



**Manufacturing Specification for
SPORRAN
THE ROYAL REGIMENT OF SCOTLAND**

Defence Clothing (DC)

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PREFACE

TABLE 1 – PRODUCT LIST

Item Name	Sporran Royal Regiment of Scotland
Development File No.	P4.857
NATO Stock Number	Pattern Number
8405-99-702-1559	D00862A

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
6	Reformatted	21 February 2011
5	Amendment to Horsehair requirement and Marking Clause	03 February 2009
4	Amendment to Male Press Stud Position moved from 25mm to 22mm	29 March 2007
3	This item does not supersede UK/ISC/2670B, UK/SC/3349 Issue 4 or UK/SC/3350 Issue 2 Specification amended as follows: Belt keeper added Securing bolts changed to securing nuts Stitches per 25mm amended Press stud position wording amended Tolerances adjusted Care instructions amended	06 February 2007
2	Addition of care and maintenance instructions	24 October 2006
1	New Item for the New Scottish Regiment. Supersedes UK/ISC/2670B, UK/SC/3349 Issue 4, UK/SC/3350 Issue 2 & DC/CPS/6332 Issue 1	09 October 2006

PART 1

1. THE PRODUCT

- a. Use of the Product: Sporrans for The Royal Regiment of Scotland is used by all ranks of the Royal Regiment of Scotland for Parade and Ceremonial duties.

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 Part B01 Part E01	Textiles. Test for colour fastness Colour fastness to light. Daylight Colour fastness to water
BS EN 1652	Copper and copper alloys. Plate, sheet, strip and circles for general purpose.
BS 2780	Glossary of leather terms
BS 3870 Part 1	Stitches and seams. Classification and terminology of stitch types
BS 7318	Specification for industrial sewing threads made from linen (flax) or cotton

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

- a. Product Description: White horse hair sporrán with a brass Saint Andrew and thistle design cantle, press stud closure purse, two black horsehair tassels. Supplied with a white buff PVC belt.
- b. All the leather terms stated in this specification are defined in BS 2780.

Figure 1

FRONT



BACK



TABLE 4 – PRODUCT COMPONENTS

4.1 Cattle	<ul style="list-style-type: none"> • Brass to BS EN 1652 type CuZn30, or a suitable alternative approved by DC • The Saint Andrew and thistle design shall be as shown on the Standard Pattern • Design to Standard Pattern
4.2 Hair	<ul style="list-style-type: none"> • White – Horsehair bleached white • Black – Horsehair dyed black, to meet the requirements of Table 8 for colourfastness • All hair shall be thoroughly disinfected by steam process prior to manufacture, and a certificate confirming this shall be supplied with each delivery
4.3 Wax	<ul style="list-style-type: none"> • For horsehair – Best quality “beeswax” natural or black as appropriate, or a suitable alternative approved by DC
4.4 Under hair	<ul style="list-style-type: none"> • Chrome tanned, full hair goatskin, colour white
4.5 Leather for the Purse	<ul style="list-style-type: none"> • Purse back, flap and belt loops - black, vegetable tanned leather, 2.8 to 3.0mm thick • Edge binding and gusset – black, basil, 1.0 to 1.2mm thick • Lining – Dark brown, basil, 1.0 to 1.2mm thick
4.6 Belt	<ul style="list-style-type: none"> • White buff Polyvinylchloride (PVC), as shown on the Standard Pattern
4.7 Closure	<ul style="list-style-type: none"> • Ring press fastener, durable dot, brass finished, black • Or a suitable alternative approved by DC
4.8 Securing washers	<ul style="list-style-type: none"> • Stainless steel
4.9 Securing nuts	<ul style="list-style-type: none"> • Brass, domed end • Brass, plain
4.10 Eyelets	<ul style="list-style-type: none"> • Brass, 7mm ± 1mm, inside dimensions
4.11 Adhesive	<ul style="list-style-type: none"> • Natural rubber latex with resin • Or a suitable alternative approved by DC

TABLE 4 – PRODUCT COMPONENTS continued

4.12 Sewing threads	<ul style="list-style-type: none"> • Hair to chain attachment – Thread, linen, not finer than 25/3 cord to BS 7318 • For all other purposes – Thread, linen, 25/3 cord, colour to match Standard Pattern, to BS 7318 • Or suitable alternatives approved by DC
4.13 Belt Buckles	<ul style="list-style-type: none"> • Brass, nickel-plated 20mm, belt buckle with roller • Or a suitable alternative approved by DC
4.14 Belt buckle attachment rivet	<ul style="list-style-type: none"> • Brass or copper
4.15 Belt keeper	<ul style="list-style-type: none"> • Brass, nickel-plated 20mm • Or a suitable alternative approved by DC
4.16 Tassel holder	<ul style="list-style-type: none"> • Brass sheet 0.7mm thick to BS EN 1652 type CuZn36 • Thistle and leaf design as shown on the Standard Pattern • Bottom edge design as shown on the Standard Pattern • Length 65mm ± 1mm, top hole diameter 7mm ± 1mm and bottom hole diameter 30mm ± 1mm • The tassel holder shall be lacquered
4.17 Tassel chain	<ul style="list-style-type: none"> • Brass, 6 to 7 links per 25mm
4.18 Tassel chain split ring	<ul style="list-style-type: none"> • Steel, split ring, 10mm ± 1mm diameter

TABLE 5 – PRODUCT CONSTRUCTION – SPORRAN

5.1 Stitches	<ul style="list-style-type: none"> • All stitching shall be either hand stitched and machine stitched complying with BS 3870 Part 1 stitch type 301 with 5 to 6 stitches per 25mm
5.2 Crown	<ul style="list-style-type: none"> • A base of 2 layers of Grade 2 white horsehair with 2 top layers of brilliant white bleached Grade 1. • The general bulk of the horsehair shall match the Standard Pattern • The horsehair shall be hand plaited with a turning of 25mm at the top and 8 ± 1 plaits per 25mm • The plaited hair shall be attached to the hair skin in four tiers by hand stitching • The three lower tiers shall be inserted through cuts in the hair skin and then attached by binding both sides of the cuts to the plaited hair • The ends of the top tier shall be staggered to the shape of the top of the purse • The bottom of the combined hair shall be shaped as shown of the Standard Pattern
5.3 Front lining of purse	<ul style="list-style-type: none"> • Three eyelets shall be attached to the lining as shown on the Standard Pattern • The under hair skin shall be attached to the lining with adhesive

TABLE 5 – PRODUCT CONSTRUCTION – SPORRAN continued

5.4 Back face of the purse	<ul style="list-style-type: none"> • The purse pocket opening is formed by cutting through the full thickness of the back face as shown on the Standard Pattern • A male press stud shall be positioned 22mm, to its centre, from the top of the pocket and the female press stud shall be positioned on the flap to locate correctly with the male press stud • Two triangular gussets shall be attached with a single row of stitching. The stitching attaching the gussets shall continue around the whole of the opening perimeter as shown on the Standard Pattern • Two vertical belt loops, 70mm by 22mm \pm 2mm, shall be positioned as shown on the Standard Pattern. They shall be attached with two rows of stitching at the top • The purse flap is positioned over the bottom end of the belt loops and attached using two rows stitching as shown on the Standard Pattern or an alternative method approved by DC • The effective opening of the belt loops is 35mm \pm 1mm
5.5 Purse	<ul style="list-style-type: none"> • The lining is attached to the back of the purse with adhesive • The perimeter shall be bound with leather, 30mm wide, attached with one row of stitching through all the layers of material. The join shall be positioned at the bottom of the purse • Two 4mm holes shall be punched through the purse to locate the tassel chains. Positioned immediately above the flap and the outside edges of the belt loops, as shown on the Standard Pattern
5.6 Cattle attachment	<ul style="list-style-type: none"> • Three washers, brass bolts, plain nuts and domed nuts secure the purse to the cantle • The bolt length shall allow the plain nut and the domed nut to be locked together as shown on the Standard Pattern • There shall be no excess bolt length

TABLE 5 – PRODUCT CONSTRUCTION – SPORRAN continued

5.7 Tassel attachment	<ul style="list-style-type: none">• Two tassels shall be attached to the sporrans through the holes in the sporrans front using split rings as shown on the Standard Pattern
5.8 Belt	<ul style="list-style-type: none">• White buff PVC 18mm wide, effective length 1200mm \pm 5mm• A 20mm buckle shall be attached either by stitching or by rivet and stud• There shall be nine belt holes starting 70mm \pm 2mm from the end and spaced 25mm \pm 1mm apart• The belt shall be supplied with a keeper
5.9 General	<ul style="list-style-type: none">• The sporrans shall be secured in a clean condition and free from loose hair

TABLE 6 – PRODUCT CONSTRUCTION – TASSELS

6.1 Horse hair	<ul style="list-style-type: none"> The general bulk of horsehair shall match the Standard Pattern
6.2 Plaiting	<ul style="list-style-type: none"> The horsehair shall be hand plaited with 25mm turning at the top and 8 ± 1 plaits per 25mm
6.3 Assembly	<ul style="list-style-type: none"> The chain shall be attached with at least 4 stitches passing through the core and hair below the binding and firmly finished off
6.4 Finishing	<ul style="list-style-type: none"> A split ring shall be fitted to the free end of the chain The tassels shall be delivered in a clean and neat condition

TABLE 7 – MEASUREMENTS AND TOLERANCES IN MILLIMETERS

Item	Part	Measurement	Tolerance \pm	
Sporran	Overall length	490	2	
Purse	Length	240	2	
	Width	150	2	
	Pocket	Height	70	1
		Width	100	1
		Top of gusset width	75	2
		Top edge of pocket to bottom of purse	135	1
	Flap	Height	70	1
		Width	120	1
Top of purse to top of flap		75	1	
Tassel	Length (including tassel holder & excluding chain)	310	3	
	Chain length above tassel holder to front of Sporran	45	1	

TABLE 8 – COLOUR FASTNESS

Colour fastness to	Rating (Minimum)		Method of test
	Colour change	Staining	
Light	5	-	BS EN ISO 105:B01
Water	4	3	BS EN ISO 105:E01

4. LABELLING REQUIREMENTS

- a. The sporrans shall be clearly and indelibly marked with 3mm figures/letters with the contract number, year and month of manufacture and batch identification, relating to the consignment of horsehair and a NATO Stock Number and any other such markings as the contract or order may require. Sporrans shall be marked just under the top edge of the pocket under flap (out of view).
- b. Each sporran shall be supplied with a care and maintenance instructions as follows:

TABLE 9 – SPECIMEN LABELS

<u>Sporran Royal Regiment of Scotland – Care Instructions</u>
<ul style="list-style-type: none"> • The brass cantle shall be removed from the sporran for cleaning • The tassel holders are lacquered to aid cleaning and may require re-lacquering during their life • The horsehair on the sporran and tassels is to be lightly brushed. Do NOT comb • The shaping of the horsehair on the sporran and tassels is NOT to be tampered with in any way, especially “tidying it up” by cutting straight across the bottom

Figure 2 Example care label