



**Technical Specification for**  
**BRAID, CORD, LACE, BADGES and EMBROIDERY GOLD GILT**  
**BRAID, CORD, LACE, BADGES and EMBROIDERY SILVER GILT**

**Defence Clothing (DC)**

PROPERTY OF  
MINISTRY OF DEFENCE



PREFACETABLE 1 – PRODUCT LIST

<b>Item Name</b>	BRAID, CORD, LACE, BADGES and EMBROIDERY GOLD GILT BRAID, CORD, LACE, BADGES and EMBROIDERY SILVER GILT
<b>Development File No.</b>	
<b>Product Support File No.</b>	
<b>NATO Stock Numbers</b>	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
04	Item 5: Updated labelling requirements Item 6: Added manufacture information Item 7: update packaging information	04 December 2013
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

<b>Specification/Document</b>	<b>Detail</b>
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"> <li>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.</li> </ul>
4.2 Metal Wires	<ul style="list-style-type: none"> <li>Metal wires used shall be copper electroplated with silver.</li> <li>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.</li> <li>Silver wires shall be finished with a clear lacquer.</li> <li>Gold wires shall be finished with a gold lacquer.</li> </ul>
4.3 Composite Yarns	<ul style="list-style-type: none"> <li>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.</li> </ul>
4.4 Metal Embroidery Threads	<ul style="list-style-type: none"> <li>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.</li> <li>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.</li> </ul>

TABLE 4 – PRODUCT COMPONENTS Continued

4.5 Ground Cloths for badges & chevrons	<ul style="list-style-type: none"> <li>• For badges manufactured from Melton ground cloth, the cloth is to be light Melton as specified in UK/SC/5516.</li> <li>• Colour of ground cloth is to be as standard pattern</li> </ul>
4.6 Backing cloth	<ul style="list-style-type: none"> <li>• <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</li> <li>• <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.</li> <li>• Or an alternative approved by DC.</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Braids and cords	<ul style="list-style-type: none"> <li>• 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.</li> <li>• Braiding shall be carried out to give an even braid, free from manufacturing defects.</li> <li>• The finished width of the braid or cord, number of spindles, braiding ends and plaits per cm shall comply with the requirements specified. *</li> </ul>
5.2 Laces	<ul style="list-style-type: none"> <li>• 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. *</li> <li>• 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.</li> </ul>
5.3 Embroidery	<ul style="list-style-type: none"> <li>• 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.</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION Continued

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

#### 4. PHYSICAL REQUIREMENTS

BS ISO 6348 describes mass. A mass tolerance of  $\pm 5$  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	D01
Light	Rubbing	Dry cleaning
6	Dry	Colour change
	Wet	
	4 – 5	5

5. LABELLING REQUIREMENTS:

SPECIMEN LABEL

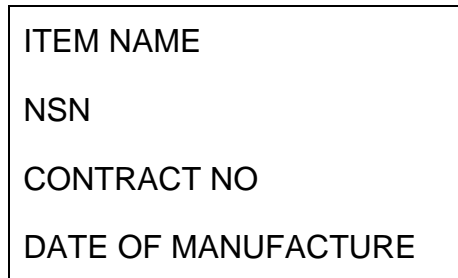


Figure 1. Example Identification and Marking label

6. MANUFACTURE INFORMATION

Under no circumstances should the contractor's name, logo or trademark appear on the badge or on the packaging.

7. PACKAGING

- a. Each NSN item is to be individually wrapped (pairs or each, as necessary) and then sealed in a polythene bag.
- b. The bag shall be identified with a clearly printed pressure sensitive self adhesive label firmly adhered to the outside of the package.
- c. Information and format on the label is to be as follows:  
Item name as stated in figure 1, NATO Stock Number, Contract Number, and Date of Manufacture.
- d. 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.