



Royal Canadian Mounted Police  
Gendarmerie royale du Canada

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# Specification

## Socks, Athletic, Tube

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.



## Modifications

[illegible]

## **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 governs.

It may be obtained from:

Royal Canadian Mounted Police  
Uniform and Equipment Program  
(440 Coventry Road, Warehouse Building)  
73 Leikin Drive  
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**

### **SOCKS, ATHLETIC, TUBE**

#### **1 Definition**

- 1.1 This specification governs the manufacture and inspection of Socks, Athletic, Tube. The specific item covered under this specification with stock number is as follows:
  - i. 6480-500 Socks, Athletic, Tube/Chaussettes tubes de sport
- 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 Socks, Athletic, Tube.
- 1.4 This specification has been translated into French from this original English language document.

#### **2 Applicable Documents**

- 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 Association of Textile Chemists and Colorists  
Test Method 20A-2017                      Fiber Analysis: Quantitative
- 2.3 Canadian General Standards Board  
86.1-2003                                      Care Labelling of Textiles

#### **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** – Socks, Athletic, Tube must be a calf length, tube sock, knit with an elastic cuff. It must be designed in accordance with the attached drawing forming part of this specification and viewing sample.

#### 4 **Detail Requirements**

##### 4.1 **Components**

- 4.1.1 **Yarn** – The yarn must be white in colour and the fibre content of the finished sock must be as per the values in Table I. All yarns listed below must be used in the construction and must be as follows:

4.1.1.1 Poly/cotton pre-dyed optical white; 1/24cc, 50/50pc, ring spun combed and,

4.1.1.2 Nylon/spandex natural white; 1/70 stretch nylon air tacked with 20 denier spandex and,

4.1.1.3 Elastic spandex; spandex 180 double covered with 1/70 nylon natural white

- 4.2 **Size and Dimensions** – Socks, Athletic Tube must come in one size, regular. The regular size relaxed flat length must measure 42 cm  $\pm$  1.5 cm. The sock dimensions are specified in drawing #1. Care must be taken to ensure pairs of socks are carefully matched in length. There is no specific weight required for the socks.

- 4.3 **Knit Construction** – The sock must be knit in a tubular pattern to the length as specified above using the information below.

4.3.1 **Cuff** – The construction of the cuff must be a 3 by 1 mock rib, double welt with the elastic spandex specified in para. 4.1.1.3 laid in every course. The yarn must be 3 plies of the yarn specified in para. 4.1.1.1, and 1 ply of the yarn specified in para. 4.1.1.2.

4.3.2 **Leg** – The construction of the leg must be a 3 by 1 mock rib with the elastic spandex specified in para. 4.1.1.3 laid in every course. The yarn must be 4 plies of the yarn specified in para. 4.1.1.1, and 1 ply of the yarn specified in para. 4.1.1.2.

- 4.3.3 **Foot** – The construction of the foot must be a flat knit with full terry. The yarn must be 3 plies of the yarn specified in para. 4.1.1.1, and 1 ply of the yarn specified in para. 4.1.1.2.
- 4.3.4 **Toe Closing** – The toes must be closed by either an automatic toe closing system on the sock knitting machine, or on a Rosso toe closing machine. The seam must be finished in such a way that the seam is smooth, flat, and non-abrasive, ensuring that the toe seam does not create a raised edge visible on the exterior of the sock when worn. Toe closing thread colour must match the sock colour.
- 4.4 **Marking** – Each pair of socks must be legibly marked in accordance with good commercial practice. Sticker or cardboard sleeves, hand tags or stamped labels are some examples of acceptable labelling methods. The label information outlined below should be clearly indicated in a font no less than size 6:
1. Item name, in English and French, as per para. 1.1
  2. RCMP Stock Number: 6480-500
  3. Manufacturer identification: Company name or number
  4. Date of manufacture, in numeric format year/month (Ex. 2016/05)
  5. Size in both English and French: using size designation referenced in contract documents.
- 4.5 **Cleaning Instructions Label** – The label must be completed in accordance with the manufacturer's recommended cleaning instructions in English and French. The use of cleaning symbols as per CAN/CGSB 86.1-2003 is acceptable as a replacement to text.
- Note:** The manufacturers identification must not appear anywhere on the garment except on the garment label as indicated.

## 5 **Quality Assurance Provisions**

- 5.1 **Responsibility for Inspection** – Unless otherwise stipulated in the Contract, it is the Contractor's responsibility to satisfy the RCMP, Uniform and Equipment Program that the components and material being supplied conform to this specification. This must 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 must use an independent commercial testing establishment.

- 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**  
**Sock Properties**

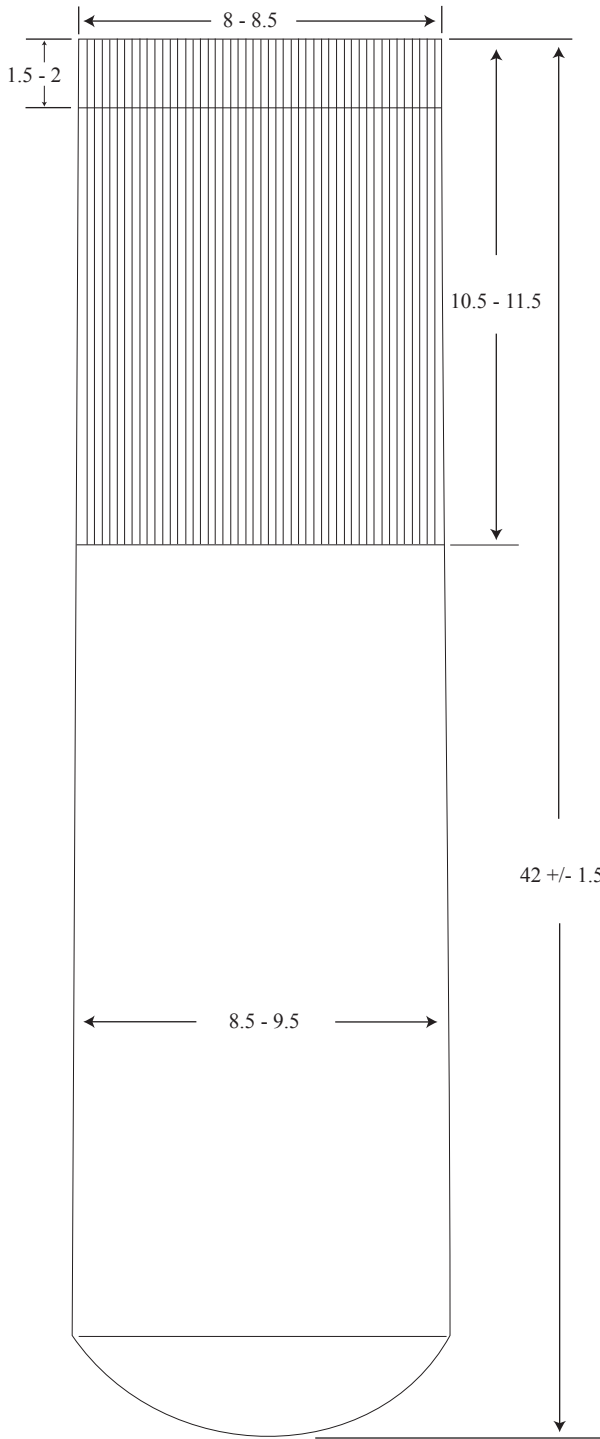
	Test	Duration/Conditions	Requirement	Test Method
1	Fibre Content	Test must be performed on FINISHED sock, not yarn.	Cotton = 45% Polyester = 45% Nylon = 9% Spandex = 1%  Total tolerance for all values is $\pm 10\%$	<ul style="list-style-type: none"><li>• AATCC Test Method 20A-2017</li></ul>



Drawing # 1

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Socks, Athletic, Tube



NOT TO SCALE  
All measurements are shown in centimeters.