



**Technical Specification for  
CAP, SERVICE, PEAKED  
No. 2 Khaki**

**Defence Clothing**  
Integrated Project Team

PROPERTY OF :-  
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PREFACETABLE 1 – PRODUCT LIST

<b>Item Name</b>	<b>Cap, Service, Peaked</b>
<b>Nato Stock Number (NSN)</b>	8405-99-973-2641 to 2653
<b>Pattern No(s)</b>	13863B
<b>Development File No</b>	NN/SCD/P915
<b>Product Support File No.</b>	NV/452/029

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TABLE 2 – ISSUE RECORD

<b>Issue No</b>	<b>Comments</b>	<b>Issue Date</b>
7	Reformatted to DE&S template. Technical Review.	12 November 2008
6	Reformatted, Specs and docs updated photographs inserted.	18 August 2003
5		26 July 2001

PART 1

1. THE PRODUCT

- a. Use of the Product. A peaked cap, made from cloth, uniform wool, khaki, worn by the Household Cavalry, RMP and MPSC for wear with No. 2 dress. The size schedule provides for thirteen sizes.

FIGURE 1

Patt 13863B



Patt 13863B



TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

<b>Specification/Document</b>	<b>Detail</b>
BS EN ISO 105 Part X12	Textiles. Tests for colour fastness. Colour Fastness To Rubbing.
BS EN 12590	Textiles. Industrial sewing threads wholly or partly made from synthetic fibres.
BS 2780	Glossary of leather terms.
BS 3870 Part 1 & 2	Stitches and seams.
BS 4560	Fabrics for linings in uniform clothing.
UK/SC/4776	Cloth, buckram, jute.
UK/SC/5516	Cloths wool uniform dress.
UK/SC/5628	Cloth velvet cotton and silk WR.
UK/SC/5696	Leather, sheep, headleather.

2. PATTERNS.

- a. Master Patterns. The DC IPT at Caversfield holds a Master Pattern for this product. Potential contractors may view the pattern on site by arrangement with the DC IPT Commercial Department.
- a. Standard Patterns. A Standard Pattern may be obtained from the DC IPT Technical Information Office and may be used to provide the criteria for all materials, components and manufacturing features not fully defined in this specification.

PART 23. PRODUCT DESIGN

- a. Product Description. A peaked cap, made from cloth, uniform wool, khaki, for wear with No. 2 dress. The size schedule provides for thirteen sizes.

TABLE 4 – PRODUCT COMPONENTS

4.1 Crown tip, bevel, Band piping Covering of peak	<ul style="list-style-type: none"> <li>• Cloth, uniform, wool, khaki, Pattern No. 8846Q to UK/SC/5516, NATO Stock No. 8305-99-869-5454.</li> </ul>
4.2 Band Lining	<ul style="list-style-type: none"> <li>• Cloth, cotton, silesia, plain weave, black to comply with the requirements of BS 4560.</li> <li>• Or an approved alternative by DC IPT.</li> <li>• The use of sulphur dye is prohibited for black band lining.</li> </ul>
4.3 Crown Disc	<ul style="list-style-type: none"> <li>• Cellulose acetate sheet, colourless, 0.1mm thick.</li> <li>• Or sheeting, 0.1mm to 0.13mm thick.</li> </ul>
4.4 Head Leather	<ul style="list-style-type: none"> <li>• Leather, sheep, for head leathers, natural at least 1.0mm but not more than 1.3mm thick, to UK/SC/5696.</li> <li>• Or an alternative approved by DC IPT.</li> </ul>
4.5 Bow for Leather	<ul style="list-style-type: none"> <li>• Braid, Fawn, 13mm wide.</li> </ul>
4.6 Band Stiffener (Listed in order of preference)	<ul style="list-style-type: none"> <li>• Cloth, buckram, jute, laminated 2 ply, impregnated buckram to comply with the buckling and flexibility tests specified in specification UK/SC/4776.</li> <li>• Or glued hessian plain weave, 1000 g/m<sup>2</sup>.</li> <li>• Or high density polyethylene sheet, 0.1mm thickness <math>\pm</math> 0.10mm, either solid or perforated.</li> <li>• Or air expanded plastic, 1.2mm thickness.</li> <li>• Or high density Polypropylene sheet, 1.0mm thickness <math>\pm</math> 0.1mm, either solid or perforated.</li> </ul>
4.7 Peak	<ul style="list-style-type: none"> <li>• Foundation, flexible, vulcanised fibre approximately 2mm thick, flexible fibre- board 1.75mm thick.</li> <li>• Upper side cloth covered in material stated in 4.1.</li> <li>• An alternative approved by the DC IPT.</li> </ul>

TABLE 4 – PRODUCT COMPONENTS continued

4.8 Lining for Peak	<ul style="list-style-type: none"> <li>• Skiver green or imitation skiver green, embossed cotton backed plastic. The term skiver is defined in BS 2780. and is to conform to Table 8.</li> </ul>
4.9 Front Support	<ul style="list-style-type: none"> <li>• Sprung steel support, with brass tip.</li> <li>• Or an alternative approved by DC IPT.</li> </ul>
4.10 Wire for Crown	<ul style="list-style-type: none"> <li>• Wire, steel, galvanised, rustproof 15SWG with steel or brass connecting tube, all metals to be rustproof.</li> <li>• An alternative approved by DC IPT.</li> </ul>
4.11 Binding stiffener for peak	<ul style="list-style-type: none"> <li>• Cloth, velveteen, fawn or black to comply with the colour fastness requirements for perspiration, Table 2, of UK/SC/5628.</li> </ul>
4.12 Thread, For all purposes	<ul style="list-style-type: none"> <li>• Thread, corespun polyester cotton of BS EN 12590.</li> <li>• Metric Ticket No. 25 (26) for sewing peak to stiffener.</li> <li>• Metric Ticket No. 36 (35) for bevel, band, sewing in crown, back and front finishing, band lining marking button position and all hand sewing.</li> <li>• Metric Ticket No. 75 for all other sewing.</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Crown	<ul style="list-style-type: none"> <li>• The crown tip, oval in shape, is to comply with the measurements set out in Table 7. The measurements are to be taken from the crown tip seam.</li> <li>• The perimeter of the crown tip is to have a piped edge joined in line with the back seam of the bevel quarters.</li> <li>• A detachable transparent disc, sufficient to cover the crown tip, is to be inserted.</li> </ul>
5.2 Bevel	<ul style="list-style-type: none"> <li>• The bevel is to be quartered with the seams opened and pressed flat.</li> </ul>
5.3 Band	<ul style="list-style-type: none"> <li>• The band is to be joined at the centre back of the cap in line with the seam of the bevel.</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION continued

5.4 Band Stiffener	<ul style="list-style-type: none"> <li>• The stiffener is to be cut sufficiently long to allow a 2cm overlap where it is joined at the back of the cap slightly offset to reduce thickness.</li> <li>• The stiffener is to be stitched through the outer material of the band 0.6cm from the bottom edge, and baisted through the outer material at the band/bevel seam.</li> <li>• The stiffener is to be covered with the lining as stated in 4.2. The lining is to be securely attached at the top and bottom of the stiffener by either hand or machine stitching.</li> </ul>
5.5 Peak	<ul style="list-style-type: none"> <li>• The peak, cloth side uppermost, chamfer edged on the brow line and lined on the underside, is to be identical in shape to that of the Standard Pattern.</li> <li>• When fitted the peak is to be correctly balanced and central to the front seam of the bevel quarters.</li> <li>• The peak may be fitted to the band stiffener by sewing the inner edge of the peak to either the inner or outer edge of the stiffener.</li> <li>• The seam allowance from seam to inner peak edge is not to be less than 0.3cm and not more than 0.5cm.</li> <li>• When fitting the peak to the outer edge of the stiffener, the bottom edge of the stiffener is to be bound with velveteen.</li> <li>• When fitting the peak to the inner edge of the stiffener, a strip of velveteen, depth 2.5cm is to be sewn to the head leather prior to attaching the head leather to the cap, extending the length of the peak.</li> </ul>
5.6 Head Leather	<ul style="list-style-type: none"> <li>• The cap is to have a brachered head leather, the ends of which are overlapped 1cm, at the centre back of the cap, and tacked together at the top edge through the braid bow.</li> <li>• The taping on the headleather may be sewn to the band by hand or machine, but in neither case is the leather to show below the bottom edge of the band.</li> </ul>
5.7 Crown Wire	<ul style="list-style-type: none"> <li>• A cap wire with a connecting tube is to be fitted on the inside of the cap above the piping of the crown.</li> </ul>



TABLE 5 – PRODUCT CONSTRUCTION continued

5.8 Front Support	<ul style="list-style-type: none"> <li>• The front metal support is to be securely fixed onto the crown wire and lie immediately behind the front bevel seam.</li> <li>• The bottom of the support is to be housed in a 2.5cm square pocket of good quality leather sewn to the centre front of the band stiffener.</li> <li>• The front support is not to protrude above the bevel/piping seam.</li> </ul>
5.9 Button Position	<ul style="list-style-type: none"> <li>• The button position is to be indicated on each side, by marking with white thread or plastic tag 0.6cm from the bottom edge and in line with the side seam bevel.</li> </ul>
5.10 Seams and Stitching to BS 3870	<ul style="list-style-type: none"> <li>• Machine stitching is to be stitch type 301, with at least eight but not more than ten stitches per 2cm and be correctly tensioned.</li> <li>• The crown/bevel piped seam is to be formed using seam type 1.12.01.</li> <li>• The brachering on the headleather is to have at least six stitches per 2cm.</li> </ul>
5.11 General	<ul style="list-style-type: none"> <li>• Sewing threads may be treated with a stain free lubricant.</li> <li>• All seams are to be free from pucker.</li> <li>• The cap is to be free from all ends of sewing thread, be blocked and pressed and delivered in a clean condition.</li> </ul>

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS AND ACTUAL BODY MEASUREMENTS

Nato Stock No. 8405-99-973	2641	2642	2643	2644	2645	2646	2647	2648	2649	2650	2651	2652	2653
Size and Internal Circumference	51	52	53	54	55	56	57	58	59	60	61	62	63

TABLE 7 – MEASUREMENTS AND TOLERANCES

															Tols (mm)	
Size	51	52	53	54	55	56	57	58	59	60	61	62	63	+	-	
CROWN		All sizes 2 cm oval														
Length		25.8	26.1	26.4	26.7	27	27.3	27.6	27.9	28.2	28.5	28.8	29.1	29.4	2	2
Width		24.6	24.9	25.2	25.5	25.8	26.1	26.4	26.7	27	27.3	27.6	27.9	28.2	2	2
Crown tip piping depth	Bevel Depth	5													2	2
	Band Depth	5													2	2
PEAK	Depth at centre	4													1	1
	Length point to point	19.5													5	5
Stiffener Depth		6													2	2
Headleather Depth		4.5													2	2
FRONT SUPPORT	Depth	7.6													2	2
	Width	1.2													<u>2</u>	<u>2</u>

- All measurements are in centimetres unless otherwise stated.

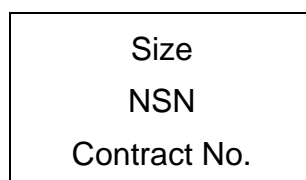
TABLE 8 – TEST REQUIREMENTS.

The peak lining is to conform to the requirements of the following Table:

Agency	Rating for colour change	Method of Test
Rubbing wet	4	BS EN ISO 105 Part X12

4. LABELLING. The size number, NATO Stock Number and the contract number is to be either:
- Clearly marked on a label to be sewn to the centre of the crown lining. Or
  - Clearly printed on a pressure sensitive self adhesive label to be adhered to the crown lining.
  - The identification label is to be covered by the crown disc, including pressure sensitive self adhesive labels.

FIGURE 2



Example Identification and marking label.

- The size number is to be 1.2cm high and the remainder of the characters 0.6cm high.