



**Technical Specification for
CAP, SERVICE, WOMAN'S
No. 1 and No. 2 Dress, Regts and Corps,
MOD Guard Service and WO's**

Defence Clothing
Integrated Project Team

PROPERTY OF :-
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PREFACETABLE 1 – PRODUCT LIST

Item Name	CAP, SERVICE, WOMAN'S No. 1 and No. 2 Dress, Regts and Corps, MOD Guard Service and WO's	
Development File No	D/DCT/P2940/ & P3225 (RT)	
Product Support File No.	D/DCT/452/05 (QAA)	
Regt / Corp	NATO Stock No. 8410-99-	Pattern No.
RA, RAOC, REME, AGC	978-8197 to 8208	24515
APTC, Waterloo band of the King's Div	978-8209 to 8220	24519
R Signals	978-8221 to 8232	24520
RAVC	978-8257 to 8268	24523
RMP	978-8269 to 8280	24524
RAMC	978-8281 to 8292	24525
RADC	978-8293 to 8304	24526
QARANC	978-8305 to 8316	24528
R Engineers	978-9984 to 9995	27567
MOD Guard Service	869-3630 to 3641	28373
RLC	869-5648 to 5659	28703

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
7	Reformatted to DE&S template. Updated specs & docs.	12 November 2008
6	Reformatted Specs and Docs updated Changes to main materials	04 August 2003
5	Specification updated by development replacing Issue 4, 16 February 2001	30 July 2001

PART 1

1. THE PRODUCT

- a. Use of the Product. A peaked cap for wear with No.1 or No.2 Dress worn by women of various Regiments and Corps, MOD Guard Service and WO's. The schedule provides for eleven sizes and outsize measure.

FIGURE 1. Cap, Service, Woman's, item 8410-99-978-8197, Pattern Number 24515 shown.



Front and left hand side as worn.



Back and right hand side as worn

TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 Part X12	Textiles. Tests for colour fastness Colour Fastness to Rubbing
BS EN ISO 845	Cellular plastics and rubbers - Determination of apparent (bulk) density.
BS EN 12590	Textiles. Industrial sewing threads made wholly or partly from synthetic fibres
BS EN ISO 139	Textile standard atmospheres for conditioning and testing.
BS 2780	Glossary of leather terms
BS 3412	Methods of specifying general purpose polyethylene materials for moulding and extrusion
BS 3870 Parts 1 and 2	Stitches and seams
BS 4560	Specification for fabrics for linings in uniform clothing
UK/SC/4776	Cloth, buckram, jute
UK/SC/5126	Badges, button, pins, plates and titles made from GM brass and nickel silver
UK/SC/5516	Cloth, Wool Uniforms Dress
UK/SC/5628	Cloth, velvet, cotton and silk, WR
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. Peaked cap in colour and style as in Table 8 Cap details per Regiment or Corp.

TABLE 4 – PRODUCT COMPONENTS

<p>4.1 Crown, bevel, band and piping</p> <ul style="list-style-type: none"> • Cloth, Wool, Plain Weave, Melton • 395 – 420 g/m² • Blown finish • Shade and finish to match Pattern No. 8849 specified • Colourfastness & steam shrinkage requirements to meet those in UK/SC/5516 • Pattern No. 8865B to UK/SC/5628 	<ul style="list-style-type: none"> • Details as specified in Table 8.to conform to UK/SC/5516 Shades as specified below <table border="1" data-bbox="692 633 1449 1066"> <thead> <tr> <th>Pattern No.</th> <th>Colour</th> <th>NATO Stock No.</th> </tr> </thead> <tbody> <tr> <td>8849B</td> <td>Scarlet</td> <td>8305-99-869-4373</td> </tr> <tr> <td>8849C</td> <td>Crimson</td> <td>8305-99-869-4374</td> </tr> <tr> <td>8204B</td> <td>Maroon</td> <td>8305-99-942-7115</td> </tr> <tr> <td>8849W</td> <td>Guards Green</td> <td></td> </tr> <tr> <td>8849U</td> <td>Navy</td> <td></td> </tr> <tr> <td>8849L</td> <td>Grey</td> <td>8305-99-869-4382</td> </tr> <tr> <td>8865B</td> <td>Blue Velvet</td> <td>8305-99-573-5054</td> </tr> </tbody> </table>	Pattern No.	Colour	NATO Stock No.	8849B	Scarlet	8305-99-869-4373	8849C	Crimson	8305-99-869-4374	8204B	Maroon	8305-99-942-7115	8849W	Guards Green		8849U	Navy		8849L	Grey	8305-99-869-4382	8865B	Blue Velvet	8305-99-573-5054
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<p>4.2 Crown, bevel and band lining</p>	<ul style="list-style-type: none"> • Cloth, twill viscose Plain weave polyester, plain weave polyester or plain weave, viscose. or • All linings to be grey or black to meet the colour fastness requirements for perspiration, Table 4 Ref: 1.4 of BS 4560 																								
<p>4.3 Interlining, crown and Bevel</p>	<ul style="list-style-type: none"> • Flexible polyurethane, having cells of uniform size and conforming to the requirements of Table 9. • Not less than 3mm and not more than 5mm thick 																								
<p>4.4 Additional crown lining</p>	<ul style="list-style-type: none"> • Cellulose acetate sheet, colourless, or • Polyethylene film, Cellulose acetate sheet, colourless, 0.1mm thick, • PVC sheeting • Not less than 0.1mm and not more than 0.13mm 																								
<p>4.5 Head leather</p>	<ul style="list-style-type: none"> • Leather, sheep, for head leathers Basil, natural, at least 1.0mm but not more than 1.3mm thick, to UK/SC/5696 The term Basil is defined in BS 2780 or, • An imitation leather of poromeric quality or • An alternative approved by the DC IPT. 																								

TABLE 4 – PRODUCT COMPONENTS CONTINUED

4.6 Band stiffener	<ul style="list-style-type: none"> • Cloth, Buckram, jute, laminated 2 ply, impregnated. Buckram to comply with the buckling and flexibility tests specified in Specification UK/SC/4776. Or • Glued Hessian plain weave, 1000g/m². Or • High density Polyethylene sheet, 1.0mm thickness \pm 0.1mm, either solid or perforated. Or • Air expanded plastic, 1.2 mm thick. Or • High density polypropylene sheet, 1.0mm thickness \pm 0.1mm, either solid or perforated.
4.7 Peak	<ul style="list-style-type: none"> • Flexible, PVC, black/beige laminate, with black side polished and beige flock sprayed, approximately 1.0mm thick, laminated to flexible vulcanised fibre or flexible fibreboard. Or • Two-part laminate, poly/cotton, impregnated with polyurethane, with black patent, finish approximately 1.0mm thick, laminated to polypropylene/polyethylene, Surface finish leather grain, Colour to be bottle green, Approximately 1.5mm thick. • Total thickness of peaks to be no less than 2.5mm and no more than 2.8mm, to comply with the requirements of Table 12.
4.8 Lining for peak	<ul style="list-style-type: none"> • Skiver green or imitation skiver green, embossed (except two-part laminate) cotton backed plastic. The term skiver is defined in BS 2780. to comply with the colour fastness in Table 10
4.9 Peak and head leather binding	<ul style="list-style-type: none"> • Cloth, velveteen, fawn or black to comply with the colour fastness requirements for perspiration, Table 2, of UK/SC/5628 • or an alternative approved by the DC IPT
4.10 Chinstrap for Pattern No.28373	<ul style="list-style-type: none"> • PVC, black, 10mm wide at least 1.0mm but not more than 1.3mm thick
4.11 Buttons for Pattern No.28373	<ul style="list-style-type: none"> • Button, white metal, chromium plated, 14m (22 ligne), Pattern No.15914 to comply with Specification UK/SC/5126, NATO Stock No.8455-99-973-0374
4.12 Cap badge for Pattern No.28373	<ul style="list-style-type: none"> • Badge, cap, MOD Guard Service, white metal, chromium plated, Pattern No.24600, to comply with the requirements of Specification UK/SC/5126, NATO Stock No.8455-99-978-8514

TABLE 4 – PRODUCT COMPONENTS CONTINUED

4.13 Front support	<ul style="list-style-type: none"> High density polyethylene conforming to BS 3412 Section 3, Type A, Class Q, 1.0 to 1.3mm thick.
4.14 Badge holder	<ul style="list-style-type: none"> Brass as on the Standard Pattern or An alternative approved by the DCT IPT
4.15 Thread for all purposes	<ul style="list-style-type: none"> Corespun polyester/cotton to BS EN 12590. <ul style="list-style-type: none"> Metric Ticket 25 (26) for peak to stiffener Metric Ticket 36(35) for bevel, band, sewing in crown, back and front finishing, lining and all hand sewing. Metric Ticket No.75 for all other sewing.

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Crown	<ul style="list-style-type: none"> The crown, pear-shaped, formed by two pieces of main material sewn together with a 0.7mm seam using seam type 1.01.01 of BS 3870 is to conform with the measurements in Table 7. The perimeter of the crown is to have a piped edge joined in line with the back seam of the bevel (except for Pattern Nos. 24524 and 24528). The crown and piping are to be combined to flexible polyurethane foam. The foam is to be bonded to the outer material and the laminate produced is to comply with the requirements set out in Table.11 The bond is to be continuous to ensure that the outer material is free from blisters
5.2 Bevel	<ul style="list-style-type: none"> The bevel, fused to flexible polyurethane as in 5.1 above, is to be cut one piece with the seam to the back of the cap. A tack is to be used centrally at the back of the cap to retain the bevel position on to the band .
5.3 Band	<ul style="list-style-type: none"> The band is to be constructed to the requirements specified in Table 8 To be formed with a 0.5cm seam, using seam type 1.01.01 of BS 3870, and should be pressed open. The seam is to be positioned to the back of the cap in line with the crown/bevel seam.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

5.4 Band stiffener	<ul style="list-style-type: none"> • The band is to be supported with a stiffener cut sufficiently long to allow a 2cm overlap where it is joined at the back of the cap, slightly offset to reduce thickness. • The stiffener is to be sewn through the outer material immediately below the seam joining the band, and basted / sewn to the band/bevel seam.
5.5 Peak	<ul style="list-style-type: none"> • The peak, black side uppermost, chamfer edged on the brow line and lined on the underside. • The outer edge of the peak is to be bound with black PVC, 0.6mm deep. • The peak may be fitted to the band stiffener by sewing the inner edge of the peak to either the inner or outer edge of the stiffener. • The seam allowance from the seam to inner peak edge is to be not less than 3mm and not more than 5mm. • When fitting the peak to the outer edge of the stiffener, the bottom edge of the stiffener is to be bound in velveteen. • The peak is to be securely sewn to the stiffener with approximately 4 stitches per 2cm.
5.6 Head leather	<ul style="list-style-type: none"> • Each cap is to have a brachered head leather. • The depth of the head leather is to be no less than 3.5cm and no more than 4.5cm. • The ends of the head leather are to overlap no more than 2cm at the centre back of the cap and be tacked together at the top and bottom edge. • Black velveteen finished depth, 2.5cm, is to be sewn to the head leather prior to attachment to the cap, extending the length of the peak.
5.7 Front support	<ul style="list-style-type: none"> • The front support is to be securely attached to the stiffener, positioned with the bottom of the support 3.5cm from the top edge of the stiffener. • The front support is not to protrude above the crown piping / bevel / crown seam.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

5.8 Lining	<ul style="list-style-type: none"> • The crown/bevel lining is to be shaped with a dart running from the back of the cap to the centre of the crown, in line with the seam. • The lining is to be securely tacked by hand or machine or glued with a suitable adhesive to the cap at the bottom edge of the stiffener. • The additional lining cut from Polyethylene film/PVC sheeting, approximately 10cm square, is to be securely sewn centrally on the crown lining, using seam type 5.04.01 of BS 3870.
5.9 Badge/badge holder (except for Pattern No.24520)	<ul style="list-style-type: none"> • The badge holder is to be fitted vertically between the band and the stiffener at the centre front of the cap, with the socket next to the band and the projection at the top of the holder protruding on the outside 1.5cm below the band/bevel seam. • An MOD Guard Service cap badge is to be inserted into the badge holder for Pattern No.28373.
5.10 Button position and chinstrap position	<ul style="list-style-type: none"> • The button position is to be indicated on each side of the cap, using either a small piece of white knotted sewing thread or a plastic tag, positioned 1cm from the bottom edge and 1.5cm behind the junction of the peak and band. • For Pattern No.28373 a button is to be securely sewn on each side of the cap to accommodate the chinstrap, positioned 1cm from the bottom edge of the band and 1.5cm behind the junction of the peak/band point.
5.11 Seams and stitching to BS 3870	<ul style="list-style-type: none"> • Machine stitching is to be stitch type 301, with at least eight but not more than ten stitches per 2cm. • The piping is to be formed using seam type 1.12.01. • The brachering on the head leather is to be stitch type 304 with at least six stitches per 2cm. • The binding on the peak is formed using seam type 3.01.01.
5.12 General	<ul style="list-style-type: none"> • Sewing threads may be treated with a stain free lubricant. • All seams are to be free from pucker. • The caps are to be free from all ends of sewing thread, be blocked, steamed and shaped to retain appearance and be delivered in a clean condition. • The felling on the head leather is to have at least six stitches per 2cm. • The surface of the peak is to be free from cracking and other defects. • Each MOD Guard Service cap is to be fitted with the appropriate buttons, chinstrap and cap badge by the contractor.

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS AND ACTUAL BODY MEASUREMENTS

Pattern No24515	Pattern No24519	Pattern No 24520	Pattern No 24523	Pattern No 24524	Pattern No 24525	Pattern No 24526	Pattern No 24528	Pattern No 27567	Pattern No 28373	Pattern No 28703	Size and Internal circumference
8410-99-978-	8410-99-978-	8410-99-978-	8410-99-978-	8410-99-978-	8410-99-978-	8410-99-978-	8410-99-978-	8410-99-978-	8410-99-869-	8410-99-869-	
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)
8197	8209	8221	8257	8269	8281	8293	8305	9984	3630	5648	50
8198	8210	8222	8258	8270	8282	8294	8306	9985	3631	5649	51
8199	8211	8223	8259	8271	8283	8295	8307	9986	3632	5650	52
8200	8212	8224	8260	8272	8284	8296	8308	9987	3633	5651	53
8201	8213	8225	8261	8273	8285	8297	8309	9988	3634	5652	54
8202	8214	8226	8262	8274	8286	8298	8310	9989	3635	5653	55
8203	8215	8227	8263	8275	8287	8299	8311	9990	3636	5654	56
8204	8216	8228	8264	8276	8288	8300	8312	9991	3637	5655	57
8205	8217	8229	8265	8277	8289	8301	8313	9992	3638	5656	58
8206	8218	8230	8266	8278	8290	8302	8314	9993	3639	5657	59
8207	8219	8231	8267	8279	8291	8303	8315	9994	3640	5658	60
8208	8220	8232	8268	8280	8292	8304	8316	9995	3641	5659	Outsize Measure

TABLE 7 – MEASUREMENTS AND TOLERANCES

All measurements are in cm unless otherwise stated

Size	50	51	52	53	54	55	56	57	58	59	60	S/M	Tols. mm	
Crown (Measurements exclude Piping)													+	-
Length (measured along seam)	22	22.5	23	23.5	24	24.5	25	25.5	26	26.5	27			
Width at widest point (following shape of crown)	22	22.5	23	23.5	24	24.5	25	25.5	26	26.5	27			
Band														
Depth at Front	6												2	2
Depth at Back	3.5												2	2
Bevel														
Depth at Front	7.5												2	2
Depth at Sides (In line with Buttons)	6.5												2	2
Depth at Back	5.5												2	2
Peak														
Depth at Centre Front	4.5												1	1
Length from Point to Point	25.5												5	5
Band Stiffener														
Depth at Front	6.5												2	2
Depth at Back	4												2	2
Front Support														
Length	7.5												2	2
Width at Base	3												2	2
Width at Top	4.5												2	2

TABLE 8 - CAP DETAILS AND FABRIC CONFIGURATIONS

Regt / Corp	NATO Stock No. 8410-99-	Pattern No.	Crown & bevel	Piping	Band
RA, RAOC, REME, AGC	978-8197 to 8208	24515	8849U Navy	8849B Scarlet 8305-99-869- 4373	<ul style="list-style-type: none"> Two piece: 8849B 8305-99-869-4373 Scarlet 5cm tapering to 2.5cm at back seam 8849U Navy 1cm wide
APTC, Waterloo band of the King's Div	978-8209 to 8220	24519	8849U Navy	8849B Scarlet 8305-99-869- 4373	<ul style="list-style-type: none"> One piece: As crown
R Signals	978-8221 to 8232	24520	8849U Navy	As crown	<ul style="list-style-type: none"> One piece: As crown
RAVC	978-8257 to 8268	24523	8849U Navy	8204B Maroon 8305-99-942- 7115	<ul style="list-style-type: none"> Two piece 8204B 8305-99-942-7115 Maroon 5cm wide tapering to 2.5cm at back seam 8849U Navy 1cm wide
RMP	978-8269 to 8280	24524	8849B Scarlet 8305-99-869- 4373	No Piping	<ul style="list-style-type: none"> One piece: 8848U Navy
RAMC	978-8281 to8292	24525	8849U Navy	8849C Crimson 8305-99-869- 4374	<ul style="list-style-type: none"> Two piece: 8849C 8305-99-869- 4374 Crimson 5cm wide tapering to 2.5cm at back seam 8849U Navy 1cm wide
RADC	978-8293 to 8304	24526	8849U Navy	8849W Guards Green	<ul style="list-style-type: none"> Two piece: 8849W Guards Green 5cm wide tapering to 2.5cm at back seam 8849U Navy 1cm wide
QARANC	978-8305 to 8316	24528	8849U Navy	No piping	<ul style="list-style-type: none"> Three piece: 8849B 8305-99-869-4373 Scarlet 2.25cm wide tapering to zero at back seam 8849L 8305-99-869-4382 Grey 1.5cm wide tapering to 1.25cm at back seam 8849B 8305-99-869-4373 Scarlet 2.25cm wide
R Engineers	978-9984 to 9995	27567	8849U Navy	8849B Scarlet 8305-99-869- 4373	<ul style="list-style-type: none"> Three piece: 8849U Navy 1cm wide 8849B 8305-99-869-4373 Scarlet piping 0.4cm wide finished length to be as standard pattern 8849U Navy 4.6cm wide tapering to 3.5cm at back

TABLE 8 - CAP DETAILS AND FABRIC CONFIGURATIONS (CONT)

Regt / Corp	NATO Stock No. 8410-99-	Pattern No.	Crown & bevel	Piping	Band
MOD Guard Service	869-3630 to 3641	28373	8849U Navy	As crown	<ul style="list-style-type: none"> One piece: As Crown
RLC	869-5648 to 5659	28703	8849U Navy	8849B Scarlet 8305-99-869-4373	<ul style="list-style-type: none"> Two piece: 8865B 8305-99-573-5054 Blue Velvet 5.2cm wide tapering to 2.7cm at back seam 8849U Navy 0.8cm wide

TABLE 9 METHOD OF TEST Flexible polyurethane foam,

PROPERTY	REQUIREMENT	METHOD OF TEST
Apparent density kg/m ³	25 – 30	BS EN ISO 845

TABLE 10 TEST REQUIREMENTS.

The peak lining is to conform to the following Table:

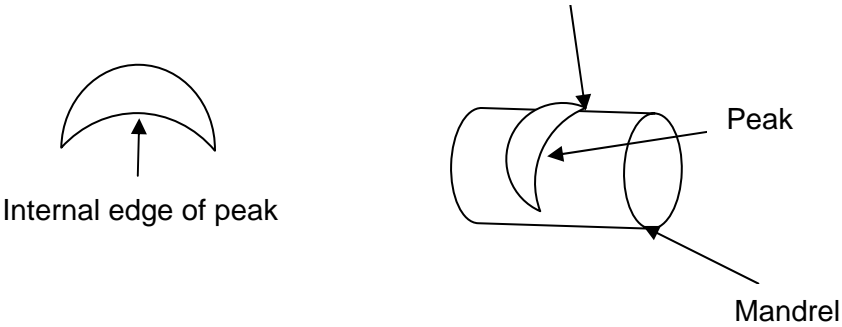
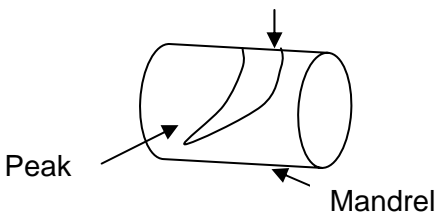
Agency	Minimum rating for colour change	Method of test
Rubbing, wet	4	BS EN ISO 105 (X12)

TABLE 11 METHOD OF TEST To Determine Fabric/foam Laminate Bond Strength.

The minimum bond strength of the laminated fabric is to be 1.25N/25mm when determined by the following method:

11.1 Sample preparation	<ul style="list-style-type: none"> Specimens which have been conditioned for 24 hours in the standard testing atmosphere defined in BS EN ISO 139 are to be cut 200mm x 25mm with at least two samples being cut with the 200mm dimension in the warp and weft direction respectively.
11.2 Procedure	<ul style="list-style-type: none"> The conditioned samples are to be delaminated by hand for 100mm. The tails are to be clamped in the jaws of a CRE tensile testing machine. The sample is then to be peeled apart with a jaw separation of 100mm/min for a 50mm length of sample.
11.3 Calculation and expression of results	<ul style="list-style-type: none"> The maximum value of peel bond strength is to be recorded for each sample that peels for 50mm without the foam breaking. If the foam does break during delamination this fact is to be noted and the value at break recorded. The mean value of two results for samples, which delaminate for 50mm without the foam breaking, is to be calculated in the warp and weft direction respectively.

TABLE 12–TEST FOR THE DELAMINATION OF PEAKS

12.1 Test procedure	<ul style="list-style-type: none"> • Four cap peaks (detached from caps) are to be taken from batches of up to 500 and conditioned for 24 hours in the standard atmosphere defined in BS EN ISO 139. • Two peaks are to be placed in an environmental chamber at $70 \pm 2^\circ\text{C}$ and 95 - 100% relative humidity for 6 hours \pm 15 minutes. After removal, the peaks are to be examined for delamination of the black PVC and the (green) skiver, delamination of either peak is to render the batch rejected. Any degree of distortion is to be such that it will not affect the subsequent fitting of the peak to a cap; severe distortion of either peak is to render the batch rejected. • Two peaks are to be placed in a freezer at $-20 \pm 2^\circ\text{C}$ for $2\frac{1}{2}$ hours \pm 5 minutes. Immediately after removal, each peak is to be subjected to the following two tests using a mandrel of diameter $150 \pm 1\text{mm}$
12.2 Edge test	<p style="text-align: center;">Edge of peak to mandrel</p>  <ul style="list-style-type: none"> • Use the minimum of force required to bend the internal edge of the peak around the mandrel, ensuring free contact with the circumference of the mandrel. Repeat with the other side up. Examine both sides of the peak for fractures or cracks; any such damage on either peak is to render the batch rejected.
12.3 Flat test	<p style="text-align: center;">Flat edge to mandrel</p>  <ul style="list-style-type: none"> • Use the minimum force required to bend the face of the peak around the mandrel, ensuring free contact with the circumference of the mandrel. Repeat with the other side up. Examine both sides of the peak for fractures and cracks: any such damage on either peak is to render the batch rejected.

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

- For Stock sizes: Item name, NATO Stock Number, size, number and the contract number.
- For special measures: Item name, NATO Stock Number, size of wearer, contract number.
- Position: Clearly marked on a label attached at the centre of the crown lining. Or
- Clearly printed on a pressure sensitive self adhesive label, to be adhered to the centre of the crown lining.
- The identification label is to be covered by the additional lining.

TABLE 13 SPECIMEN LABELS

<u>Stock Items</u>	<u>Outsize</u>
CAP, SERVICE, WOMAN'S	CAP, SERVICE, WOMAN'S
Size	Size
NSN	NSN
Contract No.	Contract No.
	Name:
	No: