



**Manufacturing Specification for
BELT CEREMONIAL
White PVC Sword Belt Waist
WITH KICKING STRAPS
ROYAL MARINES BAND SERVICE (RMBS)
WO2**

Defence Clothing

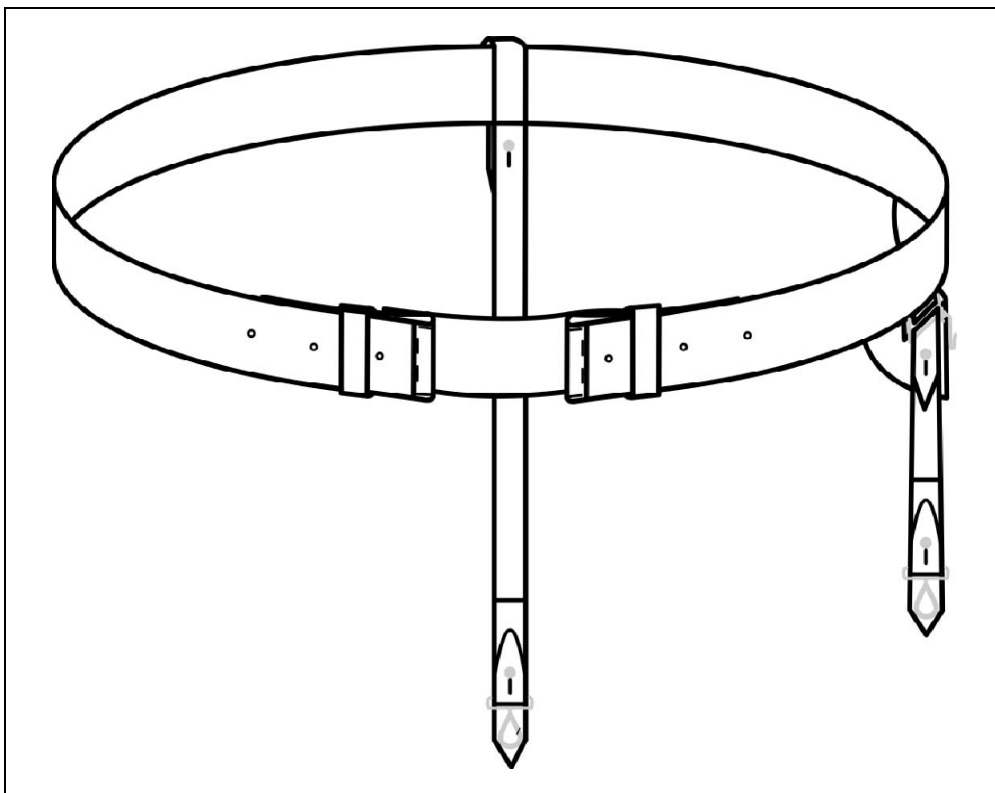
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THE PRODUCT

Item Description	NATO Stock No(s).	Pattern No (s).
BELT CEREMONIAL WHITE PVC SWORD BELT WAIST WITH KICKING STRAPS ROYAL MARINES BAND SERVICE (RMBS) WO2 SMALL	8440-99-981-9383	D01232
BELT CEREMONIAL WHITE PVC SWORD BELT WAIST WITH KICKING STRAPS ROYAL MARINES BAND SERVICE (RMBS) WO2 MEDIUM	8440-99-981-9384	D01233
BELT CEREMONIAL WHITE PVC SWORD BELT WAIST WITH KICKING STRAPS ROYAL MARINES BAND SERVICE (RMBS) WO2 LARGE	8440-99-981-9385	D01234
BELT CEREMONIAL WHITE PVC SWORD BELT WAIST WITH KICKING STRAPS ROYAL MARINES BAND SERVICE (RMBS) WO2 OUTSIZE	8440-99-981-9386	D01232 TG

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

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1. ISSUE RECORD

Issue No	Comments	Issue Date
1	1 st Edition	21 July 2009

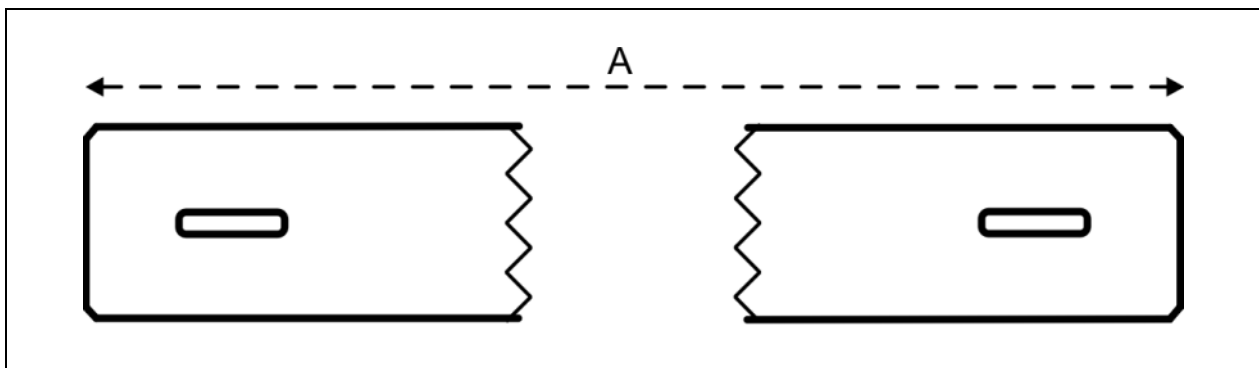
2. BILL OF MATERIALS

Refer to Technical Data Sheets at Section 8

3. 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.

4. GARMENT SIZING



All measurements are in centimetres. Measurements are made when belt is laid flat.

Size	Overall length A
Small	109.2
Medium	124.5
Large	139.7
Outsize	N/A

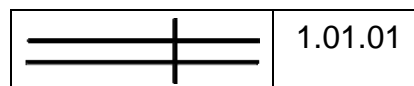
All measurements are in centimetres. Measurements are made when garment is laid flat.

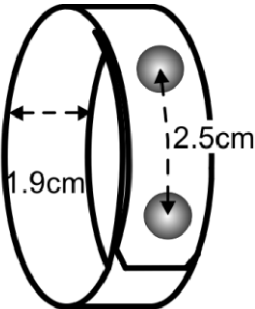
5. CONSTRUCTION

SEAMS AND STITCHING to BS 3870

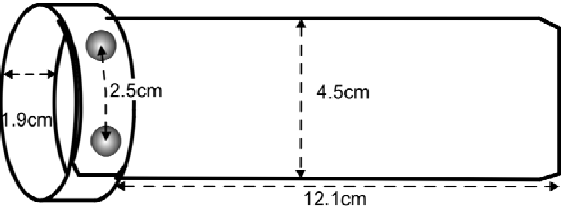
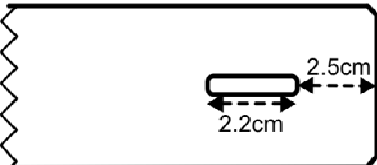
- All stitching to be machine stitch type 301 or hand stitch type 201
- To have at least 5 but no more than 6 stitches per 2cm and to be correctly tensioned
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The following seam types are referenced in this specification

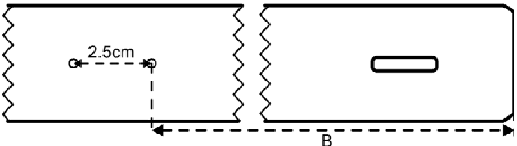


PART	DETAIL	BS 3870
BELT	<ul style="list-style-type: none"> • One-piece section. • Belt length dependent on size • Belt Width 4.5cm • Belt comes complete with: • One slider <ul style="list-style-type: none"> • One slider with tongue • One short kicking strap • One long kicking strap • Protector, Hook & Loop assembly 	
SLIDER  <p>Total length of loop 17.5cm Overlap 4.5cm</p>	<ul style="list-style-type: none"> • Slider 1.9cm wide • Total length 17.5cm • Corners chamfered at one edge as per standard pattern • Formed with a 4.5cm overlap, with chamfered corners to outer side. • Securely riveted together with two rivets, rivets positioned centrally within overlap • Ensure that the overlap on the sliders points towards the ground when the belt is worn. Diagram is correct. 	

5. CONSTRUCTION continued

<p style="text-align: center;">SLIDER WITH TONGUE</p>  <p>Total loop length 17.5cm long, overlap of 4.5cm Distance between rivets 2.5cm (centre to centre)</p>	<ul style="list-style-type: none"> • Slider 1.9cm wide • Slider total length 17.5cm • Corners are to be chamfered at one edge as per standard pattern • Formed with a 4.5cm overlap, with chamfered corners to outer side. <ul style="list-style-type: none"> • Tongue 4.5cm wide • Tongue total length 14cm • Length of tongue from slider 12.1cm • Corners chamfered at one edge as per standard pattern <ul style="list-style-type: none"> • Slider overlap and tongue (non-chamfered edge) are to be aligned as per the standard pattern and securely riveted with two rivets. • Rivets to be positioned centrally within the overlap and 2.5cm apart • Ensure that the overlap on the slider points towards the ground when the belt is worn (Diagram is correct) • When the belt is worn, the tongue is fitted on the left-hand end 	
<p style="text-align: center;">BELT END</p> 	<ul style="list-style-type: none"> • Belt ends are to have chamfered corners as on the standard pattern • Each end of the belt is to have a slot 2.2cm long and 3.5mm wide with radial ends • Positioned 2.5cm from the each end 	

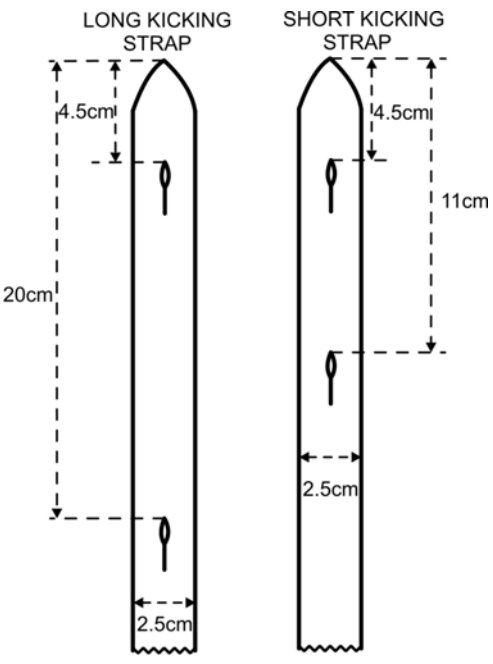
5. CONSTRUCTION continued

ADJUSTMENT HOLES			
	<ul style="list-style-type: none"> The belt is to have adjustment holes on each end 3mm in diameter, 2.5mm apart and positioned centrally on the width of belt Position and number as follows:- 		
	Size	Position of 1 st hole from end B	Number of holes
	Small	20.3	5
	Medium	22.8	5
	Large	25.4	5

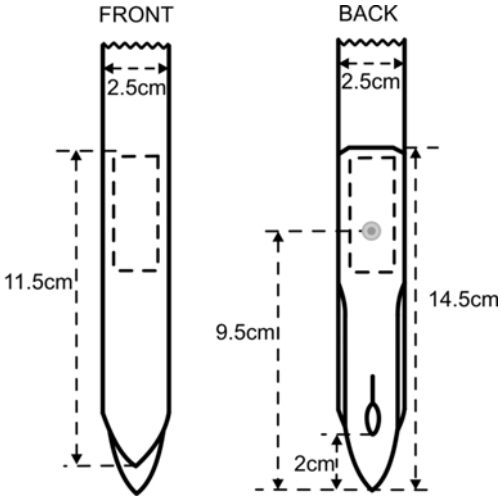
5. CONSTRUCTION continued

<p>PROTECTOR, HOOK & LOOP ASSEMBLY</p>	<p><u>Protector</u></p> <ul style="list-style-type: none"> • One layer of PVC, shaped as Standard Pattern • 15cm wide at bottom of belt • Protruding 6cm below belt • Cut away to create opening below belt • 4cm wide at top of belt • 3cm wide, 1cm below belt 		
	<p><u>Rectangular Ring</u></p> <ul style="list-style-type: none"> • 3.3cm x 1.7cm, 4mm thick, with eyehole in one corner, to be formed as per standard pattern <p><u>Sword Hook</u></p> <ul style="list-style-type: none"> • Length 5.5cm, 4mm thick, to be formed as per standard pattern and attached to rectangular ring <p><u>Hook attachment strap</u></p> <ul style="list-style-type: none"> • 11cm long • 2.5cm wide • Folded in half and passed through rectangular ring <p><u>Whole assembly</u></p> <ul style="list-style-type: none"> • To be securely attached to belt with three rows of stitching as per Standard Pattern with the metal hook and loop facing the front. • From the back view, position assembly as follows 	<p>1.01.01</p>	
<p>SIZE</p>	<p>Position of Protector from right end ('C' dimension)</p>		
<p>Small</p>	<p>33</p>		
<p>Medium</p>	<p>38.1</p>		
<p>Large</p>	<p>43.2</p>		
<p>Outsize</p>	<p>to measure</p>		

4. CONSTRUCTION continued

<p style="text-align: center;">KICKING STRAPS</p>  <p>The diagram shows two vertical kicking straps. The 'LONG KICKING STRAP' on the left is 20cm long and 2.5cm wide. It has a pointed top and two eyeholes. The first eyehole is 4.5cm from the top point, and the second is 13cm from the first. The 'SHORT KICKING STRAP' on the right is 11cm long and 2.5cm wide. It also has a pointed top and two eyeholes. The first eyehole is 4.5cm from the top point, and the second is 4.5cm from the first. Both straps have a wavy bottom edge.</p>	<p><u>Long kicking strap</u></p> <ul style="list-style-type: none"> • Overall length 97.2cm, pointed at each end, shaped as per standard pattern • Strap 2.5cm wide <p><u>Short kicking strap</u></p> <ul style="list-style-type: none"> • Overall length 41.2cm, pointed at each end, shaped as per standard pattern • Strap 2.5cm wide <p><u>Top of long kicking strap</u></p> <ul style="list-style-type: none"> • Two eyeholes, 5mm diameter hole with 18mm slit, worked centrally to accommodate double ended stud • 1st, positioned 4.5cm from pointed end, slit pointing away from point of strap • 2nd, positioned 13cm from 1st slit end, slit pointing away from point of strap <p><u>Top of short kicking strap</u></p> <ul style="list-style-type: none"> • Two eyeholes, 5mm diameter hole with 18mm slit, worked centrally to accommodate double ended stud • 1st, positioned 4.5cm from pointed end, slit pointing away from point of strap • 2nd, positioned 4.5cm from 1st slit end, slit pointing away from point of strap 	
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5. CONSTRUCTION continued

<p>KICKING STRAPS continued</p> 	<p><u>Bottom of both kicking straps</u></p> <p><u>Fastening Strap</u></p> <ul style="list-style-type: none"> • A fastening strap goes to the back of the kicking strap, shaped and chamfered as per Standard Pattern • Overall length 14.5cm • Overall width 2.5cm • The fastening strap has one eyehole, 5mm diameter hole with 18mm slit, worked centrally to accommodate single ended stud • Eyehole is to be positioned 2cm from pointed end, slit pointing away from point of the fastening strap • Single ended stud is to be positioned 9.5cm (centre) from pointed end, worked centrally to accommodate eyehole • The fastening strap is to be securely attached with box stitching, as per Standard Pattern, 11.5cm from the bottom of the kicking strap end. The stitching is to be back stitched • Each kicking strap is fitted with a swivel hook that is secured in place by closing the fastening strap 	<p>1.01.01</p>

6. PACKAGING AND LABELLING REQUIREMENTS

- a. Belts are to be supplied rolled or flat, not folded.
- b. Each individual NSN should be packed in suitably sealed clear polythene bags, and clearly labelled with the Item Description, NSN, Contract Number and Year of Manufacture, Quantity and Denomination.

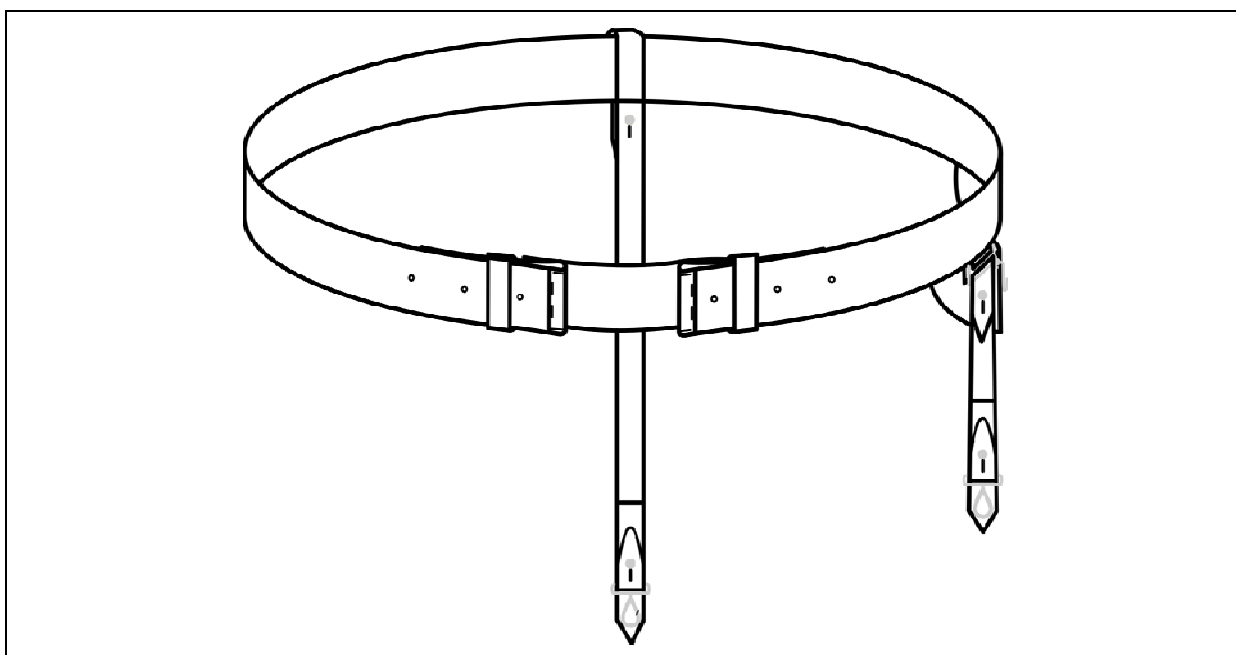
SPECIMEN LABEL (example)

Item Description: BELT CEREMONIAL SWORD RMBS WO2 SMALL
NSN: 8440-99-981-9383
Contract Number/Year of Manufacture: ABC123 / 2009
Quantity: 1
Denomination: Each

- c. Individually packed items that are to be boxed together should be packaged and labelled in accordance with the details laid down in the contract.
- d. Multiple boxes may be shipped on pallets in accordance with the details laid down in the contract.
- e. Under no circumstances should the contractor's name, logo or trademark appear on any form of labelling

7. NATO Stock Numbers and Sizes

Item Description	NATO Stock No(s)	Pattern No	Range size in Inches without buckle	Range size in Inches with buckle (+3")	Sword 'D' Guard starts from end of belt Inches
BELT SWORD RMBS WO2 SMALL	8440-99-981-9383	D01232	30 to 34	33 to 37	13
BELT SWORD RMBS WO2 MEDIUM	8440-99-981-9384	D01233	35 to 39	38 to 42	15
BELT SWORD RMBS WO2 LARGE	8440-99-981-9385	D01234	40 to 44	43 to 47	17
BELT SWORD RMBS WO2 OUTSIZE	8440-99-981-9386	D01232 TO GUIDE	To Order	To Order	To Order

8. TECHNICAL DATA SHEETS

BELT CEREMONIAL WHITE PVC SWORD BELT WAIST WITH KICKING STRAPS
RMBS WO2 SMALL

Specification No.	DC/MS/6391
Item Description	BELT CEREMONIAL WHITE PVC PARADE BELT WAIST WITH KICKING STRAPS ROYAL MARINES BAND SERVICE (RMBS) WO2 SMALL
Pattern No.	D001232, D01233 & D01234
NATO Stock No.	8440-99-981-9383 to 9386
Scope: A white PVC sword belt worn by the Royal Marine Band Service WO2s and supplied in four sizes including an outside measure	

Related Specifications	Title
BS EN 12590	Specification for industrial sewing threads made wholly or partly from synthetic fibres
BS 3870 Parts 1 and 2	Stitches and seams
UK/SC/5126	Insignia, Buttons, Pins, plates & Titles manufactured from Gilding Metal, Brass and Nickel Silver

BILL OF MATERIALS

Fabric		
Reference	Description	NATO Stock No.
To match quality of standard pattern for substance, finish and shade.	<p>WHITE 'pressed' PVC</p> <p>Thickness 3mm (belt, protector, kicking straps and tongue)</p> <p>Thickness 2mm (slider loop and hook attachment strap)</p>	Quality of substance, finish and shade is highly important to customer.

Components			
Components	Size / Colour	Reference /Description	Notes / NATO Stock No.
RIVETS	Ø10mm Silver	<p>SLIDERS</p> <p>Brass metal, bright chromium plated</p>	<p>As on standard pattern</p> <p>Or an alternative approved by DC</p> <p>To UK/SC5126</p>
DOUBLE ENDED STUDS	Ø9.5mm Length 17mm Silver	<p>LONG AND SHORT KICKING STRAPS</p> <p>Brass metal, bright chromium plated</p>	<p>As on standard pattern</p> <p>Or an alternative approved by DC</p> <p>To UK/SC5126</p>
SINGLE ENDED STUDS	Ø8mm Length 10mm Silver	<p>LONG AND SHORT KICKING STRAPS</p> <p>Brass metal, bright chromium plated</p>	<p>As on standard pattern</p> <p>Or an alternative approved by DC</p> <p>To UK/SC5126</p>
SWIVEL HOOKS	Length 56mm Silver	<p>LONG AND SHORT KICKING STRAPS</p> <p>Brass metal, bright chromium plated</p>	<p>As on standard pattern</p> <p>Or an alternative approved by DC</p> <p>To UK/SC5126</p>
SWORD HOOK & RECTANGULAR RING ASSEMBLY	Overall Length 70mm Silver	<p>PROTECTOR ASSEMBLY</p> <p>Brass metal, bright chromium plated</p>	<p>As on standard pattern</p> <p>Or an alternative approved by DC</p> <p>To UK/SC5126</p>
THREAD	20 White	<p>ALL SEWING</p> <p>Polyester/cotton corespun</p>	To BS EN 12590 Table 5