

**APPENDIX 3
MANUFACTURING DATA FOR BODY BEARSKINS**

1. Raw fur must be

1.1 Black Americanus Bear

1.2 Trapped in spring either before the end of hibernation or immediately after hibernation before the bear sheds its heavy winter coat for its new summer one.

1.3 Adult male or female bear. Cubs are not acceptable.

1.4 Only the prime part (backs) is used. From just behind the shoulders to the rump and partially down the sides. Head, front paws, and flanks are removed before dyeing, as these parts are not acceptable. The tail and hind paws are left on in order to locate the straight of the back.

1.5 The color must be completely black, having no brown spots or brown underfur.

1.6 Prime pelts will have long, flexible guard hair coming through a thick growth of soft under-hair that are silky but not "wooly".

1.7 Must not have any bare or nearly bare sections. Hair must be thick and silky throughout.

1.8 Without holes, moths, knots and the skin itself must be strong and moist not dry. The hair should be slightly greasy and have a luster.

1.9 Hair must not be trimmed by any method.

1.10 Obtained in its natural state without any preservative such as salt or urine, as this interferes with the preserving agents in the finishing and dyeing processes.

1.11 Should not be exposed too long to the sun it will fall apart like jelly in processing.

1.12 Hair should not have singed (split) ends.

1.13 It is estimated that only one hat can be made per skin, with the best skins being reserved for Officers, as these skins are extremely rare.

2. Bearskins

2.1 Finishing

2.1.1 Must be done without any preservatives on skins especially salt as this causes skins to fall apart when processed or right after processing;

2.1.2 Pelt must be hand skinned to the desired thickness and handled very carefully;

2.1.3 Heads, front paws and flanks are removed before dyeing:

- a. Because they are not used in bearskins;
- b. To dye them for nothing is costly; and
- c. The smaller the size of the skin the more skins can be processed per batch.

3. **Dyeing**

3.1 Jet-black dye with slightly shiny finish is done in a drum with oil. Mothproofing is added to the dye bath.

4. **Cleaning**

4.1 Skins should not be cleaned like a fur coat is with a spirit type cleaner. This will cause the skins to dry and disintegrate.

4.2 Hats have to be taken apart and cleaned using the same process as in the original dyeing.

4.3 Hats must be resized and put on new baskets as skins shrink after cleaning.

4.4 These hats may also be cleaned by using an extremely fine hardwood (not softwood as it contains an oil) or coconut shell sawdust mixed with carbon tetrachloride or other dry cleaning fluids.

4.5 Holding the hat in one hand and wearing protective gloves, gently work the sawdust into the fur, a small area at a time.

4.6 When the hat has been completely treated with the sawdust mixture (fine sawdust and wood flour), gently shake the hat to remove the sawdust.

4.7 With a strong blower, blowout more of the sawdust.

4.8 Finally, with a soft brush and a large toothed comb, gently comb out the tangles and brush out the remaining sawdust.

4.9 The hat should be restored to a fine luster.

4.10 To be done by trained personnel or a professional furrier only.

5. **Dressing**

- 5.1 Hats should be gently combed with a comb (preferably in bone and large toothed, such as a dog's comb) to remove knots, etc and to establish the shape.
- 5.2 The fur should then be wet with warm water, brushed and left to dry overnight.
- 5.3 When dry, a good shaking holding the hat in an upside down position should give the desired shape fully rounded on top with long hair reaching down the bridge of the nose, the back neck coming down into to ducktail shape.

6. **Makeup**

- 6.1 No seams should show in the fur. This can only be obtained by hand sewing.
- 6.2 Long hair should match with long hair not as in a fur coat, long to short.
- 6.3 The hair should lie downwards on the sides but keep a rounded top without hair separating and flopping down. The top of the Cap should never be brushed or combed down. Partial inverted immersion is not bad for Caps. Let dry and shake out.
- 6.4 The center line of the back of the skin should lie down the center back of the hat and also down the center front. Otherwise the hat will always pull and look offside.
- 6.5 Fur should be cut in three pieces sewn, soaked, stretched and blocked to shape.

7. **Baskets**

- 7.1 Made of buff willow branches cut in autumn (22 September to 21 December) and boiled. Six (6)-foot lengths are used with butts to the bottom of the basket at the front going up to bend at the top and descend to the lower strut, wrapped and cut off. Usually the last two feet are thrown away as it is too thin and weak. The willow is easier shaped when wet.
- 7.2 Cane (rattan or bamboo) may also be used. It is heavier than willow but stronger.
- 7.3 Lacing is also done with split willow but plastic could also be used.
- 7.4 The front of the frame should be made straight up and flat so as to avoid angling the hair directly into the user's eyes. The crown should be rounded with the bottom sloping in into the bottom band.

- 7.5 The middle cross (2nd strut) must be sufficiently high to fill out the back of the hat to give a rounded appearance and not a bullet shaped appearance.
- 7.6 Each size hat has its own basket size. The bottom band of the basket governs the size of the hat, 3/8-inch difference from one hat size to another and rest of frame graded accordingly. Officers and guards have different frames (baskets).
- 7.7 Must have at least twelve (12) different frames and twelve (12) different blocks to stretch the skins.

8. **Leather**

- 8.1 Needs a good heavy quality black leather to be blocked tight into the hat so that it will retain its shape and not pull or fallout. Therefore, it must have long fingers to stretch right across the top of the head to form a good headrest. The lacing should be minimal. Leather sewn onto felt on the outside turned inside and blocked so stitching will not show on outside.
- 8.2 Workable black, grain kips leather.
- 8.3 Fingers are to have eyelets and fitted with a string.
- 8.4 Cut in two pieces joined on either side of the Cap.

9. **Felt**

- 9.1 Heavy (double) felt, stiffened with a suitable agent, must be used and is sewn with linen thread (or plastic lacing) by hand, to the bottom of the basket. Felt is sewn (not stapled) together (butted) as a continuous circle not overlapped on the ends. Should be seamless if possible.

10. **Plume Sockets**

- 10.1 Set right inside the pelt, not on the outside.
- 10.2 Plastic is better than leather as it lasts longer.
- 10.3 Left-hand side 2-1/2 inches up from bottom edge of the cap.
- 10.4 Located exactly midway between front and back.

11. **Air Vent**

11.1 Put in after fur is pulled onto the frame.

11.2 Should be inserted through two small slits, perpendicular to each other, with the points folded back and not by cutting a hole in the skin. A hole causes the grommets to pull out.

11.3 Are put in at every second rib around the cap and there can be as many as desired.

11.4 Should be below the second strut.

11.5 Black japanned prong type.

11.6 Must be masked by fur and invisible from outside.

12. **Hooks**

12.1 Two large hooks, 1-1/2 inches long, shall be located inside the cap, on the felt foundation, 2-1/2 inches up from the bottom over the ear area. These hooks will engage with the leather strap on the curb chain.

12.2 Should be brass, black-japanned finish.

13. **Ring:**

13.1 A small ring should also be located on the outside of the cap, on the left-hand side, 7-inches above the plume socket to engage with the hook on the plume.

14. **Shape**

14.1 Should be round sloping down to a ducktail at the back.

15. **Storage**

15.1 Caps should be stored on a hat stand, inside a large, sturdy box of dimensions larger than the hat and stand.

15.2 The box must be able to withstand stacking and be capable of being sealed against dust and moths.

15.3 Storage should be in a cool, but not damp or dry room.

16. **Sizes:**

16.1 Caps shall be supplied according to the sizes below. Each Cap shall have the size, name of contractor, and year of delivery printed on a red ticket, pasted on the inside, in legible characters, thus:

8405-21-102-XXXX
6-3/4
SMITH & CO.
008PC86-0000

17. Dimensions

17.1 The depth of the Officer's Cap shall be 11-3/4 inches at the front and 16-1/4 inches at the back.

17.2 The depth of the Other Ranks Cap shall be 9-1/4 inches at the front and 13-1/4 inches at the back.

17.3 Depth of Cap does not include the length of the hair at the bottom of the Cap.

17.4 **Size.** Internal Circumference of Head Dress in Inches:

17.4.1 6, 6-1/8, 6-1/4, 6-3/8, 6-1/2, 6-5/8, 6-3/4, 6-7/8, 7, 7-1/8, 7-1/4, 7-3/8, 7-1/2, 7-5/8, 7-3/4.