



**Technical Specification for
BERETS
Wool, Knitted, Various**

Defence Clothing

Integrated Project Team

PROPERTY OF :-
DEFENCE CLOTHING
INTEGRATED PROJECT TEAM
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PREFACETABLE 1 – PRODUCT LIST

Item Name	BERETS, Wool, Knitted, Various		
Development File No	D/DCTA/P1967 & P3374 (ST)		
Product Support File No.	D/DCTA/363/018 (QPS)		
NATO Stock No(s)	CUSTOMER	COLOUR	PATTERN No.
8405-99-976-0171 to 0187 (8405-99-843-3775, Outsize NSN)	Light Infantry	Rifle Green	13865F
8405-99-976-0192 to 0205 (8405-99-843-3776, Outsize NSN)	Royal Tank Regiments	Black	4135F
8405-99-976-0213 to 0225 (8405-99-843-3777, Outsize NSN)	Airborne Forces	Maroon	12027F
8405-99-122-3164 to 3175 (8405-99-843-3778, Outsize NSN)	Royal Hussars	Brown	19967C
8405-99-132-2248 to 2264 (8405-99-843-3779, Outsize NSN)	Guards Division	Khaki	20126B
8405-99-974-2401 to 2415 (8405-99-843-3780, Outsize NSN)	Army Air Corps	Light Blue	17952C
8405-99-132-3741 to 3754 (8405-99-843-3781, Outsize NSN)	RMP	Scarlet	21123A
8405-99-125-6721 to 6735 (8405-99-843-3782, Outsize NSN)	QARANC	Grey	15801D
8405-99-977-1570 to 1584 (8405-99-843-3783, Outsize NSN)	Scots DG	Grey	21910B
8405-99-974-3336 to 3348 (8405-99-843-3784, Outsize NSN)	Special Air Service	Beige	17430C
8405-99-132-4518 to 4530 (8405-99-132-4532, Outsize NSN)	Intelligence Corps	Cypress Green	21292B
8405-99-127-8122 to 8137	RAF	Blue-Grey	35/R/639D

TABLE 1 – PRODUCT LIST CONTINUED

NATO Stock No(s)	CUSTOMER	COLOUR	PATTERN No.
8405-99-976-0231 to 0247 (8405-99-843-3785, Outsize NSN)	All regiments (except Scottish & Irish regiments & above regiments, services & corps)	Dark Blue	13864E
8405-99-132-1281 to 1295 (8405-99-843-3786, Outsize NSN)	RA & Royal Marines	Green	24134A
8405-99-978-8447 to 8464	Adjutant Generals Corps	Green	24573A
8405-99-978-9078 to 9095	United Nations	Light Blue	24867A
8405-99-571-3506 to 3520 (8405-99-843-3788, Outsize NSN)	Royal Marines	Dark Blue	20509B
8405-99-288-7182 to 7199	The Duke of Lancaster's Regiment (King's, Lancashire and Border)	Khaki with Scarlet Badge flash	D00724A
8405-99-288-7200 to 7217	The Yorkshire Regiment	Khaki with Green Badge flash	D00725
8405-99-870-6812 to 6829	The Special Reconnaissance Regiment	Emerald Grey	D00727
8405-99-869-0210 to 0227	Royal Fleet Auxiliary	Pantone Blue	27635A
8405-99-471-4130 to 4147	The Mercian Regiment	Khaki with Green Badge flash	D01284
8405-99-836-5616 to 5633	Royal Navy	Dark Blue	D01520
8405-99-410-4153 to 4170	The Royal Welsh	Khaki with Green Badge flash	D01513

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
14	Addition of new items 8405-99-836-5617 to 5633 (Royal Navy with eyelets) 8405-99-410-4153 to 4170 (The Royal Welsh) Deletion of: 8405-99-464-3237 to 3520 & 843-3787 (Royal Navy without eyelets)	23 April 2008
13	Updating of Pattern numbers. Terminology “Special Measure” changed throughout the spec to read “Outsize”.	23 January 2008
12	Addition of new item 8405-99-471-4131 to 4147 (The Mercian Regiment)	05 July 2007
11	Updated NSNs for the QARANC Berets (excluding the Special Measure NSN)	10 May 2007
10	Re-instated NSN's for RFA blue beret NSNs 8405-99-869-0210 to 0227. Update of dry cleaning labelling.	12 April 2007
09	Addition of Special Measure NSNs for Pattern No. 13865E, 4135E, 12027E, 19967B, 20126B, 17952C, 21123A, 15801C, 21910A, 17430C, 13864E, 24134, 20508B, 2059B.	07 February 2007
08	Change of colour for SRR berets from emerald green to emerald grey & alteration of eyelet measurements. Addition of Badge support for Pattern number D00724A	02 August 2006

TABLE 2 – ISSUE RECORD CONTINUED

07	Addition of NSN's for pattern numbers D00724 and D00725. Addition of new item 8405-99-870-6812 to 6829 (Special Reconnaissance Regiment)	09 February 2006
06	Swap of NSN and Colour title on D00724 and D00725.	20 December 2005
05	Addition of pattern numbers D00724 (Lancashire Regiment beret) & D00725 (Yorkshire Regiment beret). Deletion of Range 8405-99-869-0210 to 0227. Deletion of sizes in various ranges.	02 December 2005
04	New format, change related specs and docs, insert amendments into text RM beret changed to the same size as the Army berets	08 May 2003
03	Issue B reformatted without technical change and re-issued as Issue 3. Amendment 1 included	23 June 1999

PART 1

1. THE PRODUCT

- a. Use of the Product. An item of service headdress worn by the Army, Royal Navy, Royal Marines, Royal Air Force and United Nations Forces.

FIGURE 1. Beret Design, example shown Special Air Service, Pattern number 17430C



Front and left and side as worn



Back and right hand side as worn

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 Part B02 Part D01 Part E01 Part E04	Textiles. Tests for colour fastness Colour fastness to artificial light: Xenon arc fading lamp test Colour fastness to dry cleaning Colour fastness to water Colour fastness to perspiration
BS EN ISO 139	Textiles – standard atmospheres for conditioning and testing
BS EN 1049 Part 2	Textiles. Woven fabrics. Construction. Methods of analysis Determination of number of threads per unit length
BS EN 1773	Textiles. Fabrics. Determination of width and length.
BS EN 12127	Textiles. Fabrics. Determination of mass per unit area using small samples
BS EN 12590	Textiles. Industrial Sewing Threads made wholly or partly from Synthetic Fibres.
BS 2471:2005	Methods of test for textiles – woven fabrics - determination of mass per unit length and mass per unit area
BS 3102: 1959	Specification for brass eyelets and washers for general purpose
BS 3412:1992	General purpose polyethylene materials for moulding and extrusion
BS 3870 Parts 1 and 2	Stitches and seams
BS 4560:1990	Specification for fabrics for linings in uniform clothing
BS 5790 Part 2	Coated fabrics for upholstery Specification for PVC coated woven fabric
UK/SC/5516	Cloths, Wool, Uniform Dress
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. A Circular shaped knitted beret with leather binding and adjustment tape provided in various shades as indicated in tables 1 and 10.

TABLE 4 – PRODUCT COMPONENTS

4.1 Body	<ul style="list-style-type: none"> • To be knitted from an all wool yarn, which may include a proportion of selected reclaimed wool in the blend provided the quality of the finished beret is not impaired, and be dyed to match the shade of the relevant Standard Pattern • The knitting link line and centre darn are not to be evident on the finished beret • To be milled and lightly sheared to give the same finish as the relevant Standard Pattern • To comply with the requirements of Table 8.
4.2 Lining (not to be sulphur dyed)	<ul style="list-style-type: none"> • Cloth, plain weave, cotton Silesia, FS, SF, black, Pattern No.8715B to BS 4560 Ref 1:3, • or Cloth, plain weave, viscose, black, to comply with the requirements of Table 10
4.3 Additional crown lining (as on the relevant Standard Pattern)	<ul style="list-style-type: none"> • Polyethylene film, 0.13mm thick, • or PVC sheeting, 0.13mm thick,
4.4 Headband binding	<ul style="list-style-type: none"> • Leather, sheep, black to UK/SC/5696 • or an alternative approved by the DC IPT
4.5 Headband adjustment tape	<ul style="list-style-type: none"> • Tape, black, woven, cotton or viscose, 13mm wide, to comply with the requirements of Table 9.

TABLE 4 – PRODUCT COMPONENTS CONTINUED

4.6 Badge pocket for Pattern Nos 13865F, 19967C, 20126B, 17952C, 21123A, 21910B, 17430C, 21292B, 13864E, 24573A, 24867A, D00724A, D00725, D00727 and D01284.	<ul style="list-style-type: none"> • PVC coated, black, grained surface, to BS 5790, Part 2
4.7 Badge support for Pattern Nos.24134A, 20509B, D00724A and 27635A.	<ul style="list-style-type: none"> • High density polyethylene, 1.00mm to 1.03mm thick density (BS 3412, Appendix B) 960 to 967kg/m³ • or an alternative approved by the DC IPT
4.8 Badge support for Pattern Nos. 15801D, 35/R/639D and D01520.	<ul style="list-style-type: none"> • Vulcanised rubber fibreboard approx. 1.5mm thick • or an alternative approved by the DC IPT
4.9 Badge eyelets and washers for Pattern Nos.15801D, 35/R/639D and D01520.	<ul style="list-style-type: none"> • Black, oval, to BS 3102, as on the Standard Pattern
4.10 Eyelets and washers for Pattern No. D00727	<ul style="list-style-type: none"> • Black, circular, to BS 3102, as on the Standard Pattern
4.11 Badge flash and pocket for Pattern Nos.15801D and 20509B	<ul style="list-style-type: none"> • Cloth, uniform, wool, scarlet, Pattern No.8849B, UK/SC/5516, NATO Stock No. 8305-99-869-4373.
4.12 Badge flash for pattern No. D00724A	<ul style="list-style-type: none"> • Cloth, uniform, wool, scarlet, Pattern No.8849B, UK/SC/5516, NATO Stock No. 8305-99-869-4373
4.13 Badge flash for pattern No. D00725	<ul style="list-style-type: none"> • Cloth, uniform, wool, green, Pattern No.8849D, UK/SC/5516, NATO Stock No. 8305-99-869-4375
4.14 Badge flash for pattern No. D01284	<ul style="list-style-type: none"> • Cloth, uniform, wool, Lincoln green, Pattern No.8849V, UK/SC/5516, NATO Stock No. 8305-99-471-3332
4.15 Badge flash for pattern No. D01513	<ul style="list-style-type: none"> • Cloth, uniform, wool, Guards' green, Pattern No.8849W, UK/SC/5516, NATO Stock No. 8305-99-471-3333
4.16 Threads for all purposes	<ul style="list-style-type: none"> • Corespun to BS EN 12590, Metric Ticket No.75 may be treated with stain free lubricants

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Crown	<ul style="list-style-type: none"> • Circular in shape, with diameter measurements specified in Schedule, Table 7. • The link line and centre darn are not to be evident on the finished beret.
5.2 Bevel	<ul style="list-style-type: none"> • To comply with the relevant measurements specified in Schedule, Table 7.
5.3 Lining and additional crown lining	<ul style="list-style-type: none"> • The lining of the crown tip is to be cut in one piece. In addition, a 12cm square of polyethylene film or PVC sheeting is to be securely sewn centrally onto the crown lining to cover the identification/care label. • Lining of the bevel, cut two piece, to be joined at centre front and back, and seamed to the crown tip lining.
5.4 Leather binding and adjustment tape	<ul style="list-style-type: none"> • Binding is to be at least 1cm deep when finished, attached as on the Standard Pattern, to ensure that the inner edge of the head leather does not come into contact with the head. • The attachment of the Leather binding is not to distort the beret opening shape, which is to be circular. • Adjustment tape is to be enclosed within the binding channel. The ends of the tape are to protrude 10cm from each end of the channel. The tape is to be finished in a bow as on the Standard Pattern.
5.5 Badge pocket for Pattern Nos.13865F, 19967C, 20126B, 17952C, 21123A, 21910B, 17430C, 21292B, 13864E, 24573A, 24867A and D00725	<ul style="list-style-type: none"> • Leather cloth, two ply, is to be fitted inside each beret on the left side (as worn). • The top layer, 3.5cm long and 2cm wide, is to be sewn to the bottom layer, 5cm long and 2cm wide, with two rows of stitching 1cm apart to form a pocket. • The pocket is to be securely sewn in a vertical position through the lining and body. The front edge of the pocket is to be 4cm from the centre front of the beret and the bottom edge adjacent to the inner edge of the leather binding.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

<p>5.6 Badge eyelets and support for Pattern Nos.35/R/639D and D01520</p>	<ul style="list-style-type: none"> • A support, similar in shape to that on the Standard Pattern, is to be fitted between the lining and body on the left side (as worn). • Two eyelets with washers, are to be inserted in a vertical position through the body, stiffener and lining. The eyelets are to be 2.8cm apart with the front eyelet 4cm from the centre front of the beret. Both eyelets are to be 3.5cm for pattern No 35/R/639D and 4cm for pattern No D01520 above the bottom edge of the binding, to the centre of the eyelet hole.
<p>5.7 Eyelets and ventilation holes for pattern No. D00727</p>	<ul style="list-style-type: none"> • Two eyelets with washers, are to be inserted through the body and lining. The eyelets are to be 3cm apart with the eyelets positioned mid-way between the centre front and centre back. Both eyelets are to be 3cm above the bottom edge of the binding, to the centre of the eyelet hole.
<p>5.8 Badge flash, pocket and support Pattern No.15801D</p>	<ul style="list-style-type: none"> • The badge flash is to be cut identical in shape and size to that on the Standard Pattern. An oval eyelet is to be fitted in the centre of the flash, 1cm below the point of the flash. • The flash is to be positioned with the front edge 2.5cm from the centre front, on the left side of the beret (as worn), with the bottom edge level with the edge of the leather binding. Two rows of stitching, 1cm apart, are to be sewn from immediately below the eyelet to the bottom edge to form the badge pocket. • Stitching on the flash is to be through the body of the beret only. • A support, similar in shape to the badge flash is to be fitted between the lining and the body, secured to the lining as on the Standard Pattern.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

5.9 Badge support for Pattern Nos. 24134A, 20509B and 27635A	<ul style="list-style-type: none"> The support, cut identical in shape and size to that on the Standard Pattern, is to be inserted and securely edge stitched to the bevel lining, positioned with the centre 4.5cm to the left of the centre front of the beret (as worn).
5.10 Badge flash for Pattern No.20509B	<ul style="list-style-type: none"> The badge flash is to be 5.5cm in height, and 6.5cm in width, shaped as on the Standard Pattern, positioned over the location of the stiffener with the straight edge adjacent to the edge of the leather binding.
5.11 Badge flash, pocket and support Pattern No. D00724A	<ul style="list-style-type: none"> The badge flash is to be 4.5cm square and is to be attached diagonally as on the standard pattern. The flash is to be positioned on the left side of the beret (as worn). Stitching on the flash is to be through the body of the beret only. Leather cloth, two ply, is to be fitted inside each beret on the left side (as worn). The top layer, 3.5cm long and 2cm wide, is to be sewn to the bottom layer, 5cm long and 2cm wide, with two rows of stitching 1cm apart to form a pocket. The pocket is to be securely sewn in a vertical position through the lining. The front edge of the pocket is to be 4cm from the centre front of the beret and the bottom edge adjacent to the inner edge of the leather binding. A support, similar in shape to that on the Standard Pattern, is to be fitted between the lining and body on the left side (as worn), as standard pattern.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

<p>5.12 Badge flash and pocket for pattern number D00725</p>	<ul style="list-style-type: none"> • The badge flash is to be 5.5cm high and 5cm wide and is to be attached as on the standard pattern. • The flash is to be positioned on the left side of the beret (as worn). • Stitching on the flash is to be through the body of the beret only. • Leather cloth, two ply, is to be fitted inside each beret on the left side (as worn). • The top layer, 3.5cm long and 2cm wide, is to be sewn to the bottom layer, 5cm long and 2cm wide, with two rows of stitching 1cm apart to form a pocket. • The pocket is to be securely sewn in a vertical position through the lining. The front edge of the pocket is to be 4cm from the centre front of the beret and the bottom edge adjacent to the inner edge of the leather binding.
<p>5.13 Badge flash and pocket for pattern number D01284</p>	<ul style="list-style-type: none"> • The badge flash is to be 6cm high and 5cm wide and is to be attached as on the standard pattern. • The flash is to be positioned on the left side of the beret (as worn). • Stitching on the flash is to be through the body of the beret only. • Leather cloth, two ply, is to be fitted inside each beret on the left side (as worn). • The top layer, 3.5cm long and 2cm wide, is to be sewn to the bottom layer, 5cm long and 2cm wide, with two rows of stitching 1cm apart to form a pocket. • The pocket is to be securely sewn in a vertical position through the lining. The front edge of the pocket is to be 4cm from the centre front of the beret and the bottom edge adjacent to the inner edge of the leather binding.

5.14 Badge flash for pattern number D01513	<ul style="list-style-type: none">• The badge flash is to be 5cm high and 5cm wide and is to be attached as on the standard pattern.• The flash is to be positioned on the left side of the beret (as worn).• Stitching on the flash is to be through the body of the beret only.
5.14 Seams and stitching	<ul style="list-style-type: none">• All seams are to be free from pucker.• Stitch type 301 of BS 3870, with at least eight but not more than ten stitches per 2cm.
5.15 General	<ul style="list-style-type: none">• The beret is to be free of all ends of sewing threads, be blocked and pressed and delivered in a clean condition.

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS AND ACTUAL SIZE OF BERET

Size No and internal circumference of headband	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	Outsize	
NATO STOCK NUMBERS																			
8405-99-976-	Rifle Green	0171	0172	0173	0174	0175	0176	0177	0178	0179	0180	0181	0182	0183	0184	0185	0186	0187	8405-99-843-3775
8405-99-976-	Black		0192	0193	0194	0195	0196	0197	0198	0199	0200	0201	0202	0203	0204	0205			8405-99-843-3776
8405-99-976-	Maroon			0213	0214	0215	0216	0217	0218	0219	0220	0221	0222	0223	0224	0225			8405-99-843-3777
8405-99-122-	Brown				3164	3165	3166	3167	3168	3169	3170	3171	3172	3173	3174	3175			8405-99-843-3778
8405-99-132-	Khaki	2248	2249	2250	2251	2252	2253	2254	2255	2256	2257	2258	2259	2260	2261	2262	2263	2264	8405-99-843-3779
8405-99-974-	Light Blue	2401	2402	2403	2404	2405	2406	2407	2408	2409	2410	2411	2412	2413	2414	2415			8405-99-843-3780
8405-99-132-	Scarlet			3741	3742	3743	3744	3745	3746	3747	3748	3749	3750	3751	3752	3753	3754	3755	8405-99-843-3781
8405-99-125-	Grey			6721	6722	6723	6724	6725	6726	6727	6728	6729	6730	6731	6732	6733	6734	6735	8405-99-843-3782
8405-99-977-	Grey	1570	1571	1572	1573	1574	1575	1576	1577	1578	1579	1580	1581	1582	1583	1584			8405-99-843-3783
8405-99-974-	Beige			3336	3337	3338	3339	3340	3341	3342	3343	3344	3345	3346	3347	3348			8405-99-843-3784
8405-99-132-	Cypress Green				4518	4519	4520	4521	4522	4523	4524	4525	4526	4527	4528	4529	4530		4532
8405-99-127-	Blue Grey	8122	8123	8124	8125	8126	8127	8128	8129	8130	8131	8132	8133	8134	8135	8136			8137

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS AND ACTUAL SIZE OF BERET

Size No and internal circumference of headband		48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	Outsize
NATO STOCK NUMBERS																			
8405-99-976-	Dark Blue	0231	0232	0233	0234	0235	0236	0237	0238	0239	0240	0241	0242	0243	0244	0245	0246	0247	8405-99-843-3785
8405-99-132-	Green	1281	1282	1283	1284	1285	1286	1287	1288	1289	1290	1291	1292	1293	1294	1295			8405-99-843-3786
8405-99-978-	Green	8447	8448	8449	8450	8451	8452	8453	8454	8455	8456	8457	8458	8459	8460	8461	8462	8463	8464
8405-99-978-	UN Blue	9078	9079	9080	9081	9082	9083	9084	9085	9086	9087	9088	9089	9090	9091	9092	9093	9094	9095
8405-99-571-	Dark Blue RM	3506	3507	3508	3509	3510	3511	3512	3513	3514	3515	3516	3517	3518	3519	3520			8405-99-843-3788
8405-99-288-	Khaki with scarlet flash	7182	7183	7184	7185	7186	7187	7188	7189	7190	7191	7192	7193	7194	7195	7196	7197	7198	7199
8405-99-288-	Khaki with green flash	7200	7201	7202	7203	7204	7205	7206	7207	7208	7209	7210	7211	7212	7213	7214	7215	7216	7217
8405-99-870-	Emerald Grey	6812	6813	6814	6815	6816	6817	6818	6819	6820	6821	6822	6823	6824	6825	6826	6827	6828	6829
8405-99-869-	Pantone Blue	0210	0211	0212	0213	0214	0215	0216	0217	0218	0219	0220	0221	0222	0223	0224	0225	0226	0227
8405-99-471-	Khaki with Lincoln green flash	4130	4131	4132	4133	4134	4135	4136	4137	4138	4139	4140	4141	4142	4143	4144	4145	4146	4147
8405-99-836-	Dark Blue	5616	5617	5618	5619	5620	5621	5622	5623	5624	5625	5626	5627	5628	5629	5630	5631	5632	5633
8405-99-410-	Khaki with Guards green flash	4153	4154	4155	4156	4157	4158	4159	4160	4161	4162	4163	4164	4165	4166	4167	4168	4169	4170

TABLE 7 – SCHEDULE OF MEASUREMENTS AND TOLERANCES (All measurements are in centimetres except where stated)

																		Tolerances		
																		+	-	
																		mm	mm	
Size No and internal circumference of headband	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	Outsize	2	2
Crown Diameter	24						25						26						5	5
Depth of bevel including binding	6cm																		2	2

TABLE 8 – REQUIREMENTS FOR THE FINISHED BODY

METHOD OF TEST									
PHYSICAL PROPERTIES		COLOUR FASTNESS - Minimum Ratings							
Table 9 of this specification	BS EN 12127	BS EN ISO 105							
Relaxation shrinkage	Mass per unit area	Part B02 Light	Part EO4 Perspiration			Part D01		Part E01	
%	g/m ²					Dry Cleaning		Water	
Max	± 40	Colour change	Colour change	Staining cotton & wool	Colour change	Staining cotton & wool	Colour change	Staining cotton & wool	
5 in either direction	610				5	4	4	4	4

TABLE 9 – REQUIREMENTS FOR HEADBAND ADJUSTMENT TAPE

METHOD OF TEST			
	BS 2471	BS EN 1773	BS EN 1049 Part 2
	Mass per unit length	Width	Threads per width
	g/m	mm	-
	Min	± 1	Min
Viscose	3.5	13	30
Cotton	3.0	13	45

TABLE 10 – REQUIREMENTS FOR LINING CLOTH, PLAIN WEAVE, BLACK

METHOD OF TEST			
BS EN 12127	BS EN 1773	BS EN 1049 Part 2	
Mass per unit area	Width	Thread count	
g/m ²	cm	-	
Min	Min	Min	
80	140	Warp	Weft
		27	23

TABLE 11 – METHOD OF TEST TO DETERMINE RELAXATION SHRINKAGE

Preparation	<ul style="list-style-type: none"> • Cut around the circumference of the crown to create a flat specimen from the finished body • Condition for 24 hours to BS EN 20139 • Mark on the specimen two pairs of datum lines, 20cm apart, marked at right angles.
Procedure	<ul style="list-style-type: none"> • Weigh the specimen in the standard atmosphere (BS EN 20139) • Immerse specimen for two hours in water maintained at $20 \pm 2^{\circ}\text{C}$ • Dry flat on a rack • After conditioning to constant mass in the standard atmosphere, measure the distance between each pair of datum lines.
Expression of results	<ul style="list-style-type: none"> • The linear shrinkage is to be calculated as a percentage for each direction.

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



- Size number, NATO Stock Number, contract number, dry clean  only and beret shaping instructions.
- Position: Clearly marked on a label sewn to the centre of the crown lining.
 - OR
- Clearly printed on a pressure sensitive self-adhesive label adhered to the centre of the crown lining.
- The identification label is to be covered by the additional crown lining.

TABLE 12 – SPECIMEN LABEL

<p><u>Specimen label</u></p> <div style="border: 1px solid black; padding: 10px; margin: 10px auto; width: 80%;"> <p style="text-align: center;">56 NATO Stock No: Contract No:</p> <div style="display: flex; align-items: center;">  <p>professional dry cleaning in tetrachloroethene and solvents listed for the symbol F</p> </div> <p style="text-align: center;">normal process</p> </div> <p style="text-align: center;"><u>BERET SHAPING</u></p> <ol style="list-style-type: none"> 1. Immerse the beret alternately in hand hot then cold water until thoroughly soaked, taking care not to wet the leather band 2. Then place the beret on the head and mould to the desired shape 3. Then leave the beret flat to dry naturally
