



Technical Specification for

BRAID, CORD, LACE, BADGES and EMBROIDERY GOLD GILT
BRAID, CORD, LACE, BADGES and EMBROIDERY SILVER GILT

Defence Clothing

PROPERTY OF
MINISTRY OF DEFENCE

Defence Equipment & Support



MINISTRY OF DEFENCE

PREFACETABLE 1 – PRODUCT LIST

| | |
|---------------------------------|--|
| Item Name | BRAID, CORD, LACE, BADGES and EMBROIDERY GOLD GILT BRAID, CORD, LACE, BADGES and EMBROIDERY SILVER GILT |
| Development File No. | |
| Product Support File No. | |
| NATO Stock Numbers | See Table 8 |

Any colour shown in this document is for representation and must not be used for colour matching.

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TABLE 2 – ISSUE RECORD

| Issue No | Comments | Issue Date |
|-----------------|--|-------------------|
| 03 | Reformatted. Change to labelling/ packaging requirements. | 20 August 2009 |
| 02 | Addition of NSN's: 8455-99- 213-0888 213-0889 406-7487 764-1105 814-2142 814-2143 814-2144 814-2145 814-2146 814-2147 | 28 November 2007 |
| 01 | New specification | 05 July 2007 |
| | | |

PART 11. THE PRODUCT

- a. Use of the Product. This specification defines the requirements for gold and silver gilt braid, cord, laces, badges and embroidery which are used by the Services.

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

| Specification/Document | Detail |
|-------------------------------|--|
| BS EN ISO 105 | Textile. Tests for colour fastness. |
| Part B02 | Colour Fastness to artificial light. Xenon arc fading lamp test. |
| Part D01 | Colour fastness to dry cleaning. |
| Part X12 | Colour fastness to rubbing. |
| BS ISO 6348 | Textiles. Determination of mass vocabulary. |
| BS 4973 Part 4 | Specification for sew-in interlinings. |
| DEF STAN 81-89 | Paper, Tissue, Wrapping |
| UK/SC/5516 | Cloths, wool, uniform dress |

2. PATTERNS.

- a. Master Patterns. The 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

Badges and various accoutrements in which part of the product component contains either gold or silver gilt.

TABLE 4 – PRODUCT COMPONENTS

| | |
|------------------------------|--|
| 4.1 Textile Yarn | <ul style="list-style-type: none"> Textile yarns shall be dyed with sulphur-free fast dyes, to match the colour of the metal wire components; they shall meet the colour fastness requirements stated in Table 6, and shall be of adequate strength and durability. |
| 4.2 Metal Wires | <ul style="list-style-type: none"> Metal wires used shall be copper electroplated with silver. Metal compositions are made up of 99.00% copper, 0.50% silver (within tolerance +0.25% / -0.05%) and 0.50% trace elements mainly consisting calcium, lead, magnesium, iron, nickel. Silver wires shall be finished with a clear lacquer. Gold wires shall be finished with a gold lacquer. |
| 4.3 Composite Yarns | <ul style="list-style-type: none"> Where combination metal and textile yarns are required e.g. as in Orris laces, the metal is to be twisted uniformly over the textile core, the number of turns used in covering the latter being such that complete coverage of the core is obtained, without "grinning" through of the textile base. The composite "metal" yarns used in all cases shall be uniform in diameter, and present a uniform and continuous gold or silver appearance. |
| 4.4 Metal Embroidery Threads | <ul style="list-style-type: none"> Referring to all hand embroidered items included in the Annex 2 Product listing - Table 8. All elements of metal, gold or silver embroidery must meet the requirements in composition as stated in section 4.2. Metal Embroidery threads must be tarnish protected to ensure that subsequent handling during the hand embroidery process does not advance tarnishing of the end product. Acceptable protection can be either a light varnish finish or other approved chemical oxidation – prevention treatment, sufficient that it provides adequate protection without adversely affecting the finished appearance of the embroidery. |

TABLE 4 – PRODUCT COMPONENTS Continued

| | |
|---|---|
| 4.5 Ground Cloths for badges & chevrons | <ul style="list-style-type: none"> • For badges manufactured from melton ground cloth, the cloth is to be light melton as specified in UK/SC/5516. • Colour of ground cloth is to be as standard pattern. |
| 4.6 Backing cloth | <ul style="list-style-type: none"> • <u>Dark coloured backing cloths.</u> Cloth, plain weave flax, black, Ref No. WS1 to BS 4973: Part 4, Pattern No. 8443A. NATO Stock No. 8305-99-942-7523 • <u>Medium to light coloured backing cloths.</u> Cloth, plain weave flax, to meet the physical requirements of BS 4973: Part 4 but to match shade of standard pattern. • Or an alternative approved by DC. |

TABLE 5 – PRODUCT CONSTRUCTION

| | |
|----------------------|---|
| 5.1 Braids and cords | <ul style="list-style-type: none"> • The braids and cords shall be produced by braiding composite metal threads around textile core yarns. Cord, gold, universal shall have a single core, and the Russia braids shall have two separate cores separated by the interlacing of the braiding threads. • Braiding shall be carried out to give an even braid, free from manufacturing defects. • The finished width of the braid or cord, number of spindles, braiding ends and plaits per cm shall comply with the requirements specified. * |
| 5.2 Laces | <ul style="list-style-type: none"> • The weave order shall be as shown by the related Standard Patterns.* In this respect, only minor variations which do not affect the quality or the appearance of the lace will be permitted, i.e. the disposal, width, etc of the vellums, check, bar ends or ends within each type of lace must correspond with the relevant Standard Patterns. * • Selvages shall be firm and even, without kinks. The weft threads shall be evenly spaced and show no distortion across the width of the lace (especially within the vellums), so that objectionable "grinning" of the warp through the weft is not apparent. |
| 5.3 Embroidery | <ul style="list-style-type: none"> • Embroidery shall be carried out with approved textile yarns, and all sewing shall be securely finished off to match those properties of the related Standard Pattern. |

TABLE 5 – PRODUCT CONSTRUCTION Continued

| | |
|--|--|
| 5.4 Manufacture | <ul style="list-style-type: none"> • Braid, cord, laces and embroidery shall be manufactured to the highest standard and free from objectionable defects. Braid, cord and laces shall be even and width, construction and appearance shall be correct and uniform throughout each roll. |
| 5.5 Appearance | <ul style="list-style-type: none"> • Tarnished items are not acceptable. |
| 5.6 Finish | <ul style="list-style-type: none"> • Items are to be free from cracks. |
| 5.7 Pliability | <ul style="list-style-type: none"> • The completed braid, cord, lace and embroidery shall be of equivalent pliability to the relevant Standard Pattern. |
| 5.8 Reels | <ul style="list-style-type: none"> • Rolls may be cut to remove a defect provided that: • No roll contains more than 1 cut. • No length of less than 1 metre is included in a roll. • A 0.25 metre allowance is made for a cut through. |
| <p>* The designs, widths and weights of the braids, cords, laces and embroidery shall be in accordance with the relevant Standard Pattern.</p> | |

4. PHYSICAL REQUIREMENTS

- BS ISO 6348 describes mass. A mass tolerance of ± 5 per cent will be allowed.

TABLE 6 – COLOUR FASTNESS REQUIREMENTS

The colour fastness requirements for the textile yarns employed for braids, laces, cords, or embroidery shall be not lower than the rating specified in the following Table:

| Method of Test BS EN ISO 105 | | |
|---------------------------------|---------|---------------|
| B02 (Xenon lamp) | X12 | |
| Light | Rubbing | |
| 6 | Dry | Wet |
| | 4 – 5 | |
| | | D01 |
| | | Dry cleaning |
| | | Colour change |
| | | 5 |

5. LABELLING REQUIREMENTS.

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

TABLE 7 – SPECIMEN LABELS

| |
|--------------|
| NSN |
| Contract No. |
| Year |

Figure 1. Example Identification and Marking label

6. PACKAGING

Each badge is to be individually packed in acid free paper to comply with DEF STAN 81-89.

TABLE 8 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION**BADGES**

| No | NSC:8455- NSN: 99 | Pattern No. | Description | Additional Information |
|-----|----------------------|----------------|--|--|
| 1. | 213-0888 | D01402 | BADGE, QUALIFICATION, MUSICIAN AND BANDSMEN, THE RIFLES | Large Lyre in Wreath, Crown above. Silver gilt on black and green. |
| 2. | 213-0889 | D01403 | BADGE, QUALIFICATION, BUGLE MAJOR, THE RIFLES | 2 overlapping bugles. Silver gilt on black and green. |
| 3. | 364-0745 | D01097 | BADGE RANK SMALL CROWN , THE RIFLES | Crown. Silver gilt on black and green. |
| 4. | 364-0746 | D01098 | BADGE RANK WO2 CROWN IN WREATH, THE RIFLES | Crown in wreath. Silver gilt on black and green. |
| 5. | 364-0747 | D01099 | BADGE RANK WO1 ROYAL ARMS, THE RIFLES | Royal Arms. Silver gilt on black and green. |
| 6. | 364-0748 | D01100 | BADGE RANK CHEVRON 4 BAR BUGLE MAJOR, THE RIFLES | 4 Bar Chevron. Silver gilt on black and green. |
| 7. | 364-0749 | D01101 | BADGE RANK CHEVRON 3 BAR SERGEANT, THE RIFLES | 3 Bar Chevron. Silver gilt on black and green |
| 8. | 364-0750 | D01102 | BADGE RANK CHEVRON 2 BAR CORPORAL, THE RIFLES | 2 Bar Chevron. Silver gilt on black and green |
| 9. | 364-0751 | D01103 | BADGE RANK CHEVRON 1 BAR LANCE CORPORAL, THE RIFLES | 1 Bar Chevron. Silver gilt on black and green |
| 10. | 406-7487 | D01278 | INSIGNIA, ORGANISATIONAL, ARM. THE MERCIAN REGIMENT GILDER FLASH | Gold Wire Glider on gold wire Staffordshire knot backed by buff coloured backing on black backing. |

TABLE 8 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

| | | | | |
|-----|----------|--------|--|---|
| 11. | 764-1105 | D01089 | BADGE, QUALIFICATION, ROYAL NAVY, DIVERS | Royal Navy divers, Officer & WO1. Worn on cuff. Gold gilt wire divers helmet beneath crown with heraldic dolphin either side. |
| 12. | 777-7647 | D01225 | BADGE RANK, WO2 (CSM) LARGE CROWN, THE RIFLES | Silver Gilt Wire on black and green. |
| 13. | 777-7648 | D01226 | BADGE, QUALIFICATION, BUGLER | Silver Gilt Wire on black and green. |
| 14. | 814-2142 | D01376 | SHOULDER BOARD, RANK, WARRANT OFFICER THE ROYAL REGIMENT OF SCOTLAND | Twisted gilt wire with black cord. Plain board. No1 dress shoulder board. Supplied in Pairs. |
| 15. | 814-2143 | D01377 | SHOULDER BOARD, RANK, SECOND LIEUTENANT, THE ROYAL REGIMENT OF SCOTLAND | Twisted gilt wire with black cord. 1 metal star. No1 dress shoulder board. Supplied in Pairs. |
| 16. | 814-2144 | D01378 | SHOULDER BOARD, RANK, LIEUTENANT, THE ROYAL REGIMENT OF SCOTLAND | Twisted gilt wire with black cord. 2 metal stars. No1 dress shoulder board. Supplied in Pairs. |
| 17. | 814-2145 | D01379 | SHOULDER BOARD, RANK, CAPTAIN, THE ROYAL REGIMENT OF SCOTLAND | Twisted gilt wire with black cord. 3 metal stars. No1 dress shoulder board. Supplied in Pairs. |
| 18. | 814-2146 | D01380 | SHOULDER BOARD, RANK, MAJOR, THE ROYAL REGIMENT OF SCOTLAND | Twisted gilt wire with black cord. 1 metal crown. No1 dress shoulder board. Supplied in Pairs. |
| 19. | 814-2147 | D01381 | SHOULDER BOARD, RANK, LIEUTENANT COLONEL, THE ROYAL REGIMENT OF SCOTLAND | Twisted gilt wire with black cord. 1 metal crown & 1 metal star. No1 dress shoulder board. Supplied in Pairs. |