Fabric count Yarns/cm Nombre de fils du tissu/cm	6-M89*	Warp/27 Weft/25 Chaîne/27 Trame/25	Warp/25.5 Weft/23.1 Chaîne/25,5 Trame/23,1	
Tensile Strength Force de traction	9.1-M90*		Warp 445N Weft 445N Chaîne 445N Trame 445N	
Quantitative Analysis of Fibre Mixture Analyse quantitative des mélanges de fibres	14.2-M88*	Wool: 65% Polyester: 35% Laine: 65% Polyester: 35%	Wool: 62% Polyester: 32% Laine: 62% Polyester: 32%	
Colourfastness to light Solidité des teintures à la lumière	18.3-97* (20 SFH)	L5	L4	
Colourfastness to crocking Solidité de la couleur au frottement	22-M90* Dry Cleaning Solvent Nettoyage à sec (solvant)	Grey Scale 4 Échelle de gris 4	Grey Scale 3.5 Échelle de gris 3.5	
Colourfastness to perspiration Solidité de la couleur à la sueur	23-M90*	Grey Scale 4 Échelle de gris 4	Grey Scale 3.5 Échelle de gris 3.5	
Dimensional Change in Dry Cleaning Variation dimensionnelle au nettoyage à sec	30-M90*			Warp: 2% Weft: 2% Chaîne: 2 % Trame: 2 %
Colourfastness to Dry Cleaning Solidité de la couleur au solvant de nettoyage à sec	29.1-M89*	Grey Scale 4 on Nylon strip Échelle de gris 4 sur la bande de nylon	Grey Scale 3.5 Échelle de gris 3.5	
Crease Recovery	AATCC-66-1998:option 2**	Warp: 80% Weft: 80% Chaîne: 80 % Trame: 80		

* Textile Test Method CAN/CGSB-4.2 / Méthode pour épreuves textiles CAN/CGSB-4.2

** AATCC Technical Manual

2.2 TRIMS

The component composition of these items shall meet or exceed the minimum requirements as detailed below.

2.2.1 RANK BRAID for 1.27 cm (1/2") , 0.64 cm (1/4") & 4 cm (1.6")
 Non-tarnishing gold rank braid

2.2.1.1 Yarns

Warp yarns

Fibre content: Cotton
 Size: 11 Tex, 2 ply
 Colour: Dyed gold as per sealed sample

Weft yarn

Composite thread
 Fibre content: Produced from a non-tarnishing metallized polyester strip wrapped around a nylon core
 Widths: 0.64 cm (1/4") and 1.27 cm (1/2")
 Size: 20-30 tex
 Colour: The core of gold yarn is to be a light yellow shade.

The wrapping is to be such that the composite thread has an even lustrous appearance free from noticeable gaps where core yarn is seen. Gold coloured thread is to conform to the colourfastness requirements of table III.

2.2.1.2 RANK BRAID PROPERTIES

TABLE III GOLD BRAID			
PROPERTY	TEST METHODS CAN/CGSB	SPECIFIED	MINIMUM
Colourfastness to light	18.3-M90*	L5	
Colourfastness to Dry Cleaning	29.1-M*	Grey Scale 5	Grey Scale 4

2.2.1.3 RANK BRAID CONSTRUCTION

The rank braid is to be uniformly woven to the appearance of the sealed sample and to conform to the construction details of table IV. The braid is to be of even width, free from splits or cracks in the weft cover of the warp, with firm and straight selvages.

TABLE IV CONSTRUCTION OF GOLD BRAID			
WIDTH	NUMB. OF WRAP ENDS	WEFT PICKS	MASS
4.00 cm (1 3/4")	265 ±2	88 ±2	217 g/m
1.27 cm (1/2")	84 ±2	88 ±2	69 g/m
0.64 cm (1/4")	42 ±2	88 ±2	34.5 g/m

The attached Appendix "A" and "B" provide details on combinations and placement.

2.2.2 FUSIBLE INTERLINING

Fibre content: Polyamide / polyester blend, medium hand
Construction: Non-woven
Colour: Black

The fusible interlining shall be suitable for the intended purpose of retaining the shape of the epaulette. Fusing conditions shall be in strict accordance with those recommended by the fusible interlining supplier. There shall be no evidence of distortion, delamination or bubbling.

2.2.3 THREAD For seaming, serging and stitching (Refer to CAN/CGSB-4.139-94)

Fibre content: 100% Staple polyester
Size: R35 Tex
Colour: To match material being sewn (base cloth, braid or felt)

OR (Refer to CAN/CGSB-4.131-93)

Fibre content: 100% Wrapped polyester core
Size: R35 Tex
Colour: To match material being sewn (base cloth, braid or felt)

2.2.4 MAPLE LEAF EMBROIDERY

Stitch count: 926
Thread: 42% Polyamide / 36% polyester / 22% diverse
Colour: Metallic gold to match rank braid

The colour shall resist 100 (home or commercial) washes.
The colour shall not bleed under any condition.

2.2.5 DISTINCTIVE CLOTH

Fibre content: 65% Rayon / 35% wool blend felt
Weight (\pm 5%): 195 g/m² (5.75 oz/yd²)
Colour: In strict accordance with sealed samples of Distinctive Cloth

2.2.5.1 DISTINCTIVE COLORS AND RELATED OCCUPATIONS

BRANCH	COLOUR
Command and Operations Centres and Fleet Shore Side	Aqua
Environmental Response	Brown
Deck and Fleet Shore Side	Midnight Blue *
Incident Management	Orange
Integrated Technical Services	Emerald Green
Logistics and Supply	White
Marine Electrical and Electronic	Dark Green
Marine Engineer	Purple
Maritime Security	Maroon
Medical	Scarlett
Programs	Light Blue
Search and Rescue and Inshore Rescue Boat	Silver
Training, College	Royal Blue

* Midnight Blue distinctive colour is the natural colour of the epaulette slip on.

3.0 CUTTING

All shell component parts of each epaulettes shall be cut from one piece of cloth and in accordance with the best practice of the trade to ensure the best wearing qualities, the best appearance and a minimum of seam pulling, twisting and puckering.

4.0 STITCHES, SEAMS AND SERGING

All stitch, seam and serging types shall be in accordance with CAN/CGSB 54.1-M90 Parts 1 and 2.

4.1 Stitches and seams

All seaming and stitching shall be lockstitched and have a minimum of 4-5 stitches per cm (10-12 per inch).
Joining seam shall be a minimum of 6mm (1/4") wide and shall be securely backstitched at both ends.

4.2 Serging

All exposed cut edges shall be serged using a thread serger (stitch type 504). There shall be no less than 3 stitches per cm (8 per inch).

4.3 Embroidery

All epaulettes shall be machine embroidered with a gold maple leaf. The number of cover stitches shall be sufficient to completely cover the base cloth.

The design and size of the maple leaf shall be as shown on drawing 1 and drawing 2. All maple leafs shall be 25 mm in height and 25 mm in width with the exception of the maple leaf on the broad band +2 epaulette where the maple leaf is to be 21 mm in height and 21 mm in width.

Maple leafs are to be positioned as follows:

-Position of the maple leaf for gold braided or gold braided / Distinctive Cloth or Distinctive Cloth only epaulettes:

The maple leaf shall be centred in width at the top of the epaulette (its narrowest point) at a distance of 0.64 cm (1/4") from the finished top edge, as shown in Appendix "A".

-Position of the maple leaf for non braided or Distinctive Cloth epaulette:

The maple leaf shall be fully centred on each epaulette.

5.0 RANK BRAIDS AND DISTINCTIVE CLOTH

The gold braid shall be top stitched, along each edge, to the epaulette with a gold matching thread.

The Distinctive Cloth, when required, shall be caught into the braid assembly stitch.

When a single felt with braid is used, the top edge of the felt shall be folded under the appropriate width and stitched. The bottom edge shall be secured in the top stitch of the braid.

Appendix "A" braid diagrams details the various braid and Distinctive Cloth placements.

Appendix "B" details the number of gold braid stripe combinations and their specific position on the epaulette.

6.0 CONSTRUCTION

The finished epaulette shall be constructed to correspond to the dimensions specified in the drawings.

The edges of the opening shall be serged, turned under 0.95 cm (3/8") and stitched 0.48 cm (3/16") gauge.

The joining seam shall be 0.64 cm (1/4") wide and pressed open. Edges shall be serged.

The finished epaulette shall be pressed flat with the assembly seam centred on the underside.

The finished epaulette shall show no evidence of distortion or puckering.

7.0 PACKAGING

Epaulettes shall be paired and poly-bagged.

Packaging shall be in accordance with best commercial standards.

7.1 Identification markings

The outside of each shipping package shall clearly indicate:

-Occupation enclosed

-Stock number

This specification is RECOMMENDED by:

Clothing Advisory Consultant
Clothing and Textiles Division
Public Works and Government Services Canada

Aug 8th, 2005

Date

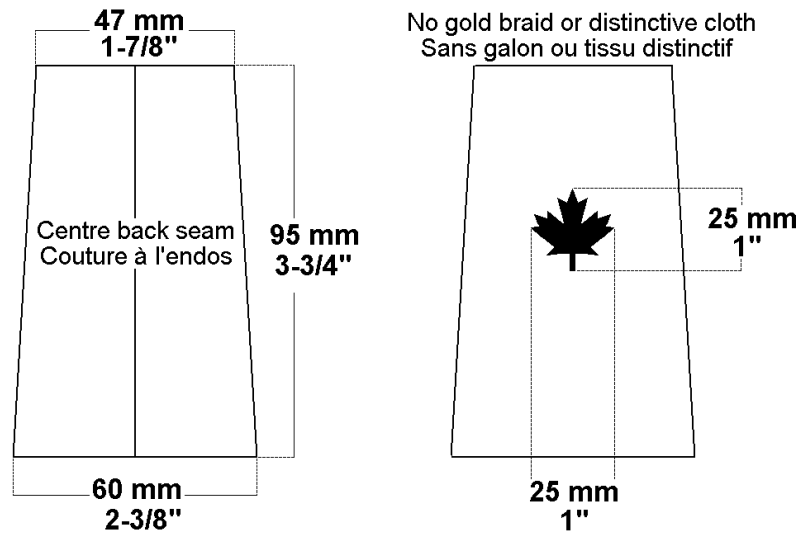
APPROVED FOR FISHERIES & OCEANS BY:

Senior Operations Policy Analyst
Programs and Operational Support, CCG Fleet
Canadian Coast Guard / Fisheries & Oceans Canada

Aug 8th, 2005

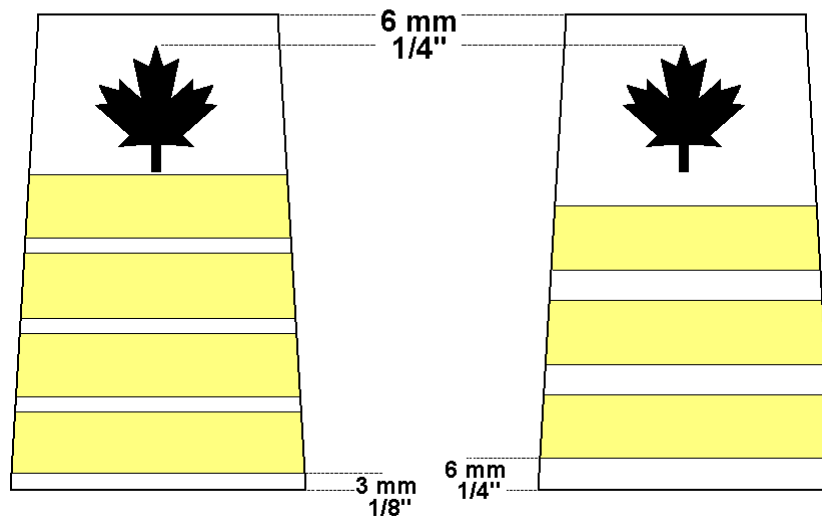
Date

DRAWING I
OFFICER EPAULETTE LAYOUT



Not to scale
Non à l'échelle

With Braid and Distinctive cloth if required
Avec galon et tissu distinctif si requis



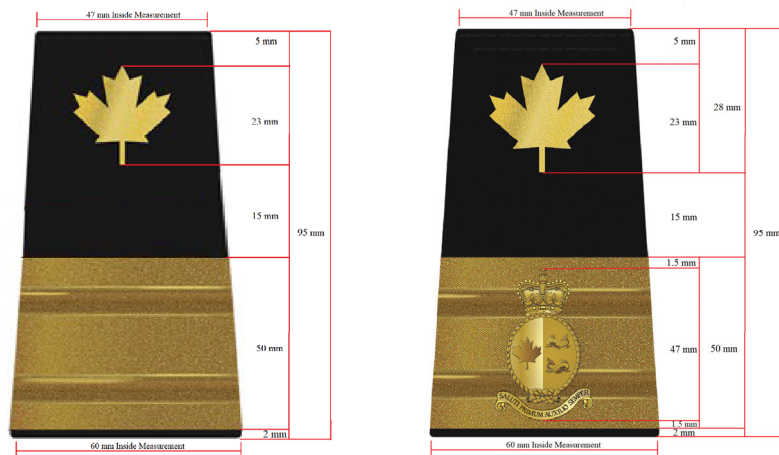
Opening dimensions are taken with the epaulette laid flat and are the inner edge-to-edge measure.

DRAWING 2

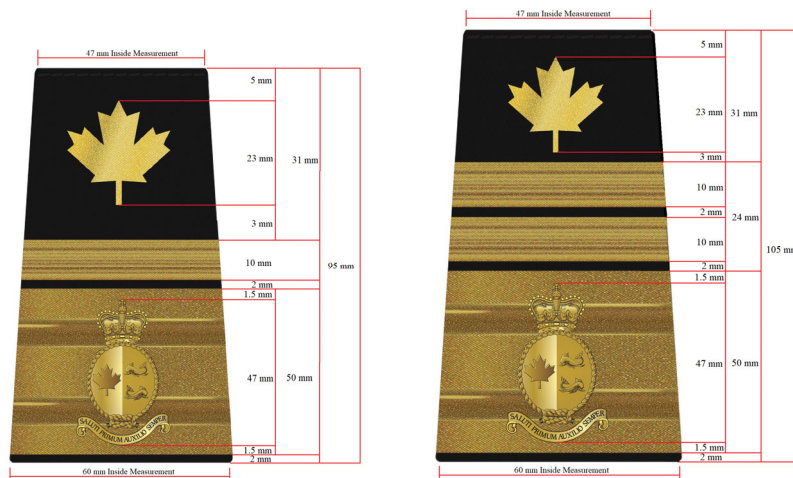
SENIOR OFFICER EPAULETTE LAYOUT









The Canadian Coast Guard Heraldic Badge and moto is to be embroidered onto the epaulette.


- Opening and overall size dimensions for Senior Officer epaulettes are the same as for Officer Epaulettes as depicted in Diagram 1 with the exception of the Broad Band plus 2 bands which is 105 mm in length.
- All Maple Leaves have a height of 23 mm and width of 23 mm




















Not to scale
Non à l'échelle




















ITEM #	EPAULETTE DESCRIPTION	DESIGN
100	EPAULETTE, PETTY OFFICER EPAULETTE, SOUS-OFFICIER	
101	EPAULETTE, OFFICER CADET EPAULETTE, ÉLÈVE OFFICIER	
102	EPAULETTE, DECK, OFFICER CADET, FINAL YEAR,-1/2 EPAULETTE, PONT, ÉLÈVE OFFICIER, DERNIERE ANNEE,-1/2	
103	EPAULETTE, DECK, 1 EPAULETTE, PONT, 1	
105	EPAULETTE, DECK & FLEET SHORE SIDE, 2 EPAULETTE, PONT ET FLOTTE CÔTÉ TERRE, 2	
106	EPAULETTE, DECK & FLEET SHORE SIDE, 2-1/2 EPAULETTE, PONT ET FLOTTE CÔTÉ TERRE, 2-1/2	
107	EPAULETTE, DECK & FLEET SHORE SIDE, 3 EPAULETTE, PONT ET FLOTTE CÔTÉ TERRE, 3	
108	EPAULETTE, DECK & FLEET SHORE SIDE, 4 EPAULETTE, PONT ET FLOTTE CÔTÉ TERRE, 4	









ITEM #	EPAULETTE DESCRIPTION	DESIGN
109	EPAULETTE, OFFICER CADET, ENGINEER ÉPAULETTE, ÉLÈVE OFFICIER, MACHINES	
110	EPAULETTE, ENGINEER, OFFICER CADET, FINAKL YEAR,-1/2 ÉPAULETTE, MACHINES, ÉLÈVE OFFICIER, DERNIERE ANNEE,-1/2	
111	EPAULETTE, ENGINEER, 1 ÉPAULETTE, MACHINES, 1	
113	EPAULETTE, ENGINEER, 2 ÉPAULETTE, MACHINES, 2	
114	EPAULETTE, ENGINEER, 2-1/2 ÉPAULETTE, MACHINES, 2-1/2	
115	EPAULETTE, ENGINEER, 3 ÉPAULETTE, MACHINES, 3	
116	EPAULETTE, ENGINEER, 4 ÉPAULETTE, MACHINES, 4	
120	EPAULETTE, LOGISTICS, 2 ÉPAULETTE, LOGISTIQUE, 2	
121	EPAULETTE, LOGISTICS, 2-1/2 ÉPAULETTE, LOGISTIQUE, 2-1/2	


ITEM #	EPAULETTE DESCRIPTION	DESIGN
125	EPAULETTE, MARINE ELECTRICAL & ELECTRONICS, 1-1/2 ÉPAULETTE, ÉLECTRICITÉ ET ÉLECTRONIQUE MARINE, 1-1/2	
126	EPAULETTE, MARINE ELECTRICAL & ELECTRONICS, 2 ÉPAULETTE, ÉLECTRICITÉ ET ÉLECTRONIQUE MARINE, 2	
127	EPAULETTE, MARINE ELECTRICAL & ELECTRONICS, 2-1/2 ÉPAULETTE, ÉLECTRICITÉ ET ÉLECTRONIQUE MARINE, 2-1/2	
128	EPAULETTE, MARINE ELECTRICAL & ELECTRONICS, 3 ÉPAULETTE, ÉLECTRICITÉ ET ÉLECTRONIQUE MARINE, 3	
129	EPAULETTE, ITS, -1/2 ÉPAULETTE, STI, -1/2	
130	EPAULETTE, ITS, 1 ÉPAULETTE, STI, 1	
133	ÉPAULETTE, ITS, 2-1/2 EPAULETTE, STI, 2-1/2	
134	ÉPAULETTE, ITS, 3 EPAULETTE, STI, 3	
138	EPAULETTE, MEDICAL, 2 ÉPAULETTE, MÉDICAL, 2	

ITEM #	EPAULETTE DESCRIPTION	DESIGN
140	EPAULETTE, MEDICAL, 3 ÉPAULETTE, MÉDICAL, 3	
142	EPAULETTE, TRAINING, 1 ÉPAULETTE, FORMATION, 1	
144	EPAULETTE, TRAINING, 2 ÉPAULETTE, FORMATION, 2	
145	EPAULETTE, TRAINING, 2-1/2 ÉPAULETTE, FORMATION, 2-1/2	
146	EPAULETTE, TRAINING, 3 ÉPAULETTE, FORMATION, 3	
148	EPAULETTE, PROGRAMS, 1 ÉPAULETTE, PROGRAMMES, 1	
149	EPAULETTE, PROGRAMS, 1 1/2 ÉPAULETTE, PROGRAMMES, 1-1/2	
150	EPAULETTE, PROGRAMS, 2 ÉPAULETTE, PROGRAMMES, 2	
151	EPAULETTE, PROGRAMS, 2-1/2 ÉPAULETTE, PROGRAMMES, 2-1/2	

ITEM #	EPAULETTE DESCRIPTION	DESIGN
152	EPAULETTE, PROGRAMS, 3 ÉPAULETTE, PROGRAMMES, 3	
153	EPAULETTE, SAR, IRB COXSWAIN,-1/2 ÉPAULETTE, SAR, PATRON D'EMBARCATIONS DE SAUVETAGE CÔTIER,-1/2	
155	EPAULETTE, SAR, 1-1/2 ÉPAULETTE, SAR, 1-1/2	
156	EPAULETTE, SAR, 2 ÉPAULETTE, SAR, 2	
157	EPAULETTE, SAR, 2-1/2 ÉPAULETTE, SAR, 2-1/2	
158	EPAULETTE, SAR, 3 ÉPAULETTE, SAR, 3	
161	EPAULETTE, ENVIRONMENTAL RESPONSE, 1-1/2 ÉPAULETTE, INTERVENTION ENVIRONNEMENTALE, 1-1/2	
162	EPAULETTE, ENVIRONMENTAL RESPONSE, 2 ÉPAULETTE, INTERVENTION ENVIRONNEMENTALE, 2	
163	EPAULETTE, ENVIRONMENTAL RESPONSE, 2 1/2 ÉPAULETTE, INTERVENTION ENVIRONNEMENTALE, 2 1/2	

ITEM #	EPAULETTE DESCRIPTION	DESIGN
164	EPAULETTE, ENVIRONMENTAL RESPONSE, 3 ÉPAULETTE, INTERVENTION ENVIRONNEMENTALE, 3	
166	INCIDENT MANAGEMENT, 1-1/2 GESTION DES INCIDENTS, 1-1/2	
167	INCIDENT MANAGEMENT, 2 GESTION DES INCIDENTS, 2	
168	INCIDENT MANAGEMENT, 2-1/2 GESTION DES INCIDENTS, 2-1/2	
169	INCIDENT MANAGEMENT, 3 GESTION DES INCIDENTS, 3	
172	MARITIME SECURITY, 1-1/2 SÉCURITÉ MARITIME, 1-1/2	
173	MARITIME SECURITY, 2 SÉCURITÉ MARITIME, 2	
174	MARITIME SECURITY, 2-1/2 SÉCURITÉ MARITIME, 2-1/2	

ITEM #	EPAULETTE DESCRIPTION	DESIGN
175	MARITIME SECURITY, 3 SÉCURITÉ MARITIME, 3	
178	COMMAND AND OPERATIONS CENTRES AND FLEET SHORE, 1-1/2 LES CENTRES DE COMMANDEMENT ET D'OPÉRATIONS ET LA FLOTTE À TERRE, 1-1/2	
179	COMMAND AND OPERATIONS CENTRES AND FLEET SHORE, 2 LES CENTRES DE COMMANDEMENT ET D'OPÉRATIONS ET LA FLOTTE À TERRE, 2	
180	COMMAND AND OPERATIONS CENTRES AND FLEET SHORE, 2-1/2 LES CENTRES DE COMMANDEMENT ET D'OPÉRATIONS ET LA FLOTTE À TERRE, 2-1/2	
181	COMMAND AND OPERATIONS CENTRES AND FLEET SHORE, 3 LES CENTRES DE COMMANDEMENT ET D'OPÉRATIONS ET LA FLOTTE À TERRE, 3	
196	EPAULETTE, SENIOR DIRECTOR, EXECUTIVE DIRECTOR ÉPAULETTE, DIRECTEUR SENIOR, DIRECTEUR EXÉCUTIF	
197	EPAULETTE, ASSISTANT COMMISSIONER & DIRECTOR GENERAL ÉPAULETTE, COMMISSAIRE ADJOINT & DIRECTEUR GÉNÉRAL FLOTTE	
198	EPAULETTE, DEPUTY COMMISSIONER ÉPAULETTE, SOUS-COMMISSAIRE	

ITEM #	EPAULETTE DESCRIPTION	DESIGN
199	EPAULETTE, COMMISSIONER ÉPAULETTE, COMMISSAIRE	

APPENDIX "B"

**NUMBER OF GOLD BRAID STRIPE COMBINATIONS
AND THEIR SPECIFIC POSITION ON THE EPAULETTE**

Number of Gold Braid Stripes	Width & Number per epaulette			Distance between gold braid stripes	Distance from bottom edge to first gold stripe
	6mm (1/4 po)	10 mm po)	4 cm (1 9/16")		
1 Broad +2		2	1	2 mm (5/64")	2mm (5/64")
1 Broad +1		1	1	2 mm (5/64")	2mm (5/64")
1 Broad			1	n/a	2mm (5/64")

Number of Gold Braid Stripes	Width & Number per epaulette			Distance between gold braid stripes	Distance from bottom edge to first gold stripe
	6mm (1/4 po)	13mm (9/16 po)	4 cm (1 9/16")		
4		4		3mm (1/8 ")	3mm (1/8 ")
3		3		6mm (1/4 ")	6mm (1/4 ")
2-1/2	1	2		6mm (1/4 ")	6mm (1/4 ")
2		2		6mm (1/4 ")	6mm (1/4 ")
1-1/2	1	1		6mm (1/4 ")	6mm (1/4 ")
1		1		n/a	6mm (1/4 ")
1/2	1			n/a	6mm (1/4 ")
1 distinctive cloth only				n/a	6mm (1/4 ")