



Technical Specification for RIBBON, CAP, Named, Class II, RN

Defence Clothing

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PREFACETABLE 1 – PRODUCT LIST

Item Name	RIBBON, CAP, Named, Class II, RN	
Development File No	D/DCTA/P3152 (ST) & D/DCIPT/RDG/NR/9/04	
Product Support File No.		
NATO Stock Number	Pattern Number	Description
8455-99-571-2297	V21422A	'named'

Any colour shown in this document is for representation and must not be used for colour matching.

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
04	Comment added reference the length of the ribbon.	09 January 2008
03	Re-formatted and reviewed. NSN's 8455-99- 571-2275 571-2280 571-2294 122-2215 all deleted. Alterations in length have been made and use of metallised polyester has been accepted.	11 November 2005
02	Spec UK/SC/4393 Iss 2 (Amendment 1). Issue 2 reformatted without technical change and re-issued as Issue 2. Amendment 1 is included at page 6 (April 2002)	10 July 1998

PART 1

1. THE PRODUCT

a. Use of the Product.

Royal Navy cap tallies, Class II. To be worn with Class II Caps.

FIGURE 1. RN Cap Tallies, Class II (example only)



TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105	Textiles. Test for colour fastness.
B02	Colour fastness to artificial light; xenon arc fading lamp
D01	Colour fastness to dry cleaning
X12	Colour fastness to rubbing
BS EN ISO 139	Textiles. Standard atmospheres for conditioning and testing.
BS EN 1049 Part 02	Textiles. Woven Fabrics. Construction. Method of Analysis. Determination of Number of Threads per Unit Length.
BS EN 1773	Textiles – fabrics – determination of width and length
BS 2471: 2005	Methods of test for textiles – woven fabrics – determination of mass per unit length and mass per unit area

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.

Royal Navy cap tallies, Class II. Black continuous filament yarn with lettering of HMS and appropriate name of the ship.

TABLE 4 – PRODUCT COMPONENTS

4.1 Ribbon	<ul style="list-style-type: none"> • The ribbon is to be made from black continuous filament matt polyester 2 fold yarn for warp and weft. • Conform to the physical requirements of Table 1. • The shade is to be uniform and the yarn is to match the properties of the ribbon yarn in the Standard Pattern.
4.2 Lettering	<ul style="list-style-type: none"> • The yarn used for lettering and other markings is to be made from gold metallised polyester film wrapped around a continuous filament yarn. • The core yarns are to be dyed to an appropriate colour so that the effect of any grinning of the core yarn through the wrapping is minimised. • The wrapping material is to be a non-tarnishing metallised polyester film, which is to be wrapped around the core yarn to give a metallic appearance. Yarn with any kinks or excessive core yarn grinning is unacceptable. • The complete yarn is to meet relevant colour fastness requirements specified in table 7.

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Ribbon	<ul style="list-style-type: none"> The background is to be plain woven ribbon to the dimensions specified in Table 6, with firm, straight selvages, which may be reinforced without compromising the appearance.
5.2 Lettering	<ul style="list-style-type: none"> The weave of the letter is to be 12 shaft sateen. The edges of the lettering are to be firm, even and neat in appearance to match the Standard Pattern. The binding points of gold yarn situated outside the letter are to be concealed. The letters are to be evenly spaced. Where two sloping sided letters are adjacent in the name, for example, A and W, a composite card should be used to avoid the appearance of more distant spacing between the two letters. Full stops are required after each of the letters preceding the name of the ship/establishment as necessary. A full stop after the name is not required. Any other name or lettering not conforming to the general pattern will be given at the time the names are supplied to the contractor. The dimensions and positions are to comply with the requirements of Table 6. Where the length of the letter is such that the positioning cannot be carried out as specified, the number of picks per cm are to be increased to a point where this can be done. The length of the individual letters will be correspondingly reduced, and the mass of the base fabric will be increased as a result.
5.3 General	<ul style="list-style-type: none"> The finished Tally is to be uniformly woven, free of defects and cut symmetrically to comply with an angle of 45% and to match the standard pattern. The mass per unit length is not to be less than the mass per unit length shown in Table 6. No plus tolerance is specified, but the right is reserved to reject ribbon so heavy that its character compared with the Standard Pattern is so altered e.g. in texture, that it is unsuitable for the intended end uses.
5.4 Dyeing and Finishing	<ul style="list-style-type: none"> The shade and finish are to match the Standard Pattern. The materials are to conform to the colour fastness requirements defined in Table 7.

TABLE 6 – MEASUREMENTS

METHOD OF TEST									
Using a calibrated rule under conditions defined in BS EN ISO 139									
RIBBON				LETTERING					
BS EN 1773	BS 2471		BS EN 1049 Part 02		From left edge in the middle of the ribbon to first letter	From last letter to right edge in the middle of the ribbon	Height	Space between lettering	Length of individual letter (All widths of lettering is dependant on shape of letter)
Width	Mass per unit length		Thread count per cm						
± 1mm	g/m		± 5%		cm	cm	mm	± 1mm	mm
Min	Min	Max	Ends	Picks			Max		Max
31.5	3.8	6	65	36	61.5	40	15	10	16

* Over all length of the cap ribbon will vary depending on the length of the name.

TABLE 7 – COLOUR FASTNESS REQUIREMENTS

Method of Test BS EN ISO 105			
B02	X12		D01
Light (xenon)	Rubbing		Dry Cleaning
6	Dry	Wet	Colour change
	4-5	4-5	5

LABELLING REQUIREMENTS. Information and format is to be as follows:

- NATO Stock Number, contract number and year of manufacture.
- Clearly printed on a pressure sensitive self-adhesive label and attached to the outer packaging.

TABLE 8 – SPECIMEN LABELS

ITEM NAME NSN Contract No.

FIGURE 2. Example Identification and marking label