

**Technical Specification for
CAP, CEREMONIAL Bearskin,
Officers and Other Ranks**



Defence Clothing
Integrated Project Team

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PREFACETABLE 1 – PRODUCT LIST

Item Name	CAP, CEREMONIAL Bearskin, Officers and Other Ranks	
Development File No	D/DCTA/P2501 (ST)	
Product Support File No.	D/DCTA/452/037 (QPS)	
Nato Stock Number (NSN)	Item	Pattern Number
8405-99-130-1105 to 1109	Officers	20070
8405-99-130-1113	Special Measure	
8405-99-975 4513 to 4520	Other Ranks	7951
8405-99-975-4521	Special Measure	

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PART 1

1. THE PRODUCT

- a. Use of the Product. A ceremonial cap for wear by Officers and Other Ranks of the Footguards.

FIGURE 1. CAP, CEREMONIAL Bearskin, example shown Other Ranks, Pattern No. 7951

Front and left side as worn.



Right hand side as worn.

TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS 3102:1959	Specification for brass eyelets and washers for general purposes.
BS 7141:Part 6	Narrow Fabrics. Specification for Laces for Footwear and other Purposes.
BS 7318	Industrial sewing threads made from linen (flax) or cotton
UK/SC/5126	Insignia, Buttons, Pins, Plates and Titles manufactured from Gilding Metal, Brass and Nickel Plate
UK/SC/5696	Leather, sheep, headleathers
CITES	Convention on International Trade of Endangered Species of Wild Flora and Fauna (CITES)

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. Shaped bearskin on a willow frame

TABLE 4 – PRODUCT COMPONENTS

4.1 Main material	<ul style="list-style-type: none"> • Bearskin, black bear or black faced brown bear, to be sourced under the CITES convention. • Prime bearskin, mineral combination tanned e.g. chrome / gluteraldehyde, free from splits or weak pelts and dyed permanent colour fast glossy black-blue based. • Hair must be free flowing and without felting. • The guard hair is not to measure less than 7cm in length for other ranks Pattern No 7951 and 8cm in length for officers Pattern No 20070. • The physical appearance is to match that of the Standard Pattern
4.2 Frame	<ul style="list-style-type: none"> • Good quality English buff willow
4.3 Headband	<ul style="list-style-type: none"> • Felt wool, black, consisting of two layers combined and stiffened for strength and support, overall thickness not less than 6mm and not more than 8mm
4.4 Headleather	<ul style="list-style-type: none"> • Leather goat/sheep skin, full grain, black, at least 1.0mm but not more than 1.2mm thick to meet the requirements of UK/SC/5696. • Or an alternative approved by the DC IPT.
4.5 Headband lining, Officers	<ul style="list-style-type: none"> • Silk, crimson, to match that on the Standard Pattern
4.6 Vents	<ul style="list-style-type: none"> • Pepperpot vents, brass, black stoving paint or powder coat finish, 20mm diameter
4.7 Hooks	<ul style="list-style-type: none"> • Brass, self coloured, size and shape as on the Standard Pattern • NATO Stock Number 8440-99-975-6336
4.8 Plume sockets	<ul style="list-style-type: none"> • PVC, black patent, 3mm thick

4.9 Drawcord for headleather	<ul style="list-style-type: none">• Black knitted cord to Table 1 Normal use to BS 7141 Part 6.• Tubular pressed flat at least 2gms/m and not more than 3gms/m• Length of cord not less than 60cm and not more than 65cm
4.10 Eyelets	<ul style="list-style-type: none">• Brass, black stoving paint or powder coat finish, internal size 5mm, to BS 3102
4.11 Plume Rings	<ul style="list-style-type: none">• Brass, black stoving paint or powder coat finish, internal diameter 14mm, to UK/SC/5126• NATO Stock No 8415-99-975-6349 Pattern No 7641
4.12 Adhesive	<ul style="list-style-type: none">• Water based paste
4.13 Sewing threads for all purposes	<ul style="list-style-type: none">• Thread No 18, Cord 3 black to Table 2 of BS 7318.• Doubled for all stitching.

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Bearskin	<ul style="list-style-type: none"> • The cap outer, manufactured from bearskin, formed from a front and back section, is shaped by three darts in both the front and back sections. • Positioned so that the bearskin when sewn together and blocked fits tightly over the frame. • The cap is to be well balanced, and the hair of the bearskin is to lay and give the same appearance that of the Standard Pattern. • Where the bearskin is joined the hair is to be well matched and without steps. • Cutting or trimming of the hair is not permitted • The hair at the crown is not to lie flat
5.2 Frame	<ul style="list-style-type: none"> • The design and shape of the frame is to be as on the Standard Pattern. • The frame, constructed from willow is to be neatly and securely bound by cane. • The frame is then to be secured to the felt band by hand stitching. • The stitching is to pass through each strut at least once and be finished with 3 lockstitches. • The length at the front of the frame from the top ring to the bottom ring is to be; <ul style="list-style-type: none"> a. not less than 16.5cm and not more than 17.5cm for Pattern No 20070 Officers. b. not less than 14.5cm and not more than 15.5cm for Pattern No 7951 Other Ranks • The circumference of the frame base is to be in accordance with the sizes specified in the Schedule.

5.3 Headband	<ul style="list-style-type: none">• The headband, shaped as that of the Standard Pattern,• 18cm deep at the centre back and 10cm deep at the centre front for Pattern No 20070 Officers• 14cm deep at the back and 8cm deep at the front for Pattern No 7951 Other Ranks.• The headband of the Pattern No 20070 Officers cap is to be lined to match the Standard Pattern.
5.4 Headleather	<ul style="list-style-type: none">• The headleather, shaped as on the Standard Pattern, is to be secured to the headband and outer bearskin penetrating all layers and lockstitched every 3 stitches.• Adhesive may be applied prior to blocking to form the shape and size of the headband.• All seams are to be neatly stitched with no less than 3 stitches per 2.5cm.• Folds or creases in the headleather will not be permitted.• The headleather is to terminate in eyeletted flanges measuring approximately 9.5cm in length.• The front and back headleather to be overlapped by a minimum of 1cm on either side and be securely sewn with at least 3 stitches per 2cm.• One eyelet fitted to each flange positioned centrally 2.2cm to the centre of the eyelet from the tip of the flange.• Holes punched to receive the eyelets are to be smaller than the outside diameter of the eyelet barrel, so that the barrel must be forced through the hole.• The eyelets are to be securely clinched without cutting the leather.

5.5 Plume Sockets	<ul style="list-style-type: none"> • A plume socket, shaped as standard pattern, 2.5cm wide and effective depth 6cm, is to securely attached to both sides of the bearskin positioned as follows: <ol style="list-style-type: none"> a. Pattern No 20070 Officers – positioned not less than 9cm, and not more than 9.5cm from the base of the cap to the point of the plume socket. b. Pattern No 7951 Other Ranks – Positioned not less than 7.5cm, and not more than 8cm from the base of the cap to the point of the PVC plume holder.
5.6 Plume Rings	<ul style="list-style-type: none"> • A plume ring is to be securely attached on each side of the bearskin 16cm from the centre of the crown and vertically in alignment with the point of the plume holder.
5.7 Hooks	<ul style="list-style-type: none"> • The hooks are to be positioned in line with the side struts of the frame and be securely sewn to the inside of the felt headband, reinforced on the outside by a small piece of leather. • The base of the hook is to measure no less than 7.5cm and no more than 8cm from the base of the cap for Officers and be no less than 6cm and no more than 6.5cm from the base of the cap for other ranks. • These measurements for size 57, to be proportionately positioned for smaller sizes
5.8 Vents	<ul style="list-style-type: none"> • Three vents are to be fitted to the inside back of the cap • To be positioned centrally between the top and middle rings of the frame • The middle vent to be positioned dead centre and the other two vents 8cm either side
5.9 Drawcord	<ul style="list-style-type: none"> • A drawcord is to be threaded through the eyelets. • The ends of the drawcord are to be sealed to prevent fraying.

TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS SIZE AND MEASUREMENTS

Officers NATO Stock Nos 8405-99-130-	1105	1106	1107	1108	1109	-	-	-	1113	Tols cm	
Other Ranks NATO Stock Nos 8405-99-975-	4513	4514	4515	4516	4517	4518	4519	4520	4521	+	-
Size and Internal Circumference	55 (6 ⁷ / ₈)	56 (7)	57 (7 ¹ / ₈)	58 (7 ¹ / ₄)	59 (7 ³ / ₈)	60 (7 ¹ / ₂)	61 (7 ⁵ / ₈)	62 (7 ³ / ₄)	Special	1	0
Overall Height From Bottom Front Edge to Inside Top										1	1
Officers	30.5cm										
Other Ranks	24.5cm										

- All measurements are in centimetres unless otherwise stated
- Measurements in brackets are imperial head-dress size

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

- NATO Stock Number, size number, and the contract number.
- Clearly printed on a pressure sensitive self-adhesive label, to be adhered to the headband at the back of the cap.

TABLE 8 – SPECIMEN LABELS

55
8405-99-130-1105
Contract No.

The size number is to be 12mm high and the remainder of characters no less 6mm high.

5. PACKAGING REQUIREMENTS

The items shall be package using the following Special Packaging Instruction (SPIS):-

- a. Pattern No 20070 Officers - SPIS DPKGA/130-1105 Drawing No PK4893
- b. Pattern No 7951 Other Ranks – SPIS DPKGA/975-4506 Drawing No PK4868