



**Technical Specification for
CAP, SERVICE No. 1 Dress Footguards
PEAK, CAP, SERVICE No. 1 Dress Footguards
CAP SERVICE No 1 Dress Honourable Artillery Company**

Defence Clothing
Integrated Project Team

PROPERTY OF :-
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PREFACE

TABLE 1 – PRODUCT LIST

Item Name	CAP, SERVICE No. 1 Dress Footguards PEAK, CAP, SERVICE No. 1 Dress Footguards CAP SERVICE No. 1 Dress Honourable Artillery Company	
Development File No.	NN/428/017	
Product Support File No.	NV/452/036	
Nato Stock Number (NSN)	Description	Pattern No. (s)
8405-99-973-1942 to 1955	Grenadier	19668B Cap
8405-99-973-1958 to 1970	Coldstream	19669B Cap
8405-99-973-1974 to 1986	Scots	19670B Cap
8405-99-973-1990 to 2002	Irish	19671B Cap
8405-99-973-2006 to 2018	Welsh	19672B Cap
8405-99-973-2030	WOI	19673B Peak
8405-99-973-2031	WOII	19674B Peak
8405-99-973-2032	Band Sergeants	19675B Peak
8405-99-973-2033	Band Corporals	19676B Peak
8405-99-973-2034	Musicians	19677B Peak
8405-99-973-2035	CQMs and Sergeants	19678B Peak
8405-99-973-2036	Corporals	19679B Peak
8405-99-973-2037	Guardsmen, Drummer & Lance Corporal	21359A Peak
8405-99-136-0370 to 0383	Honourable Artillery Company	20356B Cap

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TABLE 2 – ISSUE RECORD

Issue No	Amendments	Issue Date
10	Reformatted to DE&S template. Related specs & docs updated	12 November 2008
9	Inclusion of Cap Service No 1 Dress Honourable Artillery Company	15 February 2005
8	Clause 5.11 Front support – addition of an approved alternative method Table 3 -Removal of DEF STAN 83- 39 – Cancelled. Clause 4.5 Interlining Crown and Bevel – Cloth amended.	17 March 2004
7	Re-format specs and docs update. Photographs inserted	26 August 2003

PART 1

1. THE PRODUCT

- a. Use of the Product. A peaked cap, embellished with brass stripping or gold braid as appropriate for wear by the Footguards and Honourable Artillery Company

FIGURE 1.

Patt 19669B



Patt 19669B



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 12590	Textiles. Industrial sewing threads 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 3870 Parts 1 and 2	Stitches and seams.
BS 4560	Fabrics for linings in uniform clothing.
UK/SC/3907	Buttons anodised aluminium gold and silver.
UK/SC/4530	Ribbon textile striped Welsh guards.
UK/SC/4776	Cloth, buckram, jute.
UK/SC/5146	Braid, cord, lace, metallised polyester, gold and 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 2

3. PRODUCT DESIGN

a. Product Description. An embellished peaked cap with brass stripping or gold braid as appropriate for wear by the Footguards. An unembellished peaked cap for the Honourable Artillery Company, design as stated in TABLES 8 and 9. The size schedule provides for thirteen sizes plus a outsize measure in each range.

TABLE 4 – PRODUCT COMPONENTS

4.1 Crown tip, bevel and band. (Lower band only of Pattern No. 19668B and 19671B)	<ul style="list-style-type: none"> • Cloth, Uniform, Wool, Navy • Pattern No. 8849U to UK/SC/5516
4.2 Band, piping and Additional headband	<ul style="list-style-type: none"> • In accordance with Table 8.
4.3 Crown and bevel 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.
4.4 Crown disc	<ul style="list-style-type: none"> • Cellulose acetate sheet, colourless, 0.1mm thick. • Or, sheeting, 0.1mm to 0.3mm.
4.5 Interlining crown and bevel	<ul style="list-style-type: none"> • Cotton, Black, Plain Weave • Or an alternative approved by DC IPT.
4.6 Cord for crown piping (Pattern No. 19669B only)	<ul style="list-style-type: none"> • Twine, cotton, white, 2ktex. • Or an alternative approved by the DC IPT.
4.7 Headleather and front support pocket	<ul style="list-style-type: none"> • Leather, sheep, basil, at least 1.0mm but not more than 1.3mm thick, to UK/SC/5696. • Or an alternative approved by the DC IPT. • The term basil is defined in BS 2780.
4.8 Bow for headleather	<ul style="list-style-type: none"> • Braid, white 13mm +/- 1mm.
4.9 Band stiffener	<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.

TABLE 4 – PRODUCT COMPONENTS Continued

<p>4.10 Peak</p>	<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.
<p>4.11 Lining for peak (except two part laminate)</p>	<ul style="list-style-type: none"> • Skiver green as defined in BS 2780 or an alternative approved by the DC IPT. To comply with the requirements of Table 10.
<p>4.12 Binding for peak (Pattern No. 19673B to 19677B) and (Pattern No 20356B)</p>	<ul style="list-style-type: none"> • PVC, black, 0.6mm thick.
<p>4.13 Binding for peak (Pattern No. 19678B, 19679B and 21359A)</p>	<ul style="list-style-type: none"> • Brass stripping, deep drawing 0.5mm thick 15mm wide.
<p>4.14 Peak embellishment (Pattern No. 19673B to 19677B)</p>	<ul style="list-style-type: none"> • Braid, gold, No. 3. Pattern No. 9515A, to comply with the requirements of Specification UK/SC/5146. NSN 8315-99-130-8321.
<p>4.15 Peak embellishment (Pattern No. 19678B and 19679B)</p>	<ul style="list-style-type: none"> • Brass stripping soft, 1mm thick 3mm wide, weight 26gms per metre.

TABLE 4 – PRODUCT COMPONENTS Continued

4.16 Binding stiffener at peak	<ul style="list-style-type: none"> • Cloth, velveteen, cotton, fawn or black to comply with the colour fastness requirements for perspiration, Table 2, of UK/SC/5628.
4.17 Wire for crown	<ul style="list-style-type: none"> • Wire steel, galvanised, 15 SWG with steel or brass connecting tube all metal is to be rustproof. • Or an alternative approved by DC IPT.
4.18 Front support	<ul style="list-style-type: none"> • Sprung steel support with brass tip. • Or an alternative approved by DC IPT.
4.19 Chin strap (except Pattern No. 19670B)	<ul style="list-style-type: none"> • PVC, black, 10mm wide, by 480mm long, at least 1.0mm but not more than 1.3mm thick with buckles.
4.20 Buttons	<ul style="list-style-type: none"> • In accordance with Table 8 and to comply with the requirements of Specification UK/SC/3907.
4.21 For all purposes	<ul style="list-style-type: none"> • Thread, corespun polyester/cotton to Table 5 to BS EN ISO 12590. • Metric Ticket No. 25 (26) for peak to stiffener. • Metric Ticket No. 36 (35) for bevel, band, sewing in crown, back and front finishing lining and all hand sewing. • Metric Ticket No. 75 for all other sewing. • Or alternative approved by DC IPT.

TABLE 5 – PRODUCT CONSTRUCTION

<p>5.1 Crown</p>	<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 crown is to be securely combined to the interlining with a suitable adhesive to form a waterproof barrier 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. • The perimeter of the crown tip is to have a piped edge corded (Pattern No. 19669B only) joined in line with the back seam of the bevel quarters. • The perimeter of the crown tip of (Pattern No 20356B only) is to have a piped edge joined in line with the back seam of the bevel quarters.
<p>5.2 Bevel</p>	<ul style="list-style-type: none"> • The bevel, combined to the interlining as specified in para 5.1 above, is to be quartered with the seams opened and pressed flat.
<p>5.3 Band</p>	<ul style="list-style-type: none"> • The band is to be joined at the centre back of the cap in line with the seam of the bevel. • (Pattern No. 19669B, 19670B and 19672B). The band is to have a stitched out welt, 0.6cm from the bottom edge, formed using seam type 6.05.01 of BS 3870.

TABLE 5 – PRODUCT CONSTRUCTION Continued

<p>5.3 Band, Continued</p>	<ul style="list-style-type: none"> • (Pattern No. 19668B and 19671B). The band is to be constructed in two parts. The upper band 4.5cm deep and the lower band 0.6cm deep. • (Pattern No 20356B) The band is to be constructed in four parts top portion to measure 4.5cm deep bottom portion 0.6mm deep. • The two scarlet stripes are to be 1.6cm deep. The centre blue stripe is to be 1.3cm deep. • All the band joining seams should be joined in line with the centre back bevel seam. • All seams to be pressed open.
<p>5.4 Additional headband (Pattern No. 19669B, 19670B and 19672B)</p>	<ul style="list-style-type: none"> • The additional headband is to be fitted with the join at the centre back, with a 1.3cm seam, the corners turned in and stitched to avoid the possibility of fraying. • When headband is joined the diced/striped band is to repeat continuously around the cap.
<p>5.5 Band stiffener</p>	<ul style="list-style-type: none"> • The stiffener is to be cut sufficiently long to allow a 4cm overlap where it is joined at the centre back slightly offset to reduce thickness. • The stiffener is to be stitched through the outer material immediately below the stitched out welt, and baisted through the outer material at the band/bevel seam. • The bottom edge of the stiffener, where the peak is sewn on, is to be bound with fawn or black velveteen.
<p>5.6 Lining</p>	<ul style="list-style-type: none"> • The crown lining is to be sewn in with the crown tip piping seam and be securely tacked at the bottom edge of the stiffener. • 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.

TABLE 5 – PRODUCT CONSTRUCTION Continued

<p>5.7 Peak</p>	<ul style="list-style-type: none"> • (Pattern No. 19673B to 19677B). The outer edge is to be bound with black PVC 0.6cm deep when finished. The binding is to be formed using seam type 3.01.01 of BS 3870. • (Pattern No. 19678B, 19679B and 21359A). The outer edge is to be bound with brass, finished 0.7cm on the topside and 0.55cm on the underside. • The completed peak is to comply with the requirements of Table 12. • 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 depth of the peak at the centre front is to be 5.2cm prior to being sewn into the cap. • The inner edge of the peak is to be securely sewn to the outer edge of the stiffener with approximately four stitches per 2cm. • When fitted, the peak is to be correctly balanced and be central to the front seam of the bevel quarters • The black surface of the peak is to be free from cracks and all other defects. • Embellishment of the peak is to be in accordance with Table 9.
<p>5.8 Headleather</p>	<ul style="list-style-type: none"> • Each cap is to have a brachered headleather, the ends of which are to be overlapped 1cm at the centre back of the cap and tacked together at the top edge through a white braid bow. • 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.
<p>5.9 Chinstrap and buttons (except Pattern No. 19670B)</p>	<ul style="list-style-type: none"> • A button, in accordance with Table 8, is to be sewn on each side of the cap, to retain the chinstrap, positioned 1cm from the bottom edge of the band and in line with the side seam of the bevel.
<p>5.10 Crown wire</p>	<ul style="list-style-type: none"> • A cap wire with a connecting tube is to be fitted on the inside of the cap above the piping of the crown.

TABLE 5 – PRODUCT CONSTRUCTION Continued

<p>5.11 Front support</p>	<ul style="list-style-type: none"> • The front metal support is to be fitted with a good quality leather tab riveted and turned over at the top of the support. The tab is to be securely sewn on the inside of the piping of the crown to lie immediately behind the front bevel seam. • Or, an approved alternative method. • 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.
<p>5.12 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, and be correctly tensioned. • The piping is to be formed seam type 1.12.01. • The brachering on the headleather is to be stitch type 304 with at least six stitches per 2cm. • The felling on the headleather is to have at least six stitches per 2cm
<p>5.13 General</p>	<ul style="list-style-type: none"> • Sewing threads may be treated with a stain free lubricant • All seams are to be free from pucker. • The cap is to be free from all ends of sewing thread, be blocked and pressed and delivered in a clean condition.

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS AND CAP SIZE

Size and internal circumference	50	51	52	53	54	55	56	57	58	59	60	61	62	Outsize Measure
NSN 8405-99-973-														
Grenadier	1942	1943	1944	1945	1946	1947	1948	1949	1950	1951	1952	1953	1954	1955
Coldstream	1958	1959	1960	1961	1962	1963	1964	1965	1966	1967	1968	1969	1970	-
Scots	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	-
Irish	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	-
Welsh	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	
NSN 8405-99-136-														
Honourable Artillery Company	0370	0371	0372	0373	0374	0375	0376	0377	0378	0379	0380	0381	0382	0383

All measurements are in centimetres except where otherwise stated.

TABLE 7 – MEASUREMENTS AND TOLERANCES

Size and internal circumference		50	51	52	53	54	55	56	57	58	59	60	61	62	Special Measure	Tols (mm)	
																+	-
Crown	Length	25.5	25.8	26.1	26.4	26.7	27	27.3	27.6	27.9	28.2	28.5	28.8	29.1		2	2
	Width	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
Crown		1.2 Oval															
Bevel Depth		6														2	2
Band Depth																	
Pattern. No. 19669B, 19670B & 19672B		4.5														2	2
Pattern. No. 19668B & 19671B 20356B		5.1														2	2
Peak	Depth	4														1	1
	Length	19.5														3	3
Head Leather Depth		4														2	2
Stiffener Depth		6														2	2
Front Support	Length	7.6														2	2
	Width	1.2														2	2
Chin strap	Width	1														-	-
	Length	48 fully extended														10	10

- All measurements are in centimetres except where otherwise stated.

TABLE 8 – MATERIALS FOR CAP, SERVICE, NO. 1 DRESS FOOTGUARDS

Regiment	Pattern No.	Band	Crown piping	Additional band	Buttons
Grenadier Guards	19668B	Cloth, uniform, wool, Scarlet, Pattern No. MAT0014Z, to UK/SC/5516	Cloth, uniform, wool, Scarlet, Pattern No. MAT0014Z, to UK/SC/5516	NIL	Buttons, 22 Ligne Pattern No. 20948 NSN 8455-99-973-0090 to UK/SC/3907
Coldstream Guards	19669B	Cloth, uniform, wool, Navy Pattern No. 8849U to UK/SC/5516	Tape piping, polyethylene White Pattern No. 9362A (16mm) NSN 8315-99-135-4918	Webbing, polyethylene, White Pattern No. 9361A (38mm) NSN 8305-99-135-4834	Buttons, 22 Ligne Pattern No. 21008 NSN 8455-99-973-0093 to UK/SC/3907
Scots Guards	19670B	Cloth, uniform, wool, Navy Pattern No. 8849U to UK/SC/5516	Cloth, uniform, wool, Scarlet, Pattern No. MAT0014Z, to UK/SC/5516 NSN 8305-99-869-5465	Ribbon, diced, Scots Guards, Pattern No. 9330A NSN 8455-99-445-7815	NIL
Irish Guards	19671B	Cloth, uniform, wool, Guards Green, Pattern No. 8849W to UK/SC/5516	Cloth, uniform, wool, Guards Green, Pattern No. 8849W to UK/SC/5516	NIL	Buttons, 22 Ligne Pattern No. 20892 NSN 8455-99-973-0102 to UK/SC/3907
Welsh Guards	19672B	Cloth, uniform, wool, Navy Pattern No. 8849U to UK/SC/5516	Cloth, uniform, wool, Navy Pattern No. 8849U to UK/SC/5516	Ribbon, textile, striped, black/green Pattern No. 9456A NSN 8315-99-138-6014 to UK/SC/4530	Buttons, 24 Ligne NSN 8455-99-973-0108 Pattern No. 20891 to UK/SC/3907
Honourable Artillery Company	20356B	Cloth uniform wool Scarlet Pattern No MAT0014Z to UK/SC/5516 Cloth uniform wool Light Navy Pattern No 8849P to UK/SC/5516 NSN 8305-99-869-5466	Cloth uniform wool Scarlet Pattern No MAT0014Z to UK/SC/5516	NIL	Buttons, 22 Ligne Pattern No 21588 NSN 8455-99-973-0441 to UK/SC/3907

TABLE 9 – SCHEDULE OF NATO STOCK NUMBERS AND EMBELLISHMENTS

NATO Stock No. 8405-99-973-	Pattern Number	Rank	Embellishment
2035	19678B	CQMS and Sgts	<ul style="list-style-type: none"> • 2 Strips of brass 3mm apart with similar distance between first strip and binding.
2036	19679B	Corporals	<ul style="list-style-type: none"> • 1 strip of brass with 3mm between strip and binding.
2037	21359A	Guardsmen	<ul style="list-style-type: none"> • Brass binding on edge of the peak.
For the following peaks the first row of the gold braid is to be Adjacent to the PVC edge binding.			
2030	19673B	WOI	<ul style="list-style-type: none"> • 5 rows of gold braid with out intervening space. • The first row of gold braid is to be adjacent to the PVC edge binding.
2031	19674B	WOII	<ul style="list-style-type: none"> • 4 rows of gold braids with out intervening space. • The first row of gold braid is to be adjacent to the PVC edge binding.
2032	19675B	Band Sgts	<ul style="list-style-type: none"> • 3 rows of gold braids with 3mm intervening space. • The first row of gold braid is to be adjacent to the PVC edge binding.
2033	19676B	Band corporals	<ul style="list-style-type: none"> • 2 rows of gold braid with 3mm intervening space. • The first row of gold braid is to be adjacent to the PVC edge binding.
2034	19677B	Musicians	<ul style="list-style-type: none"> • 1 row of gold braid. • The first row of gold braid is to be adjacent to the PVC edge binding.

TABLE 10 – TEST REQUIREMENTS

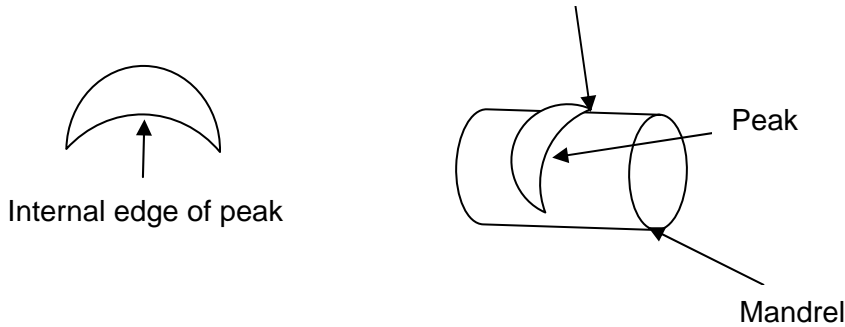
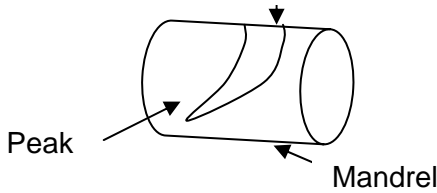
The peak lining is to conform to the requirements of the following Table:

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

TABLE 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:

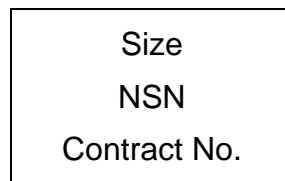
11.1 Sample preparation	<ul style="list-style-type: none"> Specimens which have been conditioned for 24 hours in the standard testing atmosphere defined in BS EN ISO 139 are to be cut 200mm x 25mm with at least two samples being cut with the 200mm dimension in the warp and weft direction respectively.
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

<p>12.1 Test procedure</p>	<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 2½ hours \pm 5 minutes. Immediately after removal, each peak is to be subjected to the following two tests using a mandrel of diameter $150 \pm 1\text{mm}$.
<p>12.2 Edge test</p>	<div style="text-align: center;"> <p>Edge of peak to mandrel</p>  </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.
<p>12.3 Flat test</p>	<div style="text-align: center;"> <p>Flat edge to mandrel</p>  </div> <ul 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.

4. **LABELLING REQUIREMENTS.** Information and format is to be as follows.
- 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 label.

FIGURE 2 – SPECIMEN LABELS



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