



**Technical Specification for
BUSBY, CEREMONIAL,
KING'S TROOP RHA, Soldiers
ROYAL ENGINEERS BAND and ROYAL SIGNALS BAND
THE LIGHT CAVALRY BAND, Officers & Other Ranks
ROYAL ARTILLERY BAND**

Defence Clothing (DC)

PROPERTY OF:-
MINISTRY OF DEFENCE



PREFACETABLE 1 – PRODUCT LIST

Item Name	BUSBY, CEREMONIAL, KING'S TROOP RHA, Soldiers ROYAL ENGINEERS BAND & ROYAL SIGNALS BAND THE LIGHT CAVALRY BAND, Other Ranks THE LIGHT CAVALRY BAND, Officers ROYAL ARTILLERY BAND	
Development File No	NN/SCD/P1828 & D/DCIPT/RDG/NR/01/22	
NATO Stock Numbers	Description	Pattern Number
8405-99-130-9763 to 9769 8405-99-130-9773	KING'S TROOP RHA, Soldiers Outsize	23501A
8405-99-212-1573	ROYAL ENGINEERS BAND and ROYAL SIGNALS BAND	29170
8405-99-553-3625 to 3632	THE LIGHT CAVALRY BAND Other Ranks	D02196
8405-99-553-3633 to 3640	THE LIGHT CAVALRY BAND, Officers	D02197
8405-99-684-4569	Royal Artillery Band	D02194

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

IPR STATEMENT

This specification contains information which is proprietary to the Secretary of State for Defence and shall remain the property of the Secretary of State. It is issued in strict confidence and must not be seen by any unauthorised person. The specification is supplied solely for the purpose of Information/Tender/Contract and shall not be copied or reproduced or used for any other purpose whatsoever without the express prior written permission of the Secretary of State as represented by the Intellectual property rights group.

Technical documents in this specification refer to the edition current at the date of tender or contract unless otherwise stated.

CROWN COPYRIGHT RESERVED

TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
09	Addition of Royal Artillery Band Busby, NSN 8405-99-684-4569, D02194	01 February 2012
08	Addition of The Light Cavalry Band Other Ranks, D02196 & Officers, D02197.	28 July 2011
07	Reformatted to DC template Removal of BS EN ISO 11640, BS EN ISO 11641 and BS EN 20105 to be replaced by UK/SC/5696	19 May 2011
06	Reformatted to DE&S template. Updated related specs & docs.	30 October 2008
05	Colour fastness Requirements reviewed, Table 9.	21 March 2007
04	Pattern 23501 updated to 23501A	26 April 2006
03	Addition of the synthetic fur composition and amendment to the bag holder strap. Amendment to colour fastness test methods.	20 September 2005
02	Reformatted, specs and docs updated. Royal Engineers and Royal Signals busby included. Change in size range	15 September 2004
01	New Issue	11 August 1998

PART 1

1. THE PRODUCT

a. Use of the Product.

Kings Troop RHA Busby made from knitted polyester base/acrylic pile material outer and dowel reinforced canvas foundation. For wear by soldiers of the King's Troop RHA as part of ceremonial dress. The size schedule provides for seven sizes and outsize.

Royal Engineers and Royal Signals Busby made from Coney skin dyed black outer and dowel reinforced canvas foundation. For wear by the Bands of ROYAL ENGINEERS and ROYAL SIGNALS as part of ceremonial dress, outsize only.

Light Cavalry Band Busby OR's and Officers made from synthetic material outer and dowel reinforced canvas foundation. For wear as part of ceremonial dress. The size schedule provides for seven sizes and outsize for both OR's and Officers.

Royal Artillery Busby made from knitted polyester base/acrylic pile material outer and dowel reinforced canvas foundation. For wear by the Royal Artillery band as part of ceremonial dress. The size schedule provides for outsize only.

Figure 1.

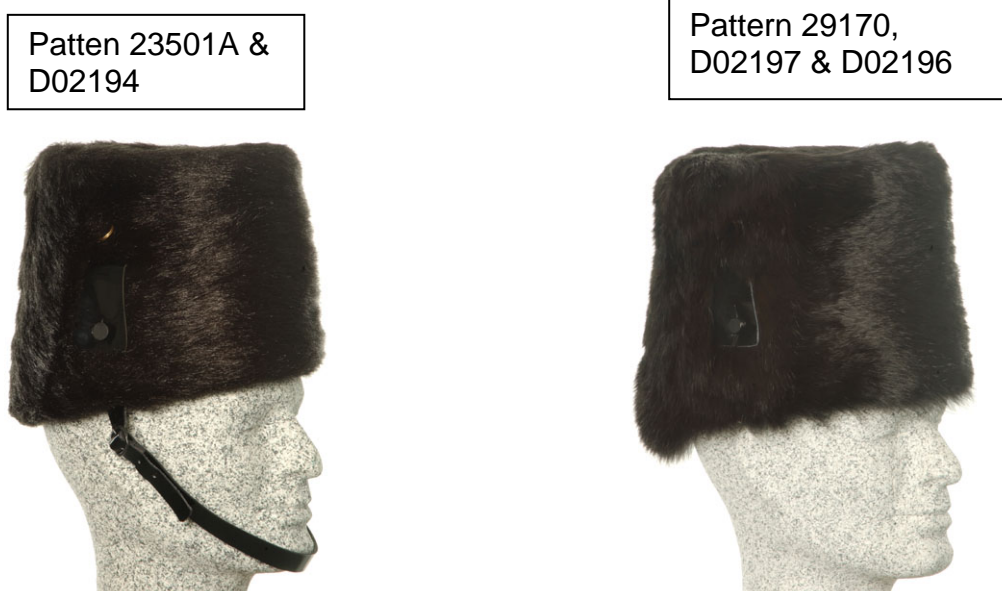


TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 Part B02 Part E01	Textile test for colour fastness. Colour fastness to Light. Colour fastness to Water.
BS EN 12590	Textiles. Industrial Sewing Threads made wholly or partly from Synthetic Fibres.
BS 3870 Part 1 and 2	Stitches and seams.
BS 4560	Fabrics for lining in uniform clothing.
BS 5742	Textiles labelling requiring to be washed and/ or dry cleaned
UK/SC/4831	BAG, BUSBY, RHA & RA LINE, BUSBY, Short, RHA LINE, BODY, Long, RHA BAG, BUSBY, Royal Engineers Band BAG, BUSBY, Royal Signals Band
UK/SC/5696	Leather, sheep, head leathers.

2. PATTERNS.

- a. Master Patterns. 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 2

3. PRODUCT DESIGN

Product Description. The design and shape of the Busbies is to be strictly in accordance with that of the Standard Pattern.

Royal Horse Artillery - The Busby is to be supplied with plume holder and chinstrap.

Royal Engineer & Royal Signals band – The Busby is to be supplied with plume holder but without chin chain.

Royal Artillery band - The Busby is to be supplied with plume holder but without chin chain.

Busby bags are not supplied with the above items.

TABLE 4 – PRODUCT COMPONENTS

4.1 Outer Fabric for Pattern No 23501A & D02194	<ul style="list-style-type: none"> • Knitted pile fabric. 50% modacrylic & 50% acrylic pile (approx. 83% of gross weight) and 100% polyester backing (approx. 17% of gross weight). Pile height 13mm, all physical appearances to match those of the Standard Pattern. • To meet the colour fastness requirements in Table 9.
4.2 Outer Fabric for Pattern No 29170	<ul style="list-style-type: none"> • Coney Skin dyed black, all physical appearances to match those of the Standard Pattern.
4.3 Outer fabric for Pattern No's D02196 & D02197	<ul style="list-style-type: none"> • The fabric including backing is to be from a man made fiber, the pile height required, to match the appearance (colour and texture) of the standard pattern. • To meet the colour fastness requirements in table 9.
4.4 Sides (foundation)	<ul style="list-style-type: none"> • Cloth, viscose, hemp, hair 213g/m² adhesively bonded to cloth hemp 191g/m².
4.5 Sides (stiffener)	<ul style="list-style-type: none"> • Dowling, deal, semi circular, 10mm dia.
4.6 Waterproof crown	<ul style="list-style-type: none"> • Natural cowhide, lacquered, 2.7mm thickness as on the Standard Pattern.
4.7 Sides stabiliser	<ul style="list-style-type: none"> • Wire spring steel 1.8mm.
4.8 Stabiliser casing	<ul style="list-style-type: none"> • Tape, nylon coated PVC black, 25mm.
4.9 Crown edging former	<ul style="list-style-type: none"> • Tubing, polyethylene, 5mm internal dia.
4.10 Headband	<ul style="list-style-type: none"> • Natural cowhide, vegetable tanned, 3mm thickness.
4.11 Headleather	<ul style="list-style-type: none"> • Leather, black grained sheep, dyed through, 1.5mm thickness, to meet the requirements of UK/SC/5696

TABLE 4 – PRODUCT COMPONENTS Continued

4.12 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.
4.13 Lining drawcord	<ul style="list-style-type: none"> • Tape, woven, 15mm, black.
4.14 Bag holder tab fastening for pattern No's 23501A, 29170 & D02194	<ul style="list-style-type: none"> • Button, nylon, black, 15 ligne as on the Standard Pattern or an alternative approved by DC.
4.15 Bag holder tab fastening for pattern No's D02196 & D02197	<ul style="list-style-type: none"> • Gold stud with nut on the reverse, as on standard pattern.
4.16 Bag holder tab	<ul style="list-style-type: none"> • Cowhide, black, patent, 1.2mm thickness.
4.17 Hooks for Pattern No's 29170, D02196, D02197 & D02194	<ul style="list-style-type: none"> • Brass 5.5cm long folded at 3.5cm
4.18 Chinstrap for 23501A	<ul style="list-style-type: none"> • Cowhide, black, patent, 1.5mm thickness, 15mm wide.
4.19 Chinstrap adjuster	<ul style="list-style-type: none"> • Buckle, brass, black.
4.20 Plume holder for 29170	<ul style="list-style-type: none"> • Fitting, brass, as on the Standard Pattern or an alternative approved by DC.
4.21 Plume holder for D02194	<ul style="list-style-type: none"> • Fitting, black finish, as on the Standard Pattern or an alternative approved by DC.
4.22 Line retention ring	<ul style="list-style-type: none"> • Ring, split, brass, 1.3cm diameter or an alternative approved by DC.
4.23 Identification label	<ul style="list-style-type: none"> • Fabric marking and attachment to comply with the requirements of Specification BS 5742.
4.23 Sewing threads for all purposes	<ul style="list-style-type: none"> • Thread, polyester and cotton, continuous filament polyester core, cotton sheath to BS EN 12590 or approved alternatives may be used: <ul style="list-style-type: none"> a. Metric Ticket No.25, black. For Fastening crown, headband stabiliser headleather, plume holder and straps b. Metric Ticket No.75, black for all other purposes

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Sides foundation	<ul style="list-style-type: none"> • Two plies of bonded hair cloth/hemp are to be sewn with vertical rows of stitching, 2.5cm apart, penetrating all layers. Closing seam is to be at the centre front. • Stiffener dowls are to be housed in each division; terminating adjacent to top edge of headleather and 2.5cm below top edge of sides. • Wire stabiliser, encased in nylon tape, is to be securely tacked to sides; positioned 6cm above and parallel to bottom edge of Busby; tacks are to be spaced at 5cm intervals.
5.2 Headband	<ul style="list-style-type: none"> • The shaped band, 2.5cm deep at front and 3.5cm at back, is to be attached to the sides by two rows of stitching, adjacent to the top edge.
5.3 Headleather and stay	<ul style="list-style-type: none"> • Leather, 6cm deep (effective) is to be joined using seam type 4.03.03 of BS 3870 and sewn to stay using seam type 2.01.01 of BS 3870. • The stay is to be sewn to sides, with the free edge uppermost and positioned 4cm above the bottom edge of the headband at the centre front and 5cm above the band at centre back. • 5 stitches per 2.5cm.
5.4 Head lining	<ul style="list-style-type: none"> • Lining, 8cm deep, is to be attached to headleather using seam type 2.02.03 of BS 3870. • A channel is to be formed in the free edge of the lining using seam type 6.03.01 of BS 3870, inturn 1.5cm deep. • A drawcord is to be housed in the channel.
5.5 Hooks on Pattern No 29170 & D02194	<ul style="list-style-type: none"> • Two hooks attached securely one either side to be positioned midway between the centre back and centre front at lower edge.
5.6 Plume holder on Pattern No 29170	<ul style="list-style-type: none"> • Positioned immediately in front of side hook, left side in wear. Securely sewn to foundation, bottom of plume holder in line with the bottom of brow.

TABLE 5 – PRODUCT COMPONENTS continued

5.7 Plume holder on Pattern No's 23501A, D02196 & D02197	<ul style="list-style-type: none"> • Positioned at top centre front aligned with top edge of side and securely sewn to the foundation.
5.8 Plume holder on Pattern No D02194	<ul style="list-style-type: none"> • Positioned at centre front 3 cm down from top edge and securely sewn to the foundation.
5.9 Waterproof crown	<ul style="list-style-type: none"> • Shaped as on the Standard Pattern with rim edge 2.5cm deep. The rim is to be stapled to the sides of the foundation.
5.10 Chinstrap for Pattern No.23501A only	<ul style="list-style-type: none"> • A strap, 36cm long, is to be securely tacked to the outside of the headleather; positioned centrally on the left side (in wear). The buckle is to be securely sewn to the free end. • A strap, 9cm long, is to be securely tacked to the outside of the headband, positioned centrally on the right side (in wear). Four eyelets are to be provided, positioned centrally and spaced at 1.5cm intervals, the first eyelet 4cm from the free end.
5.11 Outer and crown former	<ul style="list-style-type: none"> • The outer fabric is to be cut and assembled so that the lie of the pile is from right to left (in wear). • The top edge of the outer and tubular crown former are to be securely tacked to the crown rim/sides, with outer enclosed between rim and former. The outer fabric is to wrap over former and cover the sides closely and evenly. • The bottom edge of the outer is to be attached to headband, using stitch type 211 of BS 3870 with six stitches per 2cm.

TABLE 5 – PRODUCT COMPONENTS continued

5.12 Bag holder strap	<ul style="list-style-type: none"> • A shaped strap, 3.2cm wide at the top edge, 4.5cm wide at the bottom edge, 6cm long, is to be securely tacked at the top edge to right side (in wear) positioned 8cm below the top edge of side; stitching is to penetrate all layers. <p><u>Pattern No's 29170, 23501A & D02194</u></p> <ul style="list-style-type: none"> • A buttonhole is to be cut in the strap 6mm above the bottom edge, centrally positioned. A button is to be attached to the side of the busby, 12.5cm below the crown, stitching to penetrate all layers, so as to accommodate the buttonhole strap. <p><u>Pattern No's D02196 & D02197</u></p> <ul style="list-style-type: none"> • A buttonhole is to be cut in the strap 6mm above the bottom edge, centrally positioned. A stud is to be attached to the side of the busby, 12.5cm below the crown, screwed to penetrate all layers, so as to accommodate the buttonhole strap.
5.12 Line retention ring	<ul style="list-style-type: none"> • A split ring is to be attached to the right side (in wear); positioned 4cm below top edge and aligned centrally with bag holder strap, stitching is to penetrate all layers.

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS

KING'S TROOP RHA, Soldiers	
NATO Stock Numbers 8405-99-130-	Size Numbers
9763	54
9764	55
9765	56
9766	57
9767	58
9768	59
9769	60
9773	Outsize
ROYAL ENGINEERS BAND and ROYAL SIGNALS BAND	
8405-99-212-1573	Outsize

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS CONT'D

Light cavalry Band Other Ranks	
NATO Stock Numbers 8405-99-553-	Size Numbers
3625	54
3626	55
3627	56
3628	57
3629	58
3630	59
3631	60
3632	Outsize
Light cavalry Band Officers	
NATO Stock Numbers 8405-99-553-	Size Numbers
3633	54
3634	55
3635	56
3636	57
3637	58
3638	59
3639	60
3640	Outsize
ROYAL ARTILLERY BAND	
8405-99-684-4569	Outsize

TABLE 7 – MEASUREMENTS AND TOLERANCES FOR PATTERN NO'S 23501A, 291710 & D02194

All measurements are in centimetres except where otherwise stated.

									Tolerances (mm)	
Size		54	55	56	57	58	59	60	+	-
Internal Circumference	Headband	54	55	56	57	58	59	60		
	Crown	51.5	52.5	53.5	54.5	55.5	56.5	57.5		
Depth of Sides	Front	16.5							2	2
	Back	21							2	2
	Side	18.5							2	2

TABLE 7 – MEASUREMENTS AND TOLERANCES CONT'D FOR PATTERN NO D02196

All measurements are in centimetres except where otherwise stated.

									Tolerances (mm)	
Size		54	55	56	57	58	59	60	+	-
Internal Circumference	Headband	54	55	56	57	58	59	60		
	Crown	51.5	52.5	53.5	54.5	55.5	56.5	57.5		
Depth of Sides	Front	15							2	2
	Back	19							2	2
	Side	16							2	2

TABLE 7 – MEASUREMENTS AND TOLERANCES CONT'D FOR PATTERN NO D02197

All measurements are in centimetres except where otherwise stated.

									Tolerances (mm)	
Size		54	55	56	57	58	59	60	+	-
Internal Circumference	Headband	54	55	56	57	58	59	60		
	Crown	51.5	52.5	53.5	54.5	55.5	56.5	57.5		
Depth of Sides	Front	18							2	2
	Back	20							2	2
	Side	19							2	2

4. LABELLING REQUIREMENTS.

- The size number, NATO Stock Number, and the contract number are to be clearly marked on the inside of the crown, arranged as in Figure 2.

TABLE 8 – SPECIMEN LABELS

Size
NATO Stock No.
Contract No.

Figure 2. Example Identification and marking label

TABLE 9 –TEST REQUIREMENTS

The outer fabric is to conform to the requirements of the following table:

METHOD OF TEST BS EN ISO 105			
B02		E01	
Light (Xenon)		Water	
Colour Change	Staining	Colour Change	Staining
4 – 5	N/A	4 – 5	4