



**Technical Specification for
CAP, SERVICE
No. 1 and No. 2 Dress, Regt and Corps (except Household
Brigade)
And the Ministry of Defence Guard Service.**

Defence Clothing
Integrated Project Team

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PREFACETABLE 1 – PRODUCT LIST

Item Name	Cap, Service	
Development File No	D/DCTA/P2943 & P3225 (ST)	
Product Support File No.	D/DCTA/452/029 (QPS)	
NATO Stock Numbers	Regiment	Pattern No.
8405-99-136-0000 to 0015	Royals and Royal Military Academy Sandhurst	20350
8405-99-136-0160 to 0175	Non Royals	20351A
8405-99-136-0021 to 0031	QDG	28358
8405-99-132-2652 to 2663	Scots DG	20328
8405-99-136-0036 to 0045 and SM 136-0047	Royal Dragoon Guards	28359
8405-99-136-0225 to 0239	Queen's Royal Hussars & Light Dragoons. QOY (D & Y Sqn) RWxY (B&D Sqn)	28360
8405-99-136-0261 to 0269 and SM 136-0271	QOY	28361
8405-99-136-0385 to 0400	9/12 RL	20357
8405-99-136-0195 to 0207	King's Royal Hussars RWxY C Sqn	28362
8405-99-136-0417 to 0432	Queen's Royal Lancers	20359
8405-99-136-0321 to 0335	RE, MPSC, Drum Major & Drummer, 71(SC) Engr Regt, 74 (Antrim Arty) Engr Regt	20354
8405-99-136-0176 to 0191	R Signals	28363
8405-99-136-0352 to 0367	RGJ	20355A
8405-99-136-0064 to 0079	RAMC	28365
8405-99-136-0084 to 0095	RAVC	28366
8405-99-136-0096 to 0108 and SM 136-0111	RADC	28367

TABLE 1 – PRODUCT LIST continued

NATO Stock Number	Regiment	Pattern No.
8405-99-136-0288 to 0303	D (North Irish Horse) Sqn Royal Yeomanry Regt	28364
8405-99-978-9839 to 9852	RLC	27499
8405-99-978-9938 to 9953	QARANC	27551
8405-99-130-6451 to 6462	Ministry of Defence Guard Service	28043

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IPR STATEMENT

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TABLE 2 – ISSUE RECORD

Issue No	Amendments	Issue Date
18	Reformatted to DE&S template. Updated specs & docs.	12 November 2008
17	All Spec – The Royals Cap (NSN 8405-99-136-0000 to 0015) will now be used by RMAS as well.	23 August 2005
16	All spec - Honourable Artillery Company Cap NSN 8405-99-136-0368 to 0384 Pattern No.20356A has been removed from the specification. The HAC Cap has been transferred to UK/SC/3979 Cap No 1 Dress Footguards. All spec - Change Title from Police Constable MGS and Sergeants to MGS.	14 February 2005
15	Page 6 and 7 – All reference to UK/SC/5594 and Pattern 8236A deleted. Pattern 8849J inserted. Page 8 – Correction to dimensions in para 4.6 Page 19 – Pattern 8849J inserted. Pattern 8236A deleted.	22 September 2004
14	Table 7, Measurements - Peak Length- Reverted back to original measurement in previous issues of 23cm. Table 4, Product Components – 4.1 Amended typing error and included all fabrics detailed in Table 8	09 March 2004
13	New format, changes to size schedule Changes to main materials	14 August 2003
12	Size and NSN schedule added	04 April 2002

PART 1

1. THE PRODUCT

a. Use of the Product. A peaked cap for wear with No. 1 or No. 2 Dress by Regiments and Corps (except Household Brigade) and the Ministry of Defence Guard Service. Details at Pages 14 and 15 Table six schedules of requirements.

FIGURE 1.

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TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 Part X12	Textiles. Tests for colour fastness. Colour Fastness To Rubbing.
BS EN ISO 845	Cellular plastics and rubbers - Determination of apparent (bulk) density.
BS EN 12590	Textiles. Industrial sewing threads made wholly or partly made from synthetic fibres.
BS EN ISO 139	Textiles. Standard atmospheres for conditioning and testing.
BS 2780	Glossary of leather terms.
BS 3412	Methods of specifying general purpose polyethylene materials for moulding and extrusion.
BS 3870 Part 1 & 2	Stitches and seams.
BS 4560	Fabrics for linings in uniform clothing.
UK/SC/4687	Embroidered and other distinguishing items and the components used therein.
UK/SC/4776	Cloth, buckram, jute.
UK/SC/5126	Badges, button, pins, plates and titles made from GM brass and nickel silver.
UK/SC/5516	Cloths, wool, uniform dress.
UK/SC/5628	Cloth, velvet, cotton and silk, WR.
UK/SC/5696	Leather, sheep, head leathers.

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.

b. 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. Service cap with patent peak and crown, bevel and band piping. The design and dimensions of the cap are as stated in Tables 7 & 8.

TABLE 4 – PRODUCT COMPONENTS

4.1 Crown tip and bevel, band and piping	<ul style="list-style-type: none"> Details as specified in Table 8; to conform to UK/SC/5516 shades as specified below. 		
<ul style="list-style-type: none"> Cloth, Wool, Woollen, Plain Weave, melton 395 – 420 g/m² Blown finish Shade and finish to match Pattern No. 8849 specified Colourfastness & steam shrinkage requirements to meet those in UK/SC/5516 	Pattern No	Colour	NATO Stock No
	8849A	Red	8305-99-869-4372
	8849B	Scarlet	8305-99-869-4373
	8204B	Maroon	8305-99-942-7115
	8849C	Crimson	8305-99-869-4374
	8849E	Rifle Green	8305-99-869-4376
	8849F	White	8305-99-869-4377
	8849J	Dark Navy	8305-99-869-4380
	8849K	Yellow	8305-99-869-4381
	8849L	Grey	8305-99-869-4382
	8849P	Light Navy	8305-99-869-5466
	8849W	Guards Green	8305-99-471-3333
	8849U	Navy	8305-99-471-3331
	4.2 Crown, bevel and band lining	<ul style="list-style-type: none"> Cloth, twill viscose, plain weave polyester or plain weave viscose. All linings to be grey or black to meet the colour fastness requirements for perspiration, Table 4 Ref 1.4 of BS 4560. 	

TABLE 4 – PRODUCT COMPONENTS continued

4.3 Crown Disc	<ul style="list-style-type: none"> • Cellulose acetate sheet, colourless, or • Polyethylene film, or • PVC Sheeting Not less than 0.1mm and not more than 0.13mm.
4.4 Interlining, Crown, Bevel and Piping	<ul style="list-style-type: none"> • Flexible polyurethane having cells of uniform size and conforming to the requirements of Table 10. • Not less than 3mm and not more than 5mm.
4.5 Head Leather	<ul style="list-style-type: none"> • Leather, sheep for head leathers, basil, natural, at least 1.0mm, but not more than 1.3mm thick to UK/SC/5696. The term Basil is defined in BS 2780. • Or an imitation leather of poromeric quality. • Or an alternative approved by the DC IPT
4.6 Band stiffener (Listed in order of preference)	<ul style="list-style-type: none"> • Cloth, buckram, jute, laminated 2 ply, impregnated buckram to comply with the buckling and flexibility tests specified in specification UK/SC/4776. • Or glued hessian plain weave, 1000 g/m². • Or high density polyethylene sheet, 1.0mm thickness \pm 0.10mm, either solid or perforated. • Or air expanded plastic, 1.2mm thickness. • Or high density Polypropylene sheet 1.0mm thickness \pm 0.10 mm, either solid or perforated.
4.7 Peak	<ul style="list-style-type: none"> • Flexible PVC, black/beige laminate with black side polished and beige side flock sprayed, approximately 1.0mm thick laminated to flexible vulcanised fibre or flexible fibreboard, or • Two part laminate fabric impregnated with polyurethane with black patent finish approximately 1.0mm thick laminated to polypropylene/ polyethylene, surface finish leather grain, colour to be bottle green, approximately 1.5mm thick. • Total thickness of peaks to be no less than 2.5mm and no more than 2.8mm, to comply with the requirements of Table 12.
4.8 Lining for Peak (except two part laminate)	<ul style="list-style-type: none"> • Skiver green or imitation skiver green embossed cotton backed plastic. • The term skiver is defined in BS 2780 and to comply with the colour fastness in Table 9.

TABLE 4 – PRODUCT COMPONENTS continued

4.9 Binding for Peak	<ul style="list-style-type: none"> PVC, Black, 0.6mm thick.
4.10 Binding, stiffener at peak	<ul style="list-style-type: none"> Cloth, velveteen, fawn or black to comply with the colour fastness requirements for perspiration, Table 2 of UK/SC/5628.
4.11 Support for front	<ul style="list-style-type: none"> High density polyethylene conforming to BS 3412 Section 3 Type A Class Q, 1.0 to 1.3mm thick.
4.12 Crown Wire	<ul style="list-style-type: none"> Rustproof wire uncovered or nylon coated or cotton covered, with a steel or brass connecting tube. Or an alternative approved by the DC IPT.
4.13 Additional headband (Pattern No. 20355A)	<ul style="list-style-type: none"> Braid, worsted, black, 44mm, Pattern No. 9337A NATO Stock No. 8305-99-973-0787 to comply with the requirements of Specification UK/SC/4687.
4.14 Badge Holder except 8405-99-136-0176 to 0191	<ul style="list-style-type: none"> Brass as on the standard Pattern. Or an alternative approved by the DC IPT.
4.15 Buttons for Pattern No. 28043 MGS	<ul style="list-style-type: none"> Button, ER Insignia, 14mm (22 ligne), Pattern No. 15914, UK/SC/5126, NSN 8455-99-973-0374.
4.16 Chinstrap for Pattern No. 28043 MGS	<ul style="list-style-type: none"> PVC black, 480mm long by 10mm wide, at least 1.0mm but not more than 1.3mm deep with buckles.
4.17 For all purposes	<ul style="list-style-type: none"> Thread, corespun polyester/cotton to BS EN 12590. Metric Ticket No. 25 (26), for peak to stiffener. Metric Ticket No. 36 (35) Bevel, band, sewing in crown, back and front finishing, lining and all hand sewing. Metric Ticket No. 75 for all other sewing.

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Crown	<ul style="list-style-type: none"> • 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 piping seam. • The perimeter of the crown tip is to have a piped edge joined in line with the back seam of the bevel quarters. • The crown and piping are to be combined to flexible polyurethane foam. The foam is to be bonded to the outer material and the laminate produced is to comply with the requirements set out in Table 11. The bond is to be continuous to ensure that the outer material is free from blisters.
5.2 Bevel	<ul style="list-style-type: none"> • The bevel, combined to flexible polyurethane foam as specified in para 5.1 above, is to be quartered with the seams opened and pressed flat. • The band/bevel seam is to be pressed open at the centre front to the side bevel seams only.
5.3 Band	<ul style="list-style-type: none"> • The band is to be constructed as detailed in Table 8.
5.4 Additional headband for Pattern No. 20355A RGJ	<ul style="list-style-type: none"> • The additional headband is to be fitted with the join at the centre front, seamed 1.5cm, be pressed flat with the corners turned in and secured to prevent fraying.
5.5 Band stiffener	<ul style="list-style-type: none"> • 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. • The stiffener is to be stitched through the outer material immediately below the stitched out welt or through the seam joining the two piece band, and basted to the band/bevel seam. • The stiffener is to be oval (head shaped) to eliminate undue pressure on the wearer's head.

TABLE 5 – PRODUCT CONSTRUCTION continued

5.6 Lining	<ul style="list-style-type: none"> • The crown lining is to be sewn in with the crown tip piping seam and be securely attached at the bottom edge of the stiffener by hand or machine stitching or securely glued with a suitable adhesive. • The lining is to be cut deep enough to allow the side and back bevel to roll without distortion. • A detachable transparent disc, sufficient to cover the crown tip is to be inserted on top of the crown lining.
5.7 Peak	<ul style="list-style-type: none"> • The peak, black 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. • The outer edge is to be bound with black PVC, 0.6cm deep when finished. • When fitted the peak is to be correctly balanced and central to the front seam of the bevel quarters. • 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. The seam allowance from seam to inner peak edge is not to be less than 0.3cm and not more than 0.5cm. • When fitting the peak to the outer edge of the stiffener, the bottom edge of the stiffener is to be bound with velveteen. • 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. • The peak is to be securely sewn on to the stiffener with approximately four stitches per 2cms.
5.8 Head Leather	<ul style="list-style-type: none"> • Each cap is to have a brachered head leather, the ends of which are to be overlapped not less than 1cm and not more than 4cm at the centre back of the cap and tacked together at the top and bottom edge. • The taping on the head leather may be sewn to the band by hand or machine, but in neither case is the head leather to show below the bottom edge of the band.

TABLE 5 – PRODUCT CONSTRUCTION continued

5.9 Crown Wire	<ul style="list-style-type: none"> • A removable crown wire is to be fitted on the inside of the piping of the crown.
<p>5.10 Button Position and chinstrap position</p> <p>Pattern No 28043 MGS</p>	<ul style="list-style-type: none"> • The button position is to be indicated on each side of the cap by sewing a small piece of knotted white sewing thread or a plastic tag 0.6cm from the bottom edge of the band and in line with the side seam of the bevel. • Buttons Insignia to be attached to the band/welt seam in line with the cap side bevels. • Chinstrap as specified to be attached.
5.11 Front support	<ul style="list-style-type: none"> • The support is to have a curved top edge and be securely attached to the band stiffener, positioned at the centre front and 1.5cm below the top edge. • The front support is not to protrude above the crown/ bevel seam.
5.12 Badge holder (Except Pattern No. 28363 R Signals)	<ul style="list-style-type: none"> • The badge holder is to be fitted vertically between the band and the stiffener at the centre front of the cap, with the socket next to the band. The projection at the top of the holder protruding on the outside 0.5cm above the band/bevel seam or, where relevant, the band piping/bevel seam. • The holder is to be securely sewn, through the holes in the sides to the stiffener. The opening, made in the band/bevel or band piping/bevel seam to accommodate the shank of the badge, is to be securely tacked at each side of the badge holder.

TABLE 5 – PRODUCT CONSTRUCTION continued

5.13 Bevel roll for Pattern No. 28043 MGS	<ul style="list-style-type: none"> • The front bevel is to be padded, so as to give the same effect and appearance as that of the Standard Pattern.
5.14 Seams and stitching to BS 3870	<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. • The piping is to be formed using seam type 1.12.01. • The binding on the peak is to be formed using seam type 3.01.01. • The brachering on the head leather is to be stitch type 304 with at least six stitches per 2cm. • The felling on the head leather is to have at least six stitches per 2cm. • The peak is to be sewn to the stiffener with approximately four stitches per 2cm.
5.15 General	<ul style="list-style-type: none"> • Sewing threads may be treated with a stain free lubricant. • All seams are to be free from pucker. • To be blocked, steamed and shaped to retain appearance and be delivered in a clean condition. • The surface of the peak is to be free from cracking and other defects.

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

Serial No	Size NATO Stock No (NSN). All start with 8405-99	48	49	50	51	52	53	54	55
1	Royals and RMAS	136-0000	136-0001	136-0002	136-0003	136-0004	136-0005	136-0006	136-0007
2	Non Royals	136-0160	136-0161	136-0162	136-0163	136-0164	136-0165	136-0166	136-0167
3	QDG						136-0021	136-0022	136-0023
4	Scots DG					132-2652	132-2653	132-2654	132-2655
5	4/7 DG Royal DG					136-0036	136-0037	136-0038	136-0039
6	QRH, LD QOY(D&Y Sqn)		136-0225	136-0226	136-0227	136-0228	136-0229	136-0230	136-0231
7	QOY						136-0261	136-0262	136-0263
8	RL	136-0385	136-0386	136-0387	136-0388	136-0389	136-0390	136-0391	136-0392
9	KRH RWxY C Sqn				136-0195	136-0196	136-0197	136-0198	136-0199
10	Queen's Royal Lancers	136-0417	136-0418	136-0419	136-0420	136-0421	136-0422	136-0423	136-0424
11	RE, MPSC, Drum Major and Drummer 71(SC) Engr. Regt, 74 (Antrim Arty) Emngr. Regt.		136-0321	136-0322	136-0323	136-0324	136-0325	136-0326	136-0327
12	R Signals	136-0176	136-0177	136-0178	136-0179	136-0180	136-0181	136-0182	136-0183
13	RGJ	136-0352	136-0353	136-0354	136-0355	136-0356	136-0357	136-0358	136-0359
14	RAMC	136-0064	136-0065	136-0066	136-0067	136-0068	136-0069	136-0070	136-0071
15	RAVC					136-0084	136-0085	136-0086	136-0087
16	RADC	136-0096	136-0097	136-0098	136-0099	136-0100	136-0101	136-0102	136-0103
17	D (North Irish Horse) Squadron Royal Yeomanry Regt	136-0288	136-0289	136-0290	136-0291	136-0292	136-0293	136-0294	136-0295
18	RLC			978-9839	978-9840	978-9841	978-9842	978-9843	978-9844
19	QARANC	978-9938	978-9939	978-9940	978-9941	978-9942	978-9943	978-9944	978-9945
20	MGS					130-6451	130-6452	130-6453	130-6454

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

Serial No	Size NATO Stock No (NSN). All start with 8405-99	56	57	58	59	60	61	62	S/M
1	Royals and RMAS	136-0008	136-0009	136-0010	136-0011	136-0012	136-0013	136-0014	136-0015
2	Non Royals	136-0168	136-0169	136-0170	136-0171	136-0172	136-0173	136-0174	136-0175
3	QDG	136-0024	136-0025	136-0026	136-0027	136-0028	136-0029	136-0030	136-0031
4	Scots DG	132-2656	132-2657	132-2658	132-2659	132-2660	132-2661	132-2662	132-2663
5	Royal DG	136-0040	136-0041	136-0042	136-0043	136-0044	136-0045		136-0047
6	QRH, LD QOY(D&YSqn)	136-0232	136-0233	136-0234	136-0235	136-0236	136-0237	136-0238	136-0239
7	QOY	136-0264	136-0265	136-0266	136-0267	136-0268	136-0269		136-0271
8	9/12 RL	136-0393	136-0394	136-0395	136-0396	136-0397	136-0398	136-0399	136-0400
9	KRH RWxY C Sqn	136-0200	136-0201	136-0202	136-0203	136-0204	136-0205	136-0206	136-0207
10	Queen's Royal Lancers	136-0425	136-0426	136-0427	136-0428	136-0429	136-0430	136-0431	136-0432
11	RE, MPSC, Drum Major and Drummer 71(SC) Engr. Regt, 74 (Antrim Arty) Emngr. Regt	136-0328	136-0329	136-0330	136-0331	136-0332	136-0333	136-0334	136-0335
12	R Signals	136-0184	136-0185	136-0186	136-0187	136-0188	136-0189	136-0190	136-0191
13	RGJ	136-0360	136-0361	136-0362	136-0363	136-0364	136-0365	136-0366	136-0367
14	RAMC	136-0072	136-0073	136-0074	136-0075	136-0076	136-0077	136-0078	136-0079
15	RAVC	136-0088	136-0089	136-0090	136-0091	136-0092	136-0093	136-0094	136-0095
16	RADC	136-0104	136-0105	136-0106	136-0107	136-0108			136-0111
17	D (North Irish Horse) Squadron Royal Yeomanry Regt	136-0296	136-0297	136-0298	136-0299	136-0300	136-0301	136-0302	136-0303
18	RLC	978-9845	978-9846	978-9847	978-9848	978-9849	978-9850	978-9851	978-9852
19	QARANC	978-9946	978-9947	978-9948	978-9949	978-9950	978-9951	978-9952	978-9953
20	MGS	130-6455	130-6456	130-6457	130-6458	130-6459	130-6460	130-6461	130-6462

TABLE 7 – MEASUREMENTS AND TOLERANCES All measurements are in centimetres unless otherwise stated.

																	Tol (mm)		
Size and Internal Circumference		48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	Special Measure	-	+
Crown 1.2 Oval	Length	24.9	25.2	25.5	25.8	26.1	26.4	26.7	27.0	27.3	27.6	27.9	28.2	28.5	28.8	29.1		2	2
	Width	23.7	24	24.3	24.6	24.9	25.2	25.5	25.8	26.1	26.4	26.7	27	27.3	27.6	27.9		2	2
Bevel Depth		5															2	2	
Band Width		5															2	2	
Peak Depth	Centre Front	5															1	1	
Peak Length	From Point to Point	23															5	5	
Head Leather		4															2	2	
Stiffener		5.5															2	2	
Front Support		6.5															2	2	

TABLE 8 – CAP, SERVICE, No. 1 and No. 2 Dress Regts & Corps (except Household Brigade) and MGS

Serial No	NATO Stock Nos 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
1	136-0000 to 0014	Royals RA, R Anglian, King's Own Border, QLR, RWF (WO1 only) RRW, REME, SASC DYRMS, PWRR, RLC, AGC, RGBW, RMAS	20350	Number 1 The band is to be constructed in two parts. The top portion is to be 44mm wide and the bottom portion 6mm wide. The seam is to be pressed open. Upper band to be joined at centre back. The seam joining the bottom portion is to be in line with the side bevel seam.	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform Wool, Scarlet, Pattern No. 8849B 8305-99-869-4373, and Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Scarlet, Pattern No. 8849B 8305-99-869-4373
2	136-0160 to 0174	Non Royals PWO, Green Howards, DWR, Devon & Dorset, Cheshire, WFR, APTC, Army Apprentices College Birmingham, Bristol, Gloucester, Northumbrian, Leeds, Liverpool, London, Manchester, East Midlands, Oxford, Queen's (Belfast) & Sheffield University OTC	20351A	Number 2 The band cut from one piece of cloth, is to be joined at the centre back of the cap in line with the seam of the bevel quarters. The band is to have a stitched out welt 6mm from the bottom edge formed with one row of stitching made to comply with seam type 6.05.01 of BS 3870.	Cloth, Uniform, Wool, Navy Pattern No. 8849U		Cloth, Uniform, Wool, Scarlet Pattern No. 8849B 8305-99-869-4373

TABLE 8 – CAP, SERVICE, No. 1 and No. 2 Dress Regts & Corps (except Household Brigade) and MGS Continued

Serial No	NATO	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
3	136-0021 to 0030	QDG	28358	<u>As Number 1</u>	Cloth, Wool, Navy, Pattern No. 8849U.	Cloth, Velvet, Cotton & Viscose, Blue,WR, crush resistant Pattern No. 8865B 8305-99-573-5054, and Cloth,Uniform, Wool Navy Pattern No. 8849U	Cloth, Velvet, Cotton & Viscose Blue, WR crush resistant Pattern No. 8865B 8305-99-573-5054
4	132-2652 to 2662	Scots DG	20328	<u>As Number 2</u> In addition, a cloth vandyked band of 13 points is to be superimposed and edge stitched to the headband with the points terminating at the waist seam and the welt. The vandyking is to be of uniform size and shape and measure 16mm across the bars when measured at right angles to the line of the vandyking.	Cloth, Uniform, Wool, Navy Pattern No. 8849U and Vandyked with Cloth, Uniform, Wool, Yellow, Pattern No. 8849K 8305-99-869- 4381		Cloth, Uniform, Wool, Yellow, Pattern No. 8849K 8305-99-869-4381
5	136-0036 to 0045	Royal Dragoon Guards	28359	<u>As Number 1</u>	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool Light Navy Pattern No. 8849P 8305-99-869-5466 and Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool Light Navy Pattern No. 8849P 8305-99-869-5466

TABLE 8 – CAP, SERVICE, No. 1 and No. 2 Dress Regts & Corps (except Household Brigade) and MGS Continued

Serial No	NATO Stock Nos 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
6	136-0225 to 0238	Queen's Royal Hussars & Light Dragoons QOY(D & Y Sqn), RWxY (B &D Sqn)	28360	<u>As Number 2</u>	Cloth, Uniform, Wool, Scarlet, Pattern No. 8849B 8305-99-869-4373		
7	136-0261 to 0269	QOY	28361	<u>As Number 2</u>	Cloth, Uniform, Wool, Red, Pattern No. 8849A 8305-99-869-4372		
8	136-0385 to 0399	9/12 RL	20357	<u>As Number 1</u> In addition, the waist seam, bevel quarter seams and the seam joining the top and bottom portion of the band are to be piped	Cloth, Uniform, Wool, Scarlet Pattern No. 8849B 8305-99-869-4373	Cloth, Uniform, Wool, Navy Pattern No. 8849U (and bevel quarter, waist seam and band seam piping)	
9	136-0195 to 0206	King's Royal Hussars RWxY C Sqn	28362	<u>As Number 2</u>	Cloth, Uniform, Wool, Crimson Pattern No. 8849C 8305-99-869-4374		

TABLE 8 – CAP, SERVICE, No. 1 and No. 2 Dress Regts & Corps (except Household Brigade) and MGS Continued

Serial No	NATO Stock Nos 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
10	136-0417 to 0431	Queen's Royal Lancers	20359	<u>As Number 2</u> In addition, the bevel quarter seams are to be piped	Cloth, Uniform, Wool, Scarlet, Pattern No. 8849B 8305-99-869-4373	Cloth, Uniform, Wool Navy Pattern No. 8849U (and bevel quarter piping)	
11	136-0321 to 0334	RE, MPSC, Drum Major & Drummer, 71(SC) Engr Regt, 74 (Antrim Arty) Engr Regt	20354	<u>As Number 2</u> In addition, the waist seam is to be piped	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Scarlet Pattern No. 8849B 8305-99-869-4373 (and waist seam piping)	
12	136-0176 to 0190	R SIGNALS	28363	<u>As Number 2</u> But without badge holder	Cloth, Uniform, Wool, Navy Pattern No. 8849U		
13	136-0352 to 0366	RGJ	20355A	<u>As Number 1</u> In addition, the waist seam & the seam joining the top & bottom portions of the band are to be piped. A detachable band of black braid is to be fitted	Cloth, Uniform, Wool, Rifle Green, Pattern No. 8849E 8305-99-869-4376 Additional band, Braid, Worsted, Black Pattern No. 9337A, 44mm 8305-99-973-0787	Cloth, Uniform, Wool, Dark Navy Pattern No. 8849J 8305-99-869-4380 (and waist seam and band seam piping)	

TABLE 8 – CAP, SERVICE, No. 1 and No. 2 Dress Regts & Corps (except Household Brigade) and MGS Continued

Serial No	NATO Stock Nos 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
14	136-0064 to 0078	RAMC	28365	<u>As Number 1</u>	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Crimson Pattern No. 8849C 8305-99-869- 4374, and Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Crimson Pattern No. 8849C 8305-99-869-4374
15	136-0084 to 0094	RAVC	28366	<u>As Number 1</u>	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Maroon Pattern No. 8204B 8305-99-942-7115, and Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Maroon Pattern No. 8204B 8305-99-942-7115
16	136-0096 to 0108	RADC	28367	<u>As Number 1</u>	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Guards Green, Pattern No. 8849W and Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Guards Green, Pattern No. 8849W
17	136-0288 to 0302	D (North Irish Horse) Squadron Royal Yeomanry Regiment	28364	<u>As Number 2</u>	Cloth, Uniform, Wool, Rifle Green, Pattern No. 8849E 8305-99-869-4376	Cloth, Uniform, Wool, White, Pattern No. 8849F 8305-99-869- 4377	

TABLE 8 – CAP, SERVICE, No. 1 and No. 2 Dress Regts & Corps (except Household Brigade) and MGS Continued

Serial No	NATO Stock Nos 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
18	978-9839 to 9851	RLC	27499	<u>As Number 1</u>	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Velvet, Cotton, & Viscose, Blue, WR, Crush resistant Pattern No. 8865B 8305-99-573-5054, and Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Scarlet, Pattern No. 8849B 8305-99-869-4373
19	978-9938 to 9952	QARANC	27551	The cloth band is constructed In three parts. Scarlet Stripes to be 2cm and centre Grey stripe to be 1cm. Seams to be pressed open	Cloth, Uniform, Wool, Navy Pattern No. 8849U	Cloth, Uniform, Wool, Scarlet, Pattern No. 8849B 8305-99-869-4373, and Cloth, Uniform, Wool, Grey Pattern No. 8849L 8305-99-869-4382	Cloth, Uniform, Wool, Navy Pattern No. 8849U
20	130-6451 to 6461	MGS	28043	<u>As Number 2</u>	Cloth, Uniform, Wool, Navy Pattern No. 8849U		

TABLE 9 – 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(X12)

TABLE 10 – METHOD OF TEST. Flexible polyurethane foam.

PROPERTY	REQUIREMENT	METHOD OF TEST
Apparent density kg/m ³	25 - 30	BS EN ISO 845

TABLE 11 – METHOD OF TEST. To Determine Fabric/foam Laminate Bond Strength.

The minimum bond strength of the laminated fabric is to be 1.25N/25mm when determined by the following method:

11.1 Sample preparation	<ul style="list-style-type: none"> Specimens which have been conditioned for 24 hours in the standard testing atmosphere defined in BS EN ISO 139 are to be cut 200mm x 25mm with at least two samples being cut with the 200mm dimension in the warp and weft direction respectively.
11.2 Procedure	<ul style="list-style-type: none"> The conditioned samples are to be delaminated by hand for 100mm. The tails are to be clamped in the jaws of a CRE tensile testing machine. The sample is then to be peeled apart with a jaw separation of 100mm/min for a 50mm length of sample.
11.3 Calculation and expression of results	<ul style="list-style-type: none"> The maximum value of peel bond strength is to be recorded for each sample that peels for 50mm without the foam breaking. If the foam does break during delamination this fact is to be noted and the value at break recorded. The mean value of two results for samples, which delaminate for 50mm without the foam breaking, is to be calculated in the warp and weft direction respectively

TABLE 12 – TEST FOR THE DELAMINATION OF PEAKS

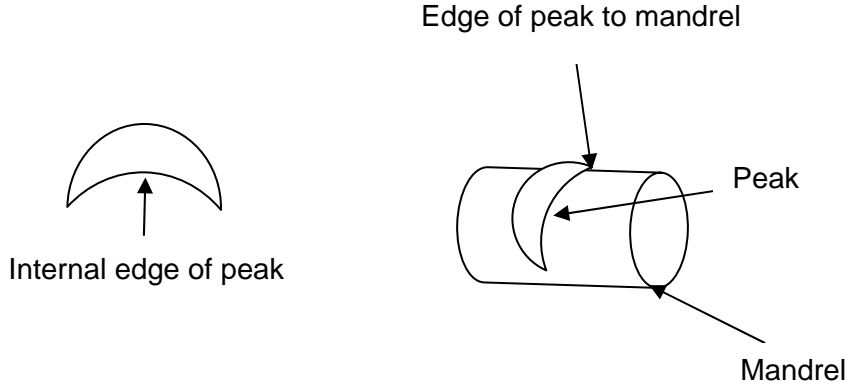
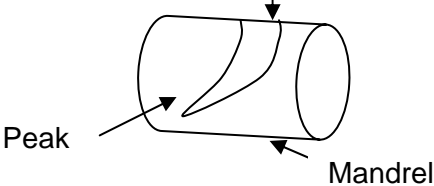
12.1 Test procedure	<ul style="list-style-type: none"> • Four cap peaks (detached from caps) are to be taken from batches of up to 500 and conditioned for 24 hours in the standard atmosphere defined in BS EN ISO 139. • Two peaks are to be placed in an environmental chamber at $70 \pm 2^\circ\text{C}$ and 95 - 100% relative humidity for 6 hours \pm 15 minutes. After removal, the peaks are to be examined for delamination of the black PVC and the (green) skiver, delamination of either peak is to render the batch rejected. Any degree of distortion is to be such that it will not affect the subsequent fitting of the peak to a cap; severe distortion of either peak is to render the batch rejected. • Two peaks are to be placed in a freezer at $-20 \pm 2^\circ\text{C}$ for $2\frac{1}{2}$ hours \pm 5 minutes. Immediately after removal, each peak is to be subjected to the following two tests using a mandrel of diameter $150 \pm 1\text{mm}$.
12.2 Edge test	<div style="text-align: center;">  </div> <ul style="list-style-type: none"> • Use the minimum of force required to bend the internal edge of the peak around the mandrel, ensuring free contact with the circumference of the mandrel. Repeat with the other side up. Examine both sides of the peak for fractures or cracks; any such damage on either peak is to render the batch rejected.

TABLE 12 – TEST FOR THE DELAMINATION OF PEAKS Continued

12.3 Flat test	<p data-bbox="799 282 1070 315">Flat edge to mandrel</p>  <p data-bbox="667 472 735 501">Peak</p> <p data-bbox="991 506 1098 535">Mandrel</p> <ul data-bbox="451 763 1430 943" style="list-style-type: none">• Use the minimum force required to bend the face of the peak around the mandrel, ensuring free contact with the circumference of the mandrel. Repeat with the other side up. Examine both sides of the peak for fractures and cracks: any such damage on either peak is to render the batch rejected.
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4. LABELLING REQUIREMENTS.

- The size number, NATO Stock Number and the contract number is to be either:
 - a. Clearly marked on a label to be sewn to the centre of the crown lining. Or
 - b. 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.
- The size number is to be 1.2cm high and the remainder of the characters 0.6cm high.

FIGURE 2

Specimen labels

