

**Technical Specification for
SHOULDER MARK
RN Warrant Officers**



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PREFACETABLE 1 – PRODUCT LIST

Item Name	SHOULDER MARK RN Warrant Officers
Development File No.	NN/SCD/P1864
Product Support File No.	NV/82/186
NATO Stock Number	Pattern Number
8455-99-130-9318	23457A

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TABLE 2 – ISSUE RECORD

Issue No.	Comments	Issue Date
2	Reformatted and re-instated after being made obsolete.	21 June 2006
1	Specification reformatted without technical change and re-issued as Issue 1. (June 2002)	24 February 1988

PART 11. THE PRODUCT

- a. Use of the Product. An embroidered sleeve made of polyester and cellulosic fibre twill for wear by RN Warrant Officers, to be fitted over a garment shoulder strap.

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BSEN 12590	Industrial sewing threads made wholly or partly from synthetic fibres.
BS 3870	Stitches and seams.
Part 1	Classification and terminology of stitch types.
Part 2	Classification and terminology of seam types.
DEF STAN 83-65	Cloths, polyester and cotton blends.
UK/SC/4687	Embroidered and other distinguishing items and the components used therein.

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. An embroidered badge in the form of a sleeve to be fitted over a garment shoulder strap.

TABLE 4 – PRODUCT COMPONENTS

4.1 Main Material	<ul style="list-style-type: none"> • Cloth, twill, polyester and cotton No. 1 black, FS, Pattern No. 8171C, to DEF STAN 83-65, NATO Stock No. 8305-99-139-6619.
4.2 Lining (fusible)	<ul style="list-style-type: none"> • Cloth, cotton, polyurethane coated 245g/m² as on the Standard Pattern, fused in accordance with the manufacturer's instructions. Specimens of the interlining and the laminate are to comply with the requirements of paragraph 5.1.
4.3 Insignia embroidery	<ul style="list-style-type: none"> • Thread, cotton, mercerised, gold, red, white, blue, black, 50/2 cord, to meet the requirements of specification UK/SC/4687.
4.4 Sewing thread for assembly	<ul style="list-style-type: none"> • Thread, polyester, continuous filament, to BS EN 12590, black, Metric Ticket No. 80. • Or an approved alternative, is to be used.

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Performance of laminates in fusible interlinings	<ul style="list-style-type: none"> • The main contractor is to ensure that the interlining is laminated strictly in accordance with the interlining manufacturer’s recommendations, these recommendations are to be specific to the specified outer cloth for the related garment. • The fusible interlining recommended must allow the garment to be washed, ironed, dry cleaned and tumble dried as recommended on the care label, throughout the garment life without any visible signs of delamination, puckering, loss of appearance and handle or excessive shrinkage. • Fusing is to be continuous so that the laminate is free from ‘blisters’ and there is no ‘strike through’ of the adhesive onto the face of the laminate or ‘strike back’ through the interlining. • The recommendations of the interlining manufacturer regarding fusing must be strictly observed and where those recommendations call for careful control of temperature, time and mechanical pressure, suitable controlled presses must be used. • The main contractor is to provide evidence to the DC IPT, of recommendations made by the interlining suppliers and the contractor is to demonstrate compliance with these recommendations throughout the contract.
5.2 Insignia	<ul style="list-style-type: none"> • The Royal Coat of Arms is to be embroidered on the sleeve positioned centrally and 1cm below top end.
5.3 Main construction	<ul style="list-style-type: none"> • The ends of the sleeve, are to be sewn using seam type 6.02.01 of BS EN 12590; inturns 1cm deep, the stitching 0.1cm from the edge. • The sleeve closing is to be seam type 1.01.01 of BS EN 12590, with the seam pressed open, positioned to form the centre of the underside.

TABLE 5 – PRODUCT CONSTRUCTION continued

5.4 Stitching to BS EN 12590	<ul style="list-style-type: none"> Machine stitching is to be type 301 with at least eight but not more than ten stitches per 2cm and be correctly tensioned.
5.5 General	<ul style="list-style-type: none"> Sewing threads may be treated with stain free lubricant. All seams are to be free from pucker. The shoulder marks are to be cleaned of all ends of sewing thread, well pressed free from gloss and delivered in a clean condition.
5.6 Measurements	<ul style="list-style-type: none"> The Shoulder Mark is to conform to the following dimensions: <div style="text-align: center;"> Width (effective) – 6cm Length – 9cm. </div>

4. LABELLING REQUIREMENTS

- Each item is to be identified by a clearly printed pressure sensitive self adhesive label firmly adhered to the underside of the item or to the outside of the polythene envelope.
- Information and format to be as follows: NATO Stock number, contract number and year of manufacture.

TABLE 6 – SPECIMEN LABELS

NSN Contract No. Year

Fig 1 Example Identification and Marking label