



**Technical Specification for
SHOULDER MARK
Woven Insignia RN**

Defence Clothing

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PREFACE

TABLE 1 – PRODUCT LIST

Item Name	SHOULDER MARK Woven Insignia RN	
Development File No	N/A	
Product Support File No.	N/A	
NATO Stock Number	Description	Pattern number
8455-99-132-6490	Foul anchor enclosed in a single circle and a laurel wreath with crown above	22003A
8455-99-869-1252	Crossed foul anchors with crown above	27776A

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

IPR STATEMENT

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
5	Reformatted. Deletion of 8455-99-869-1251	13 August 2009
4	Specification and NSNs re-instated Amendment of Pattern No.s on NSNs8455-99-132-6490 and 8455-99-869-1252	04 January 2006
3		02 November 2001
2		20 September 1983
1	New to service	

PART 1

1. THE PRODUCT

a. Use of the Product.

Slip on shoulder marks for RN for wear on heavy wool jersey and shirt sleeve order.

TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN 12590	Textiles. Industrial sewing threads made wholly or partly from synthetic fibres.
BS EN ISO 105 Part B02 Part C06 PartX12	Textiles. Tests for colour fastness Colour fastness to artificial light: Xenon arc fading lamp test Colour fastness to domestic and commercial laundering Colour fastness to rubbing
BS 3870 Parts 1 and 2	Stitches and Seams. Classification and Terminology of Stitch Type. Classification and Terminology of Seam Types.
UK/SC/6576	Cloth, twill, Polyester/ Cotton No1.

PATTERNS.

- a. Master Patterns. The DC holds a Master Pattern for this product. Potential contractors may view the pattern on site by arrangement with the DC Commercial Department.
- b. Standard Patterns. A Standard Pattern may be obtained from the DC 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 DESIGNa. Product Description.

Closed slip-on sleeve with a mounted woven rank insignia. To be issued in pairs.

TABLE 4 – PRODUCT COMPONENTS

4.1 Base ribbon	<ul style="list-style-type: none"> • Warp R10/2 Tex polyester, black. Weft 60/2 cotton count mercerised cotton, black. Ends per cm (excluding selvages) 3min. • Picks per cm 25 min. Weave 1/3 broken twill. • The colourfastness of the ribbon is to meet the requirements of the Table 6.
4.2 Insignia	<ul style="list-style-type: none"> • 2 x R22/2 Tex nylon, insignia picks per cm, 25 min. • The shades of the yarns are to match those of the appropriate standard pattern and meet the colour fastness requirements of the Appendix
4.3 Sleeve	<ul style="list-style-type: none"> • Cloth, twill, polyester and cotton, No.1 black, Pattern No.8171C, UK/SC/6576, NATO Stock No.8305-99-139-6619 or an approved alternative
4.4 For all purposes sewing thread	<ul style="list-style-type: none"> • Thread polyester and cotton, corespun to Table 5 of BS EN 12590. • Shade black to Metric Ticket No 75 or an approved • alternative

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Ribbon	<ul style="list-style-type: none"> • The insignia are to be as detailed in the schedule. • The insignia are to be woven by Jacquard mechanisms or other suitable method on a base ribbons 9cm wide with a margin of not less than 2.2cm below each motif.
5.2 Sleeve	<ul style="list-style-type: none"> • To be cut one piece 13cm wide, 10cm long. • The top and bottom edges are to be turned in 0.5cm using seam type 6.02.01 of BS 3870. The stitching is to be 0.1cm from the edge. • The ribbon is to be mounted on the topside of the sleeve with the bottom edge of the insignia 2.2cm from the bottom of the sleeve. The ribbon is to be edge stitched to the sleeve. • The sleeve is to be closed using seam type 1.01.01 of BS 3870, with the seam pressed open, positioned to form the centre of the underside. Finished measurements 5.5cm wide, 9cm long.
5.3 Stitching	<ul style="list-style-type: none"> • Machine stitching is to be stitch type 301 of BS 3870 with at least eight but not more than ten stitches per 2cm.
5.4 General	<ul style="list-style-type: none"> • Sewing threads may be treated with a stain free lubricant. • Seams are to be free from pucker. • The shoulder marks are to be free from all ends of sewing threads, be pressed and delivered in a clean condition.

TABLE 6 COLOUR FASTNESS REQUIREMENTS

Agency	Rating		Method of Test BS EN ISO 105
	Colour change	Staining	
Light (Xenon lamp)	7	-	BO2
Washing	5	-	CO6
Rubbing Wet	-	3	X12
Dry	-	4	

4. **LABELLING REQUIREMENTS.**

- Each item is to be individually wrapped (pairs or each) and identified by a clearly printed pressure sensitive self adhesive label firmly adhered to the outside of the polythene envelope/Bag.

TABLE 7 – SPECIMEN LABELS

ITEM NAME
NSN
Contract No.