



**Manufacturing Specification for
JACKET, MAN'S, No.1 Dress, Royal Irish Rangers,
Bandsman and Drummers, OR**

Defence Clothing

PROPERTY OF
DEFENCE CLOTHING

Defence Equipment & Support

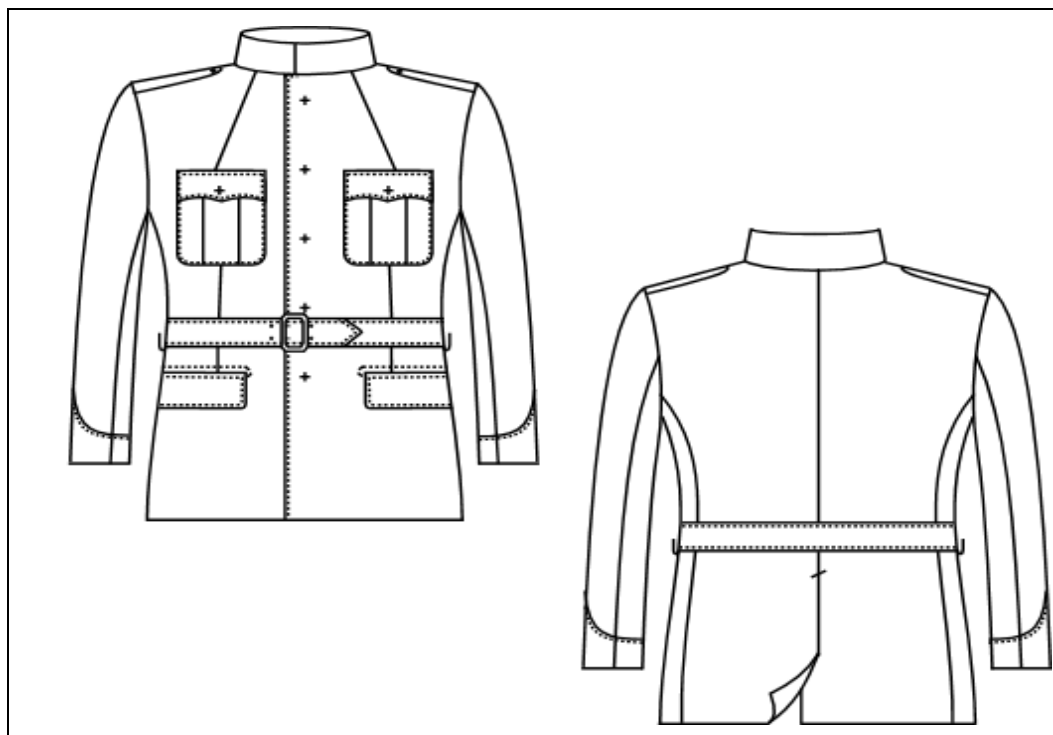


MINISTRY OF DEFENCE

THE PRODUCT

Item Description	NATO Stock No's	Pattern No.
JACKET, MAN'S, No.1 Dress, RIR Bandsman and Drummers O.R	8405-99-127-9771 to 9801	19619

Technical Support	Defence Clothing
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Any colour shown in this document is for representation and must not be used for colour matching.

IPR STATEMENT

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1. ISSUE RECORD

Issue No	Comments	Issue Date
2	Removal of all reference to the Royal Green Jackets and related NSN's. Removal of imperial measurements. Amendments to size charts and care labels.	05 August 2009
1	New specification derived from UK/SC/3366 Issue 4	12 August 2005

2. BILL OF MATERIALS

Refer to Technical Data Sheets at Section 7

3. FUSING/INTERLINING/PATTERNS

DESCRIPTION	PRODUCT	COLOUR
Forepart and shoulder reinforcement	Canvas	Yellow
Button and buttonhole and pocket stays	30mm woven tape	Red
Collar	Buckram	Grey
Pocket flaps, rifle cuff, shoulder straps, belt and jetts	Woven, knitted or non woven	Green
Front edges, back neck, armhole and vents, base of armhole	Non woven	Blue
	20mm woven tape	Orange

The technical drawing illustrates various components and patterns for a garment, organized into several sections:

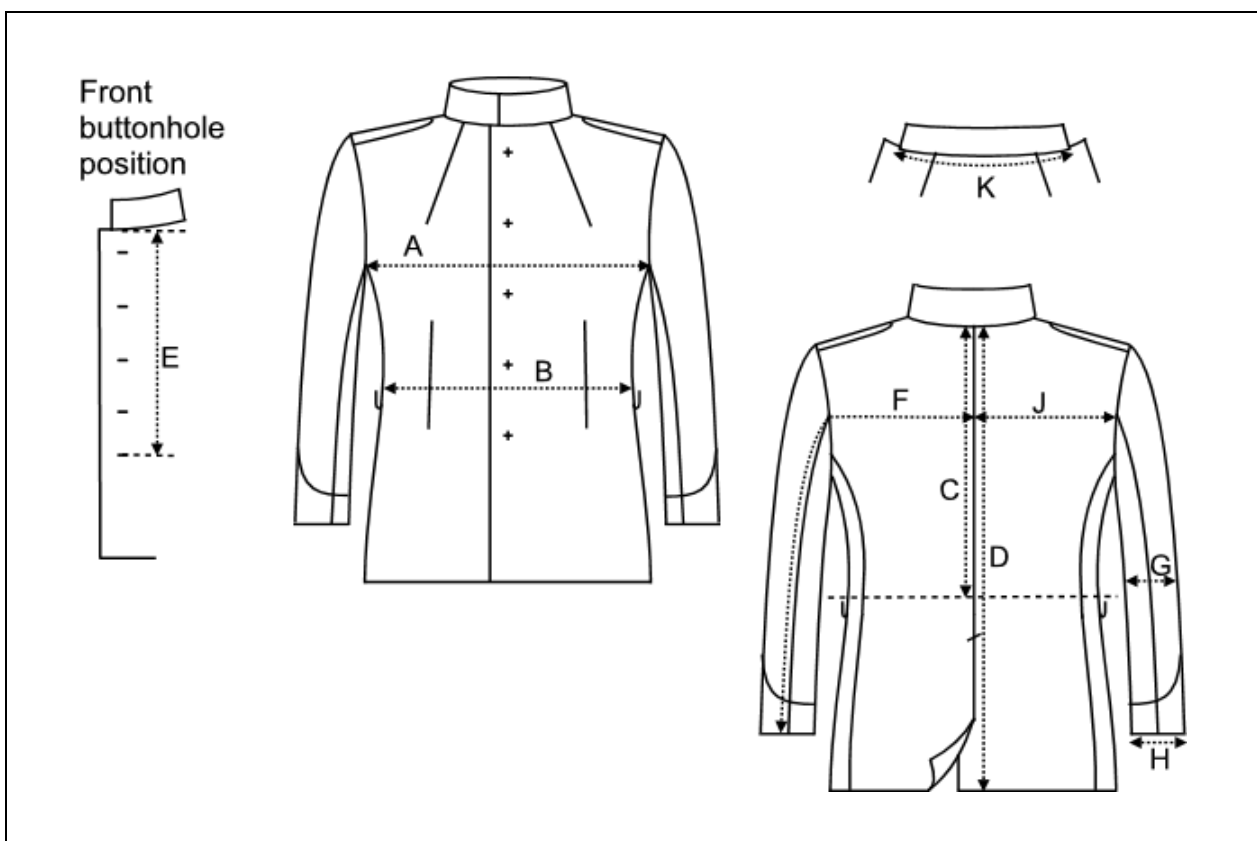
- Top Section:** Shows individual reinforcement pieces and stays. It includes a grey curved piece, a blue rectangular piece, a blue irregular piece, a blue piece with a notch, a blue piece with a pointed end, and a yellow piece.
- Middle Section:** Features a long blue strip with a pointed end, a white piece with orange trim, and a white piece with orange trim and a notch.
- Bottom Section:** Displays a white piece with orange trim, a white piece with orange trim and a notch, and a yellow piece.

PATTERNS.

- a. Master Patterns. The DC holds a Master Pattern for this product. Potential contractors may view the pattern on site by arrangement with the DC Commercial Department.
- b. Standard Patterns. A Standard Pattern may be obtained from the DC Technical Information Office and may be used to provide the criteria for all materials, components and manufacturing features not fully defined in this specification.
- c. Electronic Patterns. Electronic patterns in 'Gerber®' format, to guide for manufacture may be obtained from the DC Technical Information Office.

4. GARMENT SIZINGSIZE CHART

JACKET, MAN'S, No.1 Dress, Royal Irish Rangers, Bandsman and Drummers OR
All measurements in centimeters. Garment fastened and laid flat



4. GARMENT SIZING continued

Size No	Height	Measurements of garment										
		Around jacket		Back		Front length from collar seam to bottom buttonhole	Length from centre back to cuff	Sleeve		Half back 11cm down	Length of collar at collar seam	
		From eye of buttonholes to centre of button		From collar seam to waist	From collar seam to bottom of jacket			Width at				
		Chest	Waist			Elbow ½ way between underarm and cuff	Around cuff					
Ax2	Bx2	C	D	E	F	Gx2	Hx2	J	K			
5	160 to 162	99	84	39.5	67.5	40.5	76	38	32	18.5	40	
6		101.5	86.5					38.5	32		19	40.5
7	165 to 167	94	81	40.5	70	42	79	37.5	31	18	39	
8		96.5	84					38	31.5		18	39.5
9		99	84					38	32		18.5	40
10		101.5	86.5					38.5	32		19	40.5
11		104	89					38	32.5		19	41.5
12		106.5	91.5					39	33		19.5	42
13	170 to 172	96.5	84	42	72.5	43	81.5	38	31.5	18	39.5	
14		99	84					38	32		18.5	40
15		101.5	86.5					38.5	32		19	40.5
16		104	89					39	32.5		19	41.5
17		106.5	91.5					39	33		19.5	42
18		109	94					39.5	33		20	42.5

4. GARMENT SIZING continued

Size No.	Height	Ax2	Bx2	C	D	E	F	Gx2	Hx2	J	K
19		99	86.5					38	32	18.5	40
20	175	101.5	86.5					38.5	32	19	40.5
21	to	104	89	43	75	44.5	84	39	32.5	19	41.5
22		106.5	91.5					39	33	19.5	42
23	178	109	94					39.5	33	20	42.5
24		111.5	96.5					39.5	33.5	20	43
25		104	89					39	32.5	19	41.5
26	180	106.5	91.5					39	33	19.5	42
27	to	109	94	44.5	77.5	46	86.5	39.5	33	20	42.5
28		111.5	96.5					39.5	33.5	20	43
29	183	114.5	99					40	34	20.5	44
30		117	101.5					40.5	34	20.5	44.5
31		106.5	91.5					39	33	19.5	42
32	185	109	94					39.5	33	20	42.5
33	to	111.5	96.5	46	80	47	89	39.5	33.5	20	43
34		114.5	99					40	34	20.5	44
35	188	117	101.5					40.5	34	20.5	44.5
36		119.5	104					40.5	34.5	21	45
Tolerances +/-		1.5	1.5	1	1.5	1	1	1	1	0.5	1

5. CONSTRUCTION

SEAMS AND STITCHING to BS 3870

- Seam type 1.01.01
- Jacket up-turn stitch type 103 with 4-7 stitches per 2cm
- All other seams and topstitching 301
- Seams to be pressed open with the exception of the armhole seam
- 8-10 stitches per 2cm for all operations
- All raw edges stitch type 502, 503, 504, or 505
- Buttonholes to be cut before worked type, 22 stitches per 2cm to be bar tack finished

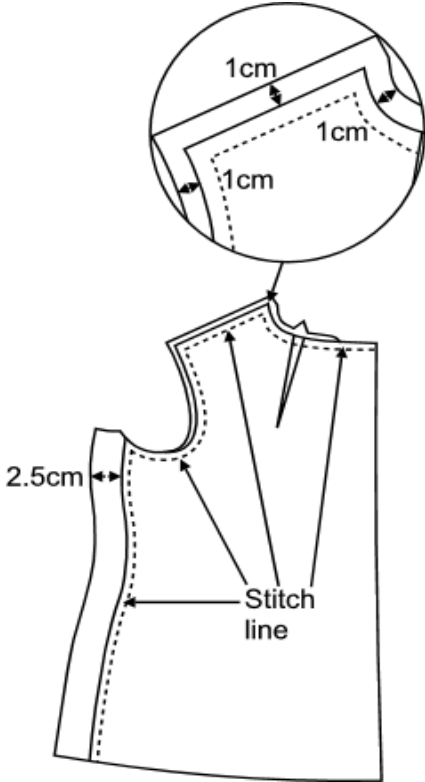
QUALITY

- The jacket is to be made to a high quality standard and to this end sound tailoring production techniques are to be applied in their construction. Attention must be paid to features which have a bearing on a neat, smooth superior finish
- Uniformity in appearance is essential, therefore there is to be no noticeable variation between production garments and the Standard Pattern
- It is essential that:
 - Body and sleeve linings are not tight
 - Garment parts are correctly aligned in assembly and that the run of seams are regular and neatly under and top pressed
 - Garment front edges are thinly constructed, well pressed, regular in shape and free from distortion.
 - There is no variation in paired features i.e. left and right collar end, cuffs etc
 - Sleevehead fullness is correctly distributed, sleeves correctly pitched and the sleevehead run is regular and well pressed
 - Shoulder seam distortion is avoided and wadding is securely and correctly inserted
 - The garment is not to be over pressed, i.e. no seam impressions or shine visible

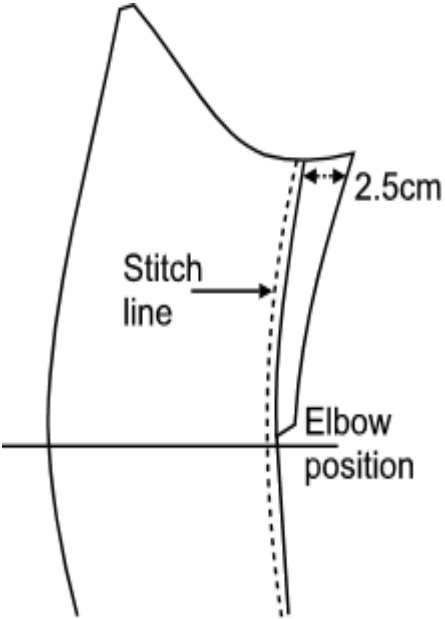
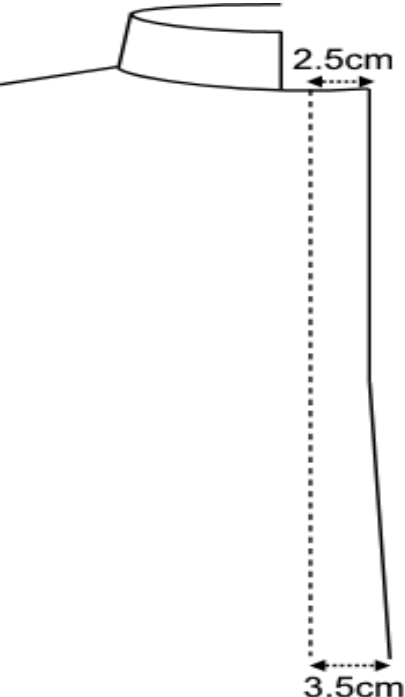
5. CONSTRUCTION

PART	DETAIL	BS 3870
DESIGN	<p style="text-align: center;">JACKET</p> <ul style="list-style-type: none"> • Single breasted to button five • Stand collar • Underarm dart • Waist dart • Gorge dart • Centre back vent • Shoulder straps • Two piece set in sleeve • Rifle cuff • Pleated breast pocket with 3 pointed flap • Jetted hip pocket with straight flap • Waist hooks • Fully lined • Loose belt 	

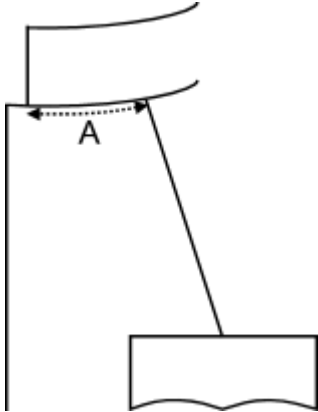
5. CONSTRUCTION continued

<p style="text-align: center;">INLAYS</p>  <p>The diagram shows a technical drawing of a jacket inlay. It includes a circular inset at the top showing a close-up of a seam with a 1cm width. Below this, a larger drawing shows the side seam of the jacket with a 2.5cm width. A dashed line indicates the 'Stitch line'.</p>	<ul style="list-style-type: none"> • Side seam 2.5cm wide • Or to have a 2cm compatible seam • Front armhole, shoulder seam and gorge seam, 1cm wide • Back armhole 1cm wide from shoulder to the back pitch 	
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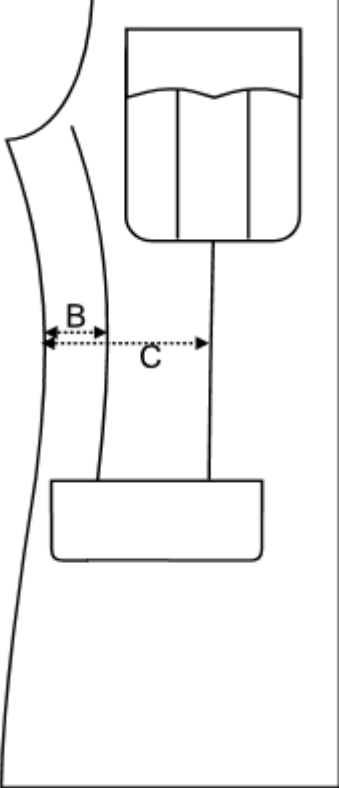
5. CONSTRUCTION continued

<p>INLAYS continued</p> 	<ul style="list-style-type: none">• Underside sleeve forearm seam 2.5cm wide• Or a 2cm compatible seam on the hind arm seam down to elbow• Corresponding inlays are to be allowed on the linings	
<p>FOREPART</p> 	<p><u>Right front</u></p> <ul style="list-style-type: none">• Button stand 2.5cm wide at top of front edge to waist• Increasing to 3.5cm at bottom edge	

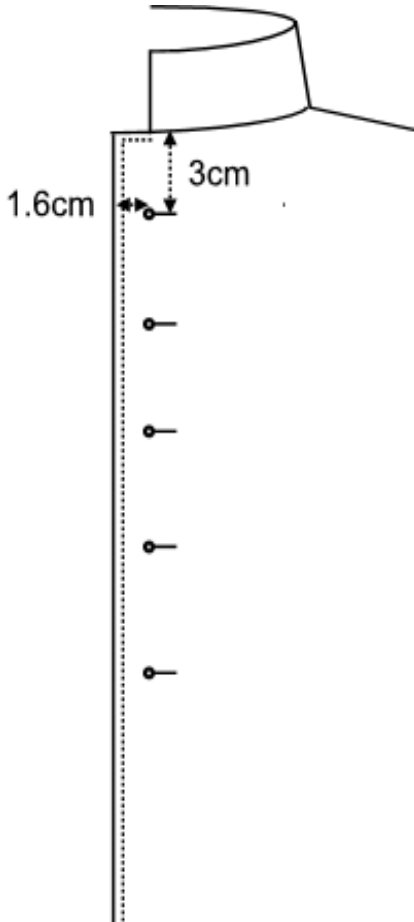
5. CONSTRUCTION continued

<p>FOREPART continued</p> 	<ul style="list-style-type: none"> • A gorge dart in each front • Extending from the gorge seam • Finishing centrally at the breast pocket flap • Dart position from collar end (see table) 	
	Size	Dart position from collar end A
	7, 8, 13	5
	5, 9, 14, 19	5.25
	6, 10, 11, 15, 16, 20, 21, 25	5.5
	12, 17, 18, 22, 23, 26, 27, 31, 32	5.75
	24, 28, 33	6
	29, 30, 34, 35	6.25
	36	6.5

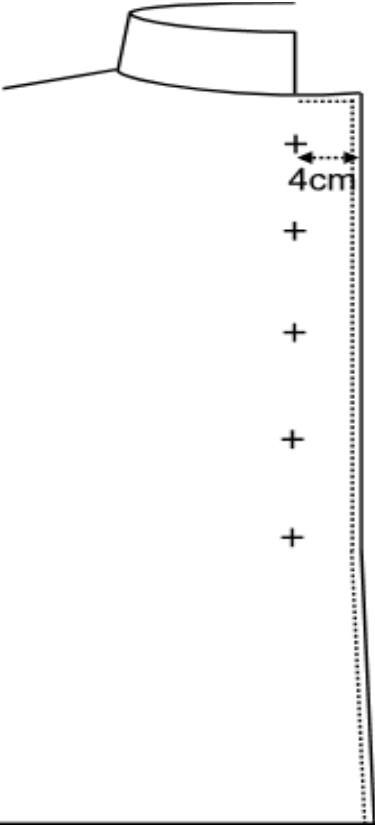
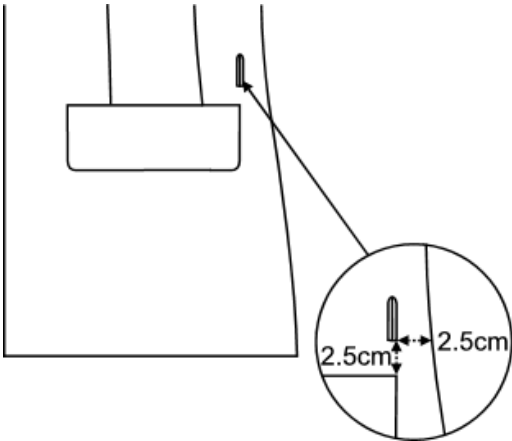
5. CONSTRUCTION continued

FOREPART continued	<ul style="list-style-type: none"> • Waist dart in each forepart • Positioned centrally above the bottom of the breast pocket • Finishing at the hip pocket jetting • Darts pressed flat • Underarm dart in each forepart • Positioned at the armhole and finishing at the hip pocket jetting • Dart positions at waist (see table) 		
	Size	Underarm dart from side seam B	Waist dart from side seam C
	7	6	16.5
	8, 13	6.5	16.5
	5, 9, 14, 19	6.5	17
	6, 10, 15, 20	6.5	17.5
	11, 16, 21, 25	7	18.5
	12, 17, 22, 26, 31	7	19.5
	18, 23, 27, 32	7.5	19.5
	24, 28, 33	7.75	19.5
	29, 34	8	20.5
	30, 35	8.5	21.5
	36	8.75	22.5

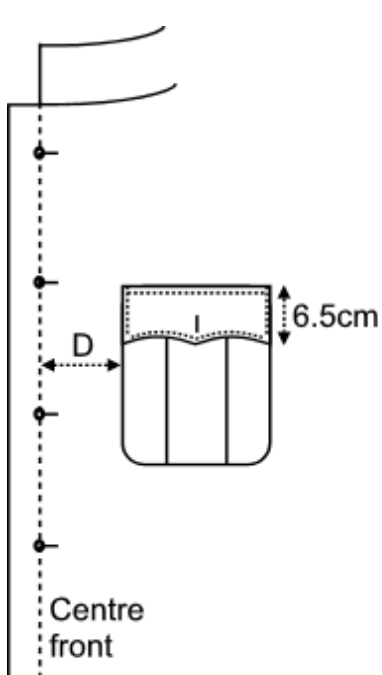
5. CONSTRUCTION continued

<p>FOREPART continued</p> 	<ul style="list-style-type: none"> • The foreparts interlined with cotton and hair canvas (see fusing diagram) • Cut full width at the shoulder • Tapering to 11.5cm at the jacket bottom • To cover the front tack of the hip pocket • Reinforcement of cotton and hair canvas and felt provided at the shoulder • Reinforcement sewn in with the sleevehead stitching • Secured with 3 rows of padding or fused • Front edges, base of armhole, buttons and buttonholes to be stayed with fusible tape (see fusing diagram) • Front edge topstitched 0.6cm <p><u>Left front as worn</u></p> <ul style="list-style-type: none"> • Five buttonholes 2.5cm effective cut length • Top buttonhole positioned 3cm down from collar seam • Position of bottom buttonhole (see size chart) • The remaining buttonholes positioned centrally between top and bottom buttonhole • The eyes 1.6cm from the front edge 	<p>1.06.0 2</p>
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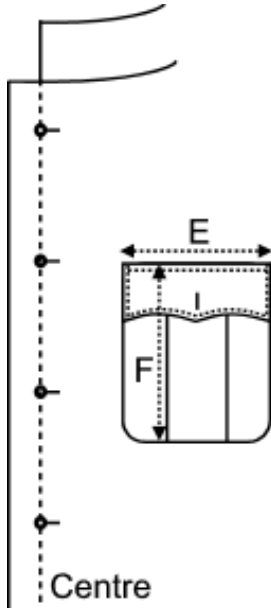
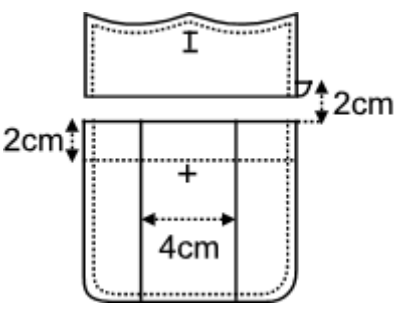
5. CONSTRUCTION continued

<p>FOREPART continued</p> 	<p><u>Right side as worn</u></p> <ul style="list-style-type: none">• Button positions to be marked with white thread• Positioned 4cm from the front edge• In register with the buttonholes	
<p>WAIST HOOKS</p> 	<ul style="list-style-type: none">• Inserted in each forepart and stayed• Positioned 2.5cm above hip pocket flap• 2.5cm from the side seam	

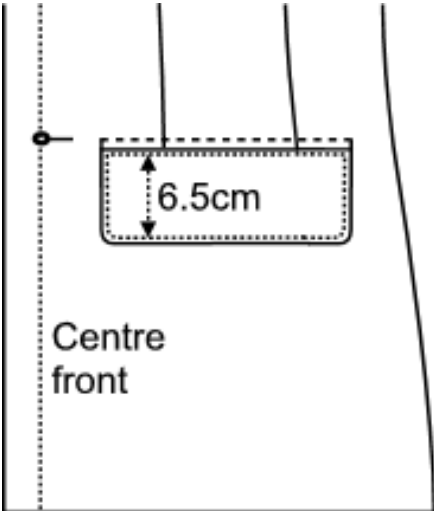
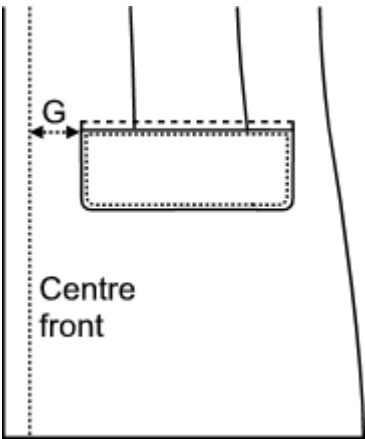
5. CONSTRUCTION continued

<p>POCKETS AND FLAPS</p> 	<ul style="list-style-type: none"> • Pocket flaps and patches to be sewn using sewing jigs • Flap attachment top stitching 0.6cm from the top edge <p>5.31.05</p>								
	<p><u>Breast pocket and flap</u></p> <ul style="list-style-type: none"> • Three pointed flap on each front to have fusible interlining (see fusing diagram) • 6.5cm deep at points • To be topstitched 0.6cm • Top edge of flap positioned in line with the second button/buttonhole • Front edge of pocket positioned parallel to centre front • Breast pocket position (see table) <p>1.06.02</p>								
	<table border="1"> <thead> <tr> <th>Size</th> <th>From centre front D</th> </tr> </thead> <tbody> <tr> <td>7</td> <td>4.5</td> </tr> <tr> <td>5, 6, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 25, 26, 27, 31, 32</td> <td>5</td> </tr> <tr> <td>24, 26, 28, 29, 30, 33, 34, 35, 36</td> <td>6</td> </tr> </tbody> </table>	Size	From centre front D	7	4.5	5, 6, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 25, 26, 27, 31, 32	5	24, 26, 28, 29, 30, 33, 34, 35, 36	6
	Size	From centre front D							
	7	4.5							
5, 6, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 25, 26, 27, 31, 32	5								
24, 26, 28, 29, 30, 33, 34, 35, 36	6								

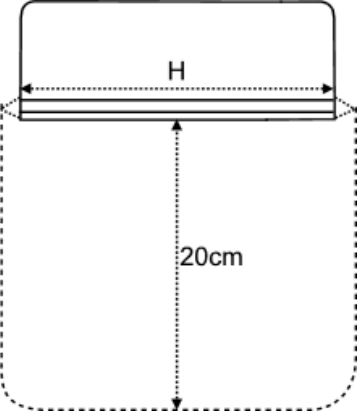
5. CONSTRUCTION continued

POCKET AND FLAPS continued												
	<ul style="list-style-type: none"> Breast pocket dimensions (see table) 											
	<table border="1"> <thead> <tr> <th>Size</th> <th>Width E</th> </tr> </thead> <tbody> <tr> <td>7</td> <td>13.5</td> </tr> <tr> <td>8,13</td> <td>14</td> </tr> <tr> <td>5, 6, 9, 10, 11, 12, 14, 15, 16, 17, 19, 20, 21, 22, 25, 26, 31</td> <td>15.5</td> </tr> <tr> <td>18, 23, 24, 27, 28, 29, 30, 32, 33, 34, 35, 36</td> <td>16</td> </tr> </tbody> </table>	Size	Width E	7	13.5	8,13	14	5, 6, 9, 10, 11, 12, 14, 15, 16, 17, 19, 20, 21, 22, 25, 26, 31	15.5	18, 23, 24, 27, 28, 29, 30, 32, 33, 34, 35, 36	16	
	Size	Width E										
	7	13.5										
	8,13	14										
	5, 6, 9, 10, 11, 12, 14, 15, 16, 17, 19, 20, 21, 22, 25, 26, 31	15.5										
	18, 23, 24, 27, 28, 29, 30, 32, 33, 34, 35, 36	16										
	<table border="1"> <thead> <tr> <th>Size</th> <th>Depth from top of flap F</th> </tr> </thead> <tbody> <tr> <td>5 to 12</td> <td>17</td> </tr> <tr> <td>13 to 24</td> <td>17.5</td> </tr> <tr> <td>25 to 30</td> <td>18</td> </tr> <tr> <td>31 to 36</td> <td>19</td> </tr> </tbody> </table>	Size	Depth from top of flap F	5 to 12	17	13 to 24	17.5	25 to 30	18	31 to 36	19	
	Size	Depth from top of flap F										
	5 to 12	17										
13 to 24	17.5											
25 to 30	18											
31 to 36	19											
<ul style="list-style-type: none"> 2.2cm long buttonhole Positioned centrally in the flap The eye 1.6cm from the point Patch has a box pleat 4cm wide Top inturn 2cm wide Button stay 2.5cm wide and 4cm deep Attached centrally in the inturn Patch sewn to the front The top edge of patch positioned 2cm below top edge of the flap Top corners to be securely tacked Button position marked with white thread In register with the buttonhole 	6.03.01											
	5.31.01											

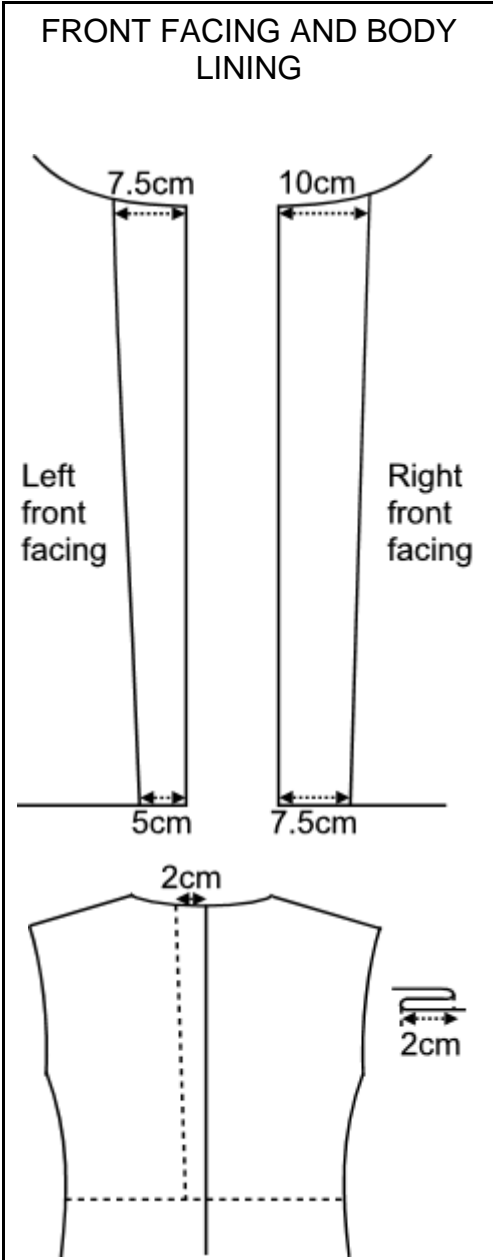
5. CONSTRUCTION continued

POCKET AND FLAPS continued		1.06.02													
	<p><u>Hip pocket and flap</u></p> <ul style="list-style-type: none"> • Straight flap on each front to have fusible interlining (see fusing diagram) • 6.5cm deep • Top edge of flap positioned in line with the bottom button/buttonhole • To be topstitched 0.6cm • The top of the flap to be stayed with fusible tape (see fusing diagram) • Extending from the side seam 														
		<ul style="list-style-type: none"> • Lower flap position (see table) <table border="1"> <thead> <tr> <th>Size</th> <th>From centre front G</th> </tr> </thead> <tbody> <tr> <td>7</td> <td>9</td> </tr> <tr> <td>8, 13</td> <td>9.5</td> </tr> <tr> <td>5, 8, 9, 13, 14, 19</td> <td>10</td> </tr> <tr> <td>6, 10, 11, 12, 15, 16, 17, 20, 21, 22, 25, 26, 31</td> <td>10.5</td> </tr> <tr> <td>18, 23, 27, 32</td> <td>11</td> </tr> <tr> <td>24, 26, 28, 29, 30, 33, 34, 35, 36</td> <td>12</td> </tr> </tbody> </table>	Size	From centre front G	7	9	8, 13	9.5	5, 8, 9, 13, 14, 19	10	6, 10, 11, 12, 15, 16, 17, 20, 21, 22, 25, 26, 31	10.5	18, 23, 27, 32	11	24, 26, 28, 29, 30, 33, 34, 35, 36
Size	From centre front G														
7	9														
8, 13	9.5														
5, 8, 9, 13, 14, 19	10														
6, 10, 11, 12, 15, 16, 17, 20, 21, 22, 25, 26, 31	10.5														
18, 23, 27, 32	11														
24, 26, 28, 29, 30, 33, 34, 35, 36	12														

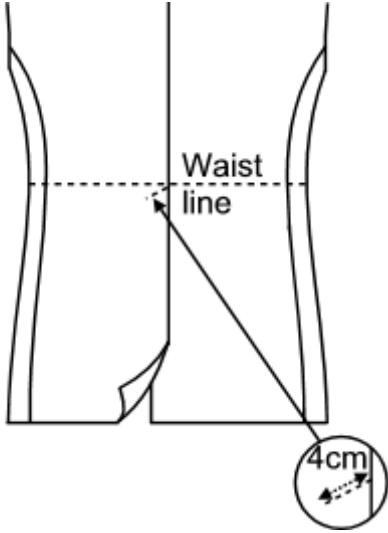
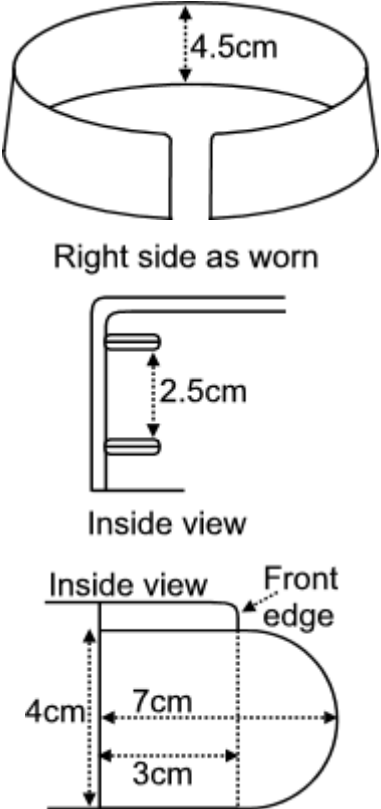
5. CONSTRUCTION continued

POCKET AND FLAPS continued	<u>Single jetted pocket</u> <ul style="list-style-type: none"> • To be stayed with fusible tape (see fusing diagram) • Jetting 0.6cm wide • Pocket ends to be securely tacked • Effective pocket depth 20cm • Hip flap dimensions (see table) 	
	Size	Flap width/ Pocket opening H
	7, 8, 13	17
	5, 6, 9, 10, 14, 15, 19, 20	18
	11, 12, 16, 17, 21, 22, 25, 26, 31	18
	18, 23, 24, 27, 28, 32, 33	19
	29, 30, 34, 35, 36	20.5

5. CONSTRUCTION continued

<p>FRONT FACING AND BODY LINING</p> 	<ul style="list-style-type: none"> • Right facing 10cm wide at the collar seam • 7.5cm wide at the bottom • Left facing 7.5cm wide at collar seam • 5cm wide at the bottom • Lining cut to correspond with the forepart and back • 1cm pleat formed at the hem • The facing/lining seam to be secured to the forepart interlining • Using fusible web 	
	<ul style="list-style-type: none"> • Lining to have a 2cm pleat in the centre back neck • Stitched 5cm below the collar seam and 5cm above the top of the vent 	

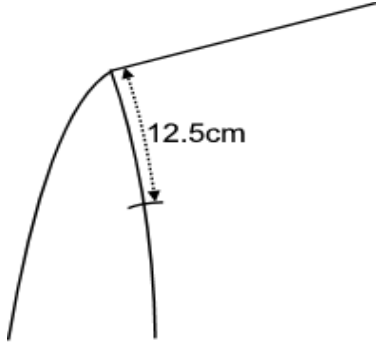
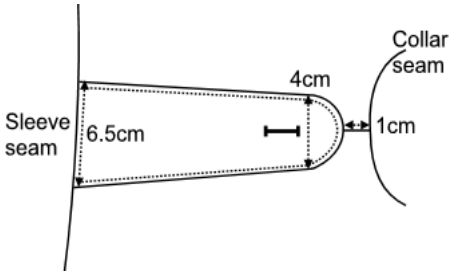
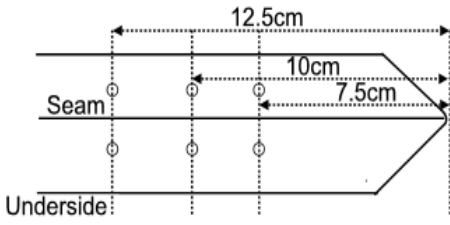
5. CONSTRUCTION continued

<p style="text-align: center;">BACK</p> 	<ul style="list-style-type: none"> • Cut with a centre back seam • Vent to finish at waist • A 4cm long tack sewn across the top of the vent • Top and underlay of vent to be stayed with fusible tape (see fusing diagram) • Back armhole and neck stayed with fusible tape (see fusing diagram) 	
<p style="text-align: center;">COLLAR</p> 	<ul style="list-style-type: none"> • Stand collar 4.5cm deep and lined • To be interlined with buckram (see fusing diagram) • Two hooks secured to the right end with tape • Centrally spaced 2.5 cm apart • Two eyes secured to the left end with tape • In register with the hooks • The collar is not to gape when fastened • A throat tab to be sewn to the lining on the left collar end • Positioned 3cm from front edge of the collar • 7cm long and 4cm wide 	

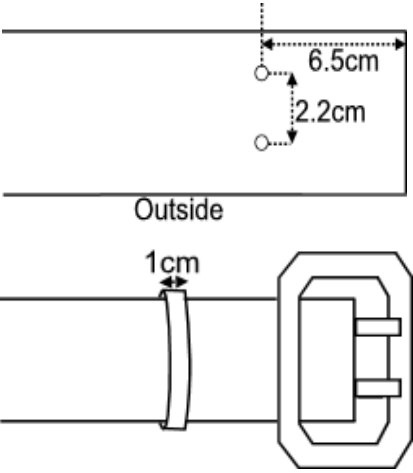
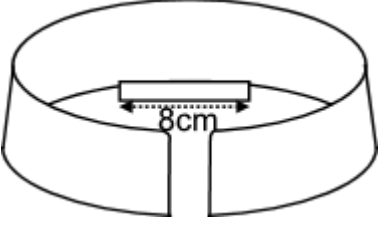
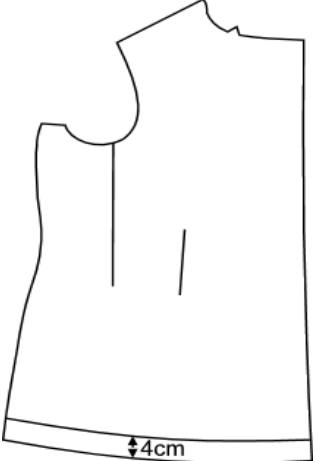
5. CONSTRUCTION continued

<p style="text-align: center;">SLEEVE</p>	<ul style="list-style-type: none"> • It is essential the sleeves are correctly pitched for the erect stature required for uniform clothing • Solid line showing correctly pitched • Dotted line incorrectly pitched <ul style="list-style-type: none"> • Sleevehead fullness is to be correctly distributed and fixed using a programmed CAM controlled machine • Shoulder pads secured to shoulder/chest reinforcement • Sleevehead wadding to extend from the forearm seam to the hindarm seams • Sleevehead lining to be machine sewn and securely tacked to the armhole at six points • At the forearm and hindarm seam • 4cm above and below forearm and hindarm seam • Alternatively the lining can be attached at the underarm seam <ul style="list-style-type: none"> • Rifle cuff 16cm deep at the point • 7cm deep at the hindarm seam • To have a fusible interlining (see fusing diagram) • Sewn to sleeve • Forming a 5cm upturn • To be securely tacked at the forearm and hindarm seams 	<p style="text-align: right;">2.02.01 103</p>
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5. CONSTRUCTION continued

<p>SLEEVES continued</p> 	<ul style="list-style-type: none"> • A becket is sewn to front and back armholes • Positioned 12.5cm below shoulder seam 	
<p>SHOULDER STRAPS</p> 	<ul style="list-style-type: none"> • Two ply main fabric with rounded end • Top ply to have fusible interlining (see fusing diagram) • Strap width 6.5cm at the sleeve seam • 4cm at eye of buttonhole • Strap to be topstitched 0.6cm • 2.2cm long buttonhole • Positioned centrally • The eye 1.6cm from the rounded free end • Strap sewn in the sleeve seam • Positioned centrally over the shoulder seam • End of strap to finish 1cm from collar seam • Button position on shoulder marked with white thread 	<p>1.06.02</p>
<p>BELT</p> 	<ul style="list-style-type: none"> • Single ply main fabric folded and seamed to finish 5cm wide • To be 0.6cm topstitched • Top side to have a fusible interlining (see fusing diagram) <p><u>Pointed end</u></p> <ul style="list-style-type: none"> • Three pairs of eyelet holes to be worked centrally from the pointed end • Positioned 7.5cm, 10cm and 12.5cm • Spaced 2.2cm apart 	<p>1.06.02</p>

5. CONSTRUCTION continued

<p>BELT continued</p>  <p>6.5cm 2.2cm 1cm Outside</p>	<p><u>Square end</u></p> <ul style="list-style-type: none"> • Pair of eyelets worked centrally 6.5cm from end • Spaced 2.2cm apart • A buckle to be fitted with the turn back stitched down • A loose runner of main fabric 1cm wide • To be supplied with the belt • Belt length from pointed end to buckle position • To be waist measurement of jacket plus 7.5cm 	
<p>HANGER</p>  <p>8cm</p>	<ul style="list-style-type: none"> • Sewn centrally at the back neck in the collar seam • Effective length 8cm 	
<p>JACKET UP-TURN</p>  <p>4cm</p>	<ul style="list-style-type: none"> • 4cm up-turn 	<p>103</p>

6. LABELLING REQUIREMENTS

Labels	Colour	Position
Identification and garment care labels	White	<u>JACKET</u> : Inside right front facing, 28cm from the bottom

Care and size labels may be combined to produce one label

Identification Label

Information and format is to be as follows

For Stock Items

Item Name, NATO Stock Number, Size, Contract Number, indication of position for wearer's name and number. The size number is to be 0.6cm high.

For Outsize

Item name, NATO Stock Number, name, number and measurements of wearer, contract number.

Manufacturer Information

Under no circumstances should the contractor's name, logo or trademark appear on any form of labelling or garment bags.

6. LABELLING REQUIREMENTS continued

SPECIMEN LABELS

Identification Labels

Stock Items

JACKET, MAN'S, No.1
Dress, Royal Irish
Rangers, Bandsman and
Drummers OR
8405-99-127-9780
Size 16
Contract No.
Height
Chest
Waist
No:

Outsize

JACKET, MAN'S, No.1
Dress, Royal Irish
Rangers, Bandsman and
Drummers OR
8405-99-127-9801
Name
No:
Height
Chest
Contract No:

Care Label

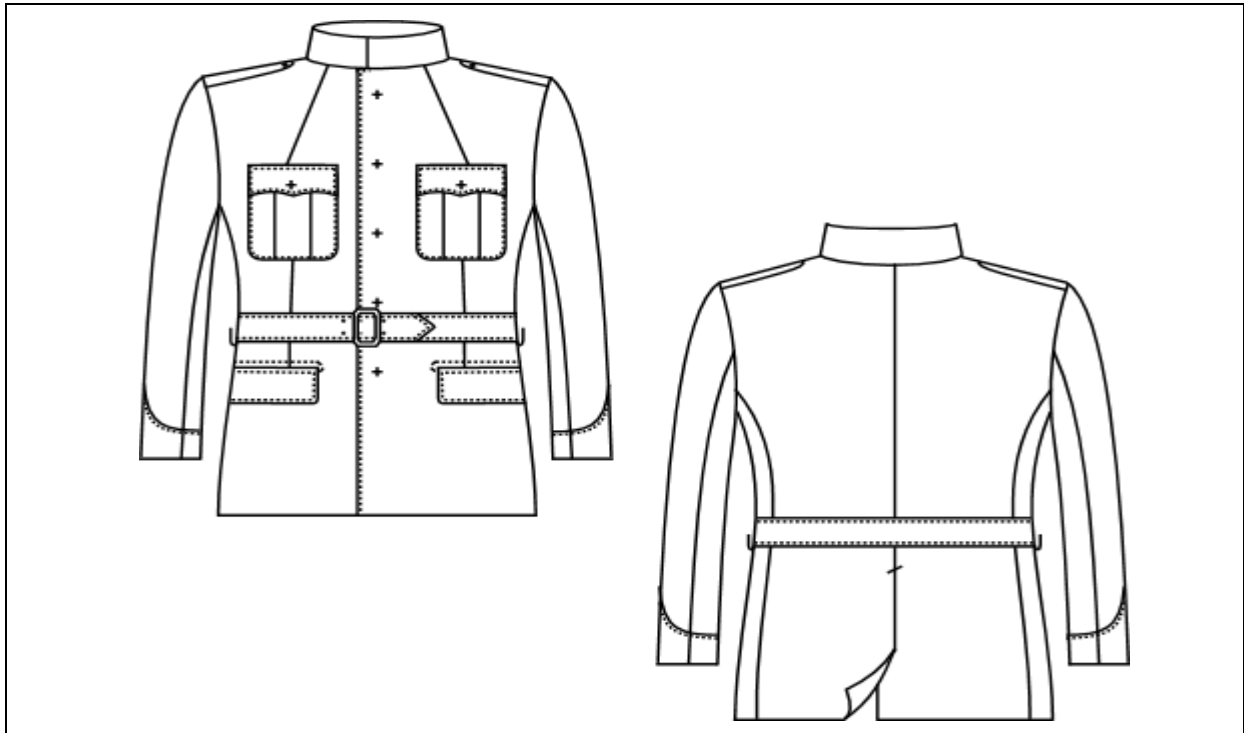
Care instructions	
	DO NOT WASH
	DO NOT BLEACH
	DO NOT TUMBLE DRY
	DO NOT IRON
	Dry clean only

6. LABELLING REQUIREMENTS continued

NATO Stock Numbers

NATO Stock No.	Size
8405-99-127-9771	7
8405-99-127-9772	8
8405-99-127-9773	9
8405-99-127-9774	10
8405-99-127-9775	11
8405-99-127-9776	12
8405-99-127-9777	13
8405-99-127-9778	14
8405-99-127-9779	15
8405-99-127-9780	16
8405-99-127-9781	17
8405-99-127-9782	18
8405-99-127-9783	19
8405-99-127-9784	20
8405-99-127-9785	21
8405-99-127-9786	22
8405-99-127-9787	23
8405-99-127-9788	24
8405-99-127-9789	25
8405-99-127-9790	26
8405-99-127-9791	27
8405-99-127-9792	28
8405-99-127-9793	29
8405-99-127-9794	30
8405-99-127-9795	31
8405-99-127-9796	32
8405-99-127-9797	33
8405-99-127-9798	34
8405-99-127-9799	35
8405-99-127-9800	36
8405-99-127-9801	Outsize

7. TECHNICAL DATA SHEETS



Jacket, Man's, No.1 Dress, Royal Irish Rangers, Bandsman and Drummers OR

Specification No.	DC/MS/3366
Item Description	JACKET, MAN'S, No.1 DRESS, ROYAL IRISH RANGERS, BANDSMAN AND DRUMMERS O.R
Pattern No.	19619 to guide
NATO Stock No.	8405-99-127-9771 to 9801
Scope: Jacket, made from baratheia wool, worsted, green material, for wear as No.1 Dress by Royal Irish Rangers Bandsman and Drummers O.R	
The size schedule provides for thirty sizes and Outsize	

RELATED SPECIFICATIONS

Related Specifications	Title
BS EN ISO 3758	Textiles. Care labelling code using symbols
BS EN 12590	Industrial sewing threads made wholly or partly from synthetic fibres
BS 3870 Part 1 & 2	Stitches and seams
BS 4560	Specification for fabrics for linings in uniform clothing
BS 4973 Part 2	Interlinings, non-woven fusible interlinings
BS 4973 Part 4	Woven sewn-in interlinings
BS 5742	Textile labels requiring to be washed and/or dry cleaned
UK/SC/2124	Insignia, Aluminium Alloys, Anodized Gold and Silver.
UK/SC/5237	Cloths, satin, viscose lining
UK/SC/5516	Cloths, wool, uniform dress
UK/SC/6409	Cloth, Baratheia, Wool, Worsted

BILL OF MATERIALS

Fabric		
Reference	Description	NATO Stock No.
Pattern No.8303G to UK/SC/6409	Jacket, Man's, No.1 Dress, RIR, Bandsman and Drummers OR MAIN MATERIAL Cloth, Baratheia, wool worsted, green, No.2	8305-99-942-5427
Pattern No.8849E to UK/SC/5516	COLLAR TAB Cloth, uniform, wool, rifle green	8305-99-869-4376
Pattern No. 8808A, to UK/SC/5237	LINING FOR BODY, SLEEVES, COLLAR AND POCKET FLAPS Cloth, twill, viscose and cotton, black, No.1, SF	
Fabric reference 2.2 to BS 4560 with stiff finish	HIP POCKET LINING AND BUTTON STAYS Cloth, knitted nylon, black	

BILL OF MATERIALS continued

Components	Size/Colour	Reference /Description	Notes / NATO Stock No.
Thread	Black 60's	Polyamide, nylon 6.6 continuous filament FOR SEWING BUTTONHOLES	BS EN 12590
Thread	Shade to match main material 12's 180's 75's	Polyester and cotton continuous filament polyester core, cotton sheath BUTTONHOLES LASHING UPTURN AND OVEREDGE STITCHING ALL OTHER SEWING	BS EN 12590 Gimp
Interlining		FOREPART AND SHOULDER REINFORCEMENTS Cloth, interlining, cotton and hair	Pattern No.8343A Ref No.WS5 (L15) to BS 4973 Part 4 8305-99-942-7003
Interlining		SHOULDER REINFORCEMENT Compressed, felt, white	Or an alternative approved by the DC
Interlining		COLLAR Cloth, buckram, flax and jute, No.2	Pattern No.8320A Ref No.WS4 (L6) to BS 4973 Part 4 8305-99-942-8282
Interlining	Charcoal	POCKET FLAPS, RIFLE CUFF, SHOULDER STRAPS, BELT AND POCKET JETTINGS Interlining fusible, non-woven	BS 4973 Part 2
Stay	Black 30mm	STAY FOR BUTTON/BUTTONHOLE AND POCKET STAY Tape, woven, fusible	
Stay	Black 20mm	STAY FOR JACKET FRONT EDGES, BACK NECK, ARMHOLE AND VENT Tape, woven, fusible	
Web	20mm	SECURING LINING/FACING SEAM Web, fusible	

BILL OF MATERIALS continued

Components	Size/Colour	Reference /Description	Notes / NATO Stock No.
Pads		SHOULDER Bonded fibre fabric layers, (nylon) triacetate wadding filling	
Wadding		SLEEVEHEAD Bonded-fibre fabric base, polyester wadding	
Stay	Black	WAIST HOOK Cloth, plain weave	Pattern No.8443A, WS1 to BS 4973 Pt 4 Or an alternative approved by the DC
Tape	6mm wide Shade to match main material	HANGER Tape, woven polyester	Or an alternative approved by the DC
Hook	Brass, black enamelled	WAIST Hook, waist, belt,	
Hooks and eyes	Brass, black enamelled	COLLAR Hooks and eyes	
Fastener	Brass, chromium plated	BELT Buckle, 2 prong	Pattern No. 35/R/1286 to UK/SC/2124 8315-99-973-0644
Identification/care instruction labels	White	Refer to section 6 for detail	BS 5742 Paragraph 3 BS EN ISO 3758