



**Technical Specification for  
LANCE, CEREMONIAL**

**Defence Clothing (DC)**

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TABLE 1 – PRODUCT LIST

Item Name		LANCE, CEREMONIAL	
TL Number	NATO Stock Number	Designation	Pattern Number
TL1028647	7810-99-456-1997	Lance	28625A

**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

<b>Issue No.</b>	<b>Comments</b>	<b>Issue Date</b>
03	Pattern number corrected to 28625A TL number added to Table 1 Para 4, Packaging, updated	03 May 2018
02	Reformatted specification. Corrected Spec No BS EN 10088-2 Deleted Spec UK/SC/5551	26 July 2012
01	UK/SC Specification to supersede Specification S.A. 502B (24 Aug 1926)	24 January 2007

PART 1

1. THE PRODUCT

- a. Use of the Product: The lance is used for ceremonial duties, for example the Household Cavalry (Figure 1)

FIGURE 1: Ceremonial Duties



TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

<b>Specification/Document</b>	<b>Detail</b>
BS EN 301	Adhesives, phenolic and aminoplastic, for load-bearing timber structures: classification and performance requirements
BS EN 10088-2	Stainless steels Part 2: Technical delivery conditions for sheet/plate and strip of corrosion resisting steels for general purposes
BS EN 10283	Corrosion resistant steel castings
BS 2780	Glossary of leather terms
BS 7318	Specification for industrial sewing threads made from linen (flax) or cotton
UK/SC/5699	Leather vegetable tanned various

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: This specification describes the materials and components for the lance (shown in Figure 2.)

FIGURE 2: Lance



TABLE 4 – PRODUCT COMPONENTS

4.1 Sewing Thread	<ul style="list-style-type: none"> <li>• Thread, linen (flax) well bees – waxed, Metric Ticket No.18 three cord, to BS 7318 Table 2</li> <li>• Shade to match the leather</li> </ul>
4.2 Adhesive	<ul style="list-style-type: none"> <li>• Synthetic resin adhesive to BS EN 301 Type 1</li> </ul>
4.3 Stave	<ul style="list-style-type: none"> <li>• The stave is to be of solid bamboo or if hollow, the hole in the centre is not to exceed 6mm diameter at the Head end or 12mm diameter at the Shoe end. The bamboo is to be reasonable straight and the knots (nodes) cut (or ground) to the same diameter as the outer skin of the culm, so as to give a smooth even finish to the length of the stave</li> <li>• Diameter of Stave: Head end = 22mm +/- 1.0mm (just below the Head) Shoe end = 30mm +/- 1.0mm (just above the Shoe)</li> <li>• The stave is not to be overly flexible or liable to bow when the stave is held at the butt end and loaded with the steel Head at the spear end. A small deflection is permitted</li> <li>• The bamboo is to be free from bad shakes (splits or cracks), holes and worms (ghoons). Slight natural blemishes on the bamboo skin, such as black marks, dots or marks of rubbing due to contact with the culm during growth, will not be rejected, provided that the general appearance of the stave is not seriously affected, or the skin so injured as to weaken the stave</li> </ul>
4.4 Head & Shoe	<ul style="list-style-type: none"> <li>• The Head and Shoe are to be made from stainless steel to BS EN 10283, austenitic grade, GX5CrNiMo19-11-2, Number 1.4408 or an acceptable alternative agreed by DC</li> </ul>
4.5 Protector	<ul style="list-style-type: none"> <li>• The Protector is to be made of calfskin, dyed through to match the shade of the Standard Pattern. The leather must be full grain, cut from the butt and back</li> <li>• The leather is to conform to UK/SC/5699</li> </ul>
4.6 Sling	<ul style="list-style-type: none"> <li>• The Sling is to be made from a strip of leather, white-faced cowhide. The leather must be full grain, cut from the butt and back. The natural face side is to be dyed white, with the edging and underside coloured white</li> <li>• The leather is to conform to UK/SC/5699</li> </ul>
4.7 Thong	<ul style="list-style-type: none"> <li>• The Thong is to be made from a strip of leather, white-faced cowhide. The leather must be full grain, cut from the butt and back. The natural face side is to be dyed white, with the edging and underside coloured white</li> <li>• The leather is to conform to UK/SC/5699</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Measurements	<ul style="list-style-type: none"> <li>• All measurements specified are in millimetres unless otherwise stated</li> <li>• All Dimensions are to be as the Standard Pattern unless otherwise mentioned</li> </ul>
5.2 General	<ul style="list-style-type: none"> <li>• The Lance shall be manufactured strictly in accordance with that of the Standard Pattern with regards to quality &amp; workmanship</li> <li>• Overall length of the Lance = 2745mm +/-10mm</li> </ul>
5.3 Stave	<ul style="list-style-type: none"> <li>• Should the Stave be hollow, it is to be filled at the head end with an ash plug as far as the first joint (node), neatly and soundly glued in</li> <li>• The Stave at the Head end should be tapered to give a good close tolerance fit for the Head</li> <li>• The Stave at the butt end should be turned down to present a clean parallel face to give a good close tolerance fit for the Shoe</li> <li>• Particular note should be made to the diameter of the stave (see 4.3). Staves that are too thick become impractical for users to grip and they will not be accepted</li> </ul>
5.4 Head & Shoe	<ul style="list-style-type: none"> <li>• All external surfaces of the Head and Shoe are to be finished to BS EN 10088-2, special finish - bright polished 2P</li> <li>• The Head and Shoe are to be bored internally to match the diameter of each individual stave</li> <li>• The ends of the rivet are to be ground flush and blended into the Head/Shoe, and the area polished back to a bright polished 2P finish</li> <li>• The Head, Shoe and ends of the Stave are to be well coated with synthetic resin adhesive and glued together. When dry the Stave is to be drilled and a stainless steel rivet fitted. The ends of the rivet are to be ground flush to the Head/Shoe and the area polished back to a mirror finish</li> <li>• Length of Head = 320mm +/-1mm</li> <li>• Length of Shoe = 172mm +/-1mm</li> </ul>
5.5 Protector	<ul style="list-style-type: none"> <li>• Length = 455 to 460mm</li> <li>• Width = 115mm approximately (dependent on diameter of Stave)</li> <li>• Thickness 3mm + 0.0mm /- 0.5mm</li> <li>• To be sewn on wet</li> <li>• The Protector is to be fitted to the Stave 480mm +/- 5mm from the top of the shoe to the bottom of the protector</li> </ul>



TABLE 5 – PRODUCT CONSTRUCTION continued

5.6 Sling	<ul style="list-style-type: none"> <li>• Standard Pattern, leaving a loop approximately 350mm in length. Length = 900mm +/-1mm</li> <li>• Width = 25mm +/- 0.5mm</li> <li>• Thickness = 4mm + 0.0mm/-0.5mm</li> <li>• The cut length of leather for the Sling is to be overlapped by 205mm and sewn at each end of the overlap as per the standard pattern</li> </ul>
5.7 Thong	<p>The Sling is to be secured to the lance with a leather Thong</p> <ul style="list-style-type: none"> <li>• Length = 1220mm +/-1mm</li> <li>• Width = 6mm +/- 0.5mm</li> <li>• Thickness = 4mm + 0.0mm / -0.5mm</li> <li>• The leather thong is to be wrapped around the double part of the sling and the stave nine times, trimmed and secured with a wood screw as per the standard pattern. The top (closest to the head end) of the lacing is to be 280mm +/- 5mm from the balance of the lance</li> </ul>
5.8 Stitching	<ul style="list-style-type: none"> <li>• Stitching of the leather is to be hand-stitched, with no loose stitching and all ends securely fastened off. Stitching must not be proud of the leather</li> </ul>
5.9 Packaging	<ul style="list-style-type: none"> <li>• Each lance is to be packed in a cardboard tube with an overall length of 2945mm +/-10mm, capped at each end with a removable bung</li> <li>• The Head and Shoe are to be suitably protected to prevent damage to the bright polished finish</li> <li>• The lance is to be positioned centrally in the length of the tube and each end of the tube is to be filled with a suitable packing material, so as to prevent the lance moving</li> <li>• The removable bung is to be secured to prevent the lance coming out of the tube during transit</li> </ul>

4. PACKAGING AND LABELLING REQUIREMENTS

- a. Packaging and package labelling shall be as detailed in the contract conditions.
- b. Items shall be packaged in a way to prevent damage during transit and storage.
- c. Under no circumstances should the contractor's name, logo or trademark appear on the items or packaging.