



**Technical Specification for
BONNET MAN'S
Caubeen, Royal Irish Regt, Pipers and Irish Guards**

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PREFACETABLE 1 – PRODUCT LIST

Item Name	Bonnet, Man's, Caubeen, Royal Irish Regt, Pipers and Irish Guards
Nato Stock Number (NSN)	8405-99-122-2418 to 2431
Pattern No(s)	19949B
Development File No	D/DCTA/P2828 (ST)
Product Support File No.	D/DCTA/502/04 (QPS)

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
11	Reformatted to DE &S template. Technical Review.	30 October 2008
10	Amendment to Table 9.	20 May 2003
9	Reformatted, amended to include Irish Guards	25 April 2003
8	Amended to reflect new 'B' version of pattern number.	16 October 2001

PART 1

1. THE PRODUCT

a. Use of the Product. A bonnet, known as a Caubeen, for wear by Royal Irish Regt, Pipers and Irish Guards. The size schedule provides for fourteen sizes.

FIGURE 1. Bonnet, Caubeen Pattern 19949B



Back and right hand side as worn

TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 B02 E01 E04 D01	Textiles. Test for Colour Fastness Colour fastness to artificial light: Xenon arc fading lamp test Colour fastness to water Colour fastness to perspiration Colour fastness to dry cleaning
BS EN 12590	Textiles. Industrial Sewing Threads made wholly or partly from Synthetic Fibres.
BS 3870 Part 1 & 2	Stitches and seams
BS 4560	Linings in uniform clothing
BS 4973 Part 4	Interlinings. Specification for woven sew-in interlinings.
BS 5742	Textile labels requiring to be washed and/or dry cleaned
UK/SC/5516	Cloths wool uniform dress

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 2

3. PRODUCT DESIGN

- a. Product Description An all wool bonnet.

TABLE 4 – PRODUCT COMPONENTS

4.1 Crown, bevel and band	<ul style="list-style-type: none"> Cloth, uniform, wool, Green No.1, Pattern No.8849E, to specification UK/SC/5516, NATO Stock No.8305-99-869-4376
4.2 Crown wadding	<ul style="list-style-type: none"> Wadding, polyester fibre, white, weight 100g/m²
4.3 Crown, bevel and band lining	<ul style="list-style-type: none"> Cloth, plain weave, polyester, Black, Pattern No.8721B to BS 4560, NATO Stock No.8305-99-769-6219
4.4 Interlining crown and bevel	<ul style="list-style-type: none"> Cloth, twill, cotton, Black. 105g/m² To comply to the colourfast requirements to Table 5 UK/SC/5900. Aniline & sulphur black dyes prohibited. Or an alternative approved by the DC IPT.
4.5 Crown disc	<ul style="list-style-type: none"> Cellulose acetate sheet, Colourless, 0.1mm thick
4.6 Stiffener for band and badge Support	<ul style="list-style-type: none"> Cloth, buckram, flax and jute, No.2, Pattern No.8320A, WS4 (L6) to BS 4973 Part 4, NATO Stock No.8305-99-942-8282
4.7 Fasteners for retaining the badge support in position	<ul style="list-style-type: none"> Fasteners, snap, black
4.8 Thread For all purposes	<ul style="list-style-type: none"> Thread, polyester/cotton, Black, green as appropriate, To BS EN 12590 Metric Ticket No.36 (35) for all sewing Or an alternative approved by the DC IPT,

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Crown	<ul style="list-style-type: none"> • The crown is to be circular in shape and comply with the measurements set out in Table 7 • The crown is to be securely combined to black twill with a solution of good quality rubber, which may contain mineral matter not exceeding 40 parts, by weight to 60 parts by weight of rubber. • The crown/ bevel seam is to be pressed open.
5.2 Bevel	<ul style="list-style-type: none"> • Made from one piece of material, joined at the centre back (seam pressed open). It is to be cut with the highest point positioned left hand side as worn at one third of the crown circumference from the centre back seam and is to be combined to black twill as specified in clause 5.1 Crown.
5.3 Band	<ul style="list-style-type: none"> • The band is to be joined at the centre back of the bonnet in line with the bevel seam. • The band interlining, of buckram, 3.5cm wide, is to be cut with an overlap of 4cm where it is joined at the back of the bonnet. • The band is to have an upturn, 1.9cm wide, which is to be securely sewn to the buckram. • The stitches are not to show on the outside of the bonnet.
5.4 Crown lining	<ul style="list-style-type: none"> • The crown lining is to be cut from one layer of polyester wadding and one of plain weave polyester lining and be sewn together using diamond shaped quilting, as on the Standard Pattern.
5.5 Bevel lining	<ul style="list-style-type: none"> • The bevel lining is to be sewn to the crown using seam type 1.01.01 of BS 3870.
5.6 Band lining	<ul style="list-style-type: none"> • The bottom edge of the bevel lining and interlining are to be sewn in with the top edge of the band lining. The bottom edge of the band lining is to be securely sewn to the inturn of the band. • The bottom edge of the band lining may be machine stitched through the band to show on the outside 0.6cm from the edge.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

<p>5.7 Badge support</p>	<ul style="list-style-type: none"> • The support, made of buckram lined on either side and sewn together by five rows of stitching as on the Standard Pattern is to be approximately 9cm deep, 17.5cm wide and shaped as on the Standard Pattern. • The bottom edge of the support is to be securely sewn to the top of the band lining with the centre of the badge support positioned centrally at the highest point at the left side of the bevel. • For the purpose of retaining the support in position, the male portions of two press studs are to be securely sewn to the top of the support spaced 5cm apart. The female portions, positioned to correspond with the male portions, are to be securely sewn to the bevel lining.
<p>5.8 Crown disc</p>	<ul style="list-style-type: none"> • A disc, approximately 13cm in diameter is to be affixed to the crown lining over the identification particulars.
<p>5.9 Seams and stitching to BS 3870</p>	<ul style="list-style-type: none"> • Machine stitching is to be stitch type 301, with at least eight but not more than ten stitches per 2cm.
<p>5.10 General</p>	<ul style="list-style-type: none"> • Sewing threads may be treated with stain free lubricants. • All seams are to be free from pucker. • The bonnet is to be free from all ends of sewing threads, blocked and pressed and delivered in a clean condition.

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

NATO Stock number 8405-99-122-	2418	2419	2420	2421	2422	2423	2424	2425	2426	2427	2428	2429	2430	2431
Size number & Internal Circumference of Headband	50	51	52	53	54	55	56	57	58	59	60	61	62	63

- All measurements are in centimetres

TABLE 7 - MEASUREMENTS AND TOLERANCES

Size number & Internal Circumference of Headband	50	51	52	53	54	55	56	57	58	59	60	61	62	63	Tolerance in mm		
															+	-	
Crown diameter	27.3	27.6	27.9	28.2	28.5	28.8	29.1	29.4	29.7	30	30.3	30.6	30.9	31.2	2	2	
Bevel - depth at																	
Centre front															8.0	2	2
Highest point*															9.5	2	2
Left ¼ position															9.0	2	2
Right ¼ position															7.0	2	2
Centre back															6.0	2	2
Band depth															3.0	2	2

*The highest point is taken 3cm forward from the left ¼ position as worn.

4. LABELLING REQUIREMENTS: Size number, NATO Stock and contract number are to be :

- Clearly marked on a label sewn to the centre of the crown lining

Or

- Clearly printed on a pressure sensitive self adhesive label, to be adhered to the centre of the crown lining

TABLE 8 – SPECIMEN LABELS



Figure 2 Example Identification and marking label

The size number is to be 0.6cm high and the remainder of characters no less than 0.2cm high.

TABLE 9 - TEST TABLE

Finished body of Caubeen is to conform to the following:

Method of Test BS EN ISO 105							
B02		E01		D01		E04	
Light (xenon)		Water		Dry Cleaning		Perspiration	
Colour change	Staining	Colour change	Staining	Colour change	Staining	Colour change	Staining
4-5	-	4	3-4	4	4	4	3-4