



**Technical Specification for
BUGLE CORDS, BREAST CORDS,
DRUM TRACERS, TRUMPET CORDS,
CORDS AND TASSELS
FOR COLOURS AND STANDARDS**

Defence Clothing (DC)

PROPERTY OF
MINISTRY OF DEFENCE



PREFACE

TABLE 1 – PRODUCT LIST

Item Name		INSTRUMENT CORDS & TASSELS, BREAST CORDS	
NATO Stock No.	User	Description	Pattern No.
7720-99-125-0992	Household Cavalry	CORD TRUMPET FOR USE WITH BANNER	9836A
7720-99-137-6741	The Rifles and Gurkhas	CORD & TASSELS BUGLE & TRUMPET BLACK	21016
7720-99-428-7196	Various Army	CORD AND TASSELS BUGLE GREEN	2627A
7720-99-666-5769	Royal Marines Band Service	TRACER DRUM, WHITE PLAITED ROPE, PAIR	D00735
8415-99-446-3679	Royal Marines	CORD BREAST ROYAL SILK	V73431
8455-99-127-1680	ATC Bandsmen	CORD BREAST FOR WHITE	35/R/636
8455-99-127-9331	Royal Irish Rangers	CORD BREAST SILVER	19871
8455-99-282-2557	RMBS and Army Bands	AIGUILLETTE CORD BUGLE RED / YELLOW / BLUE	D00738
8455-99-666-5766 to 666-5768	RMBS and Army Bands	AIGUILLETTE CORD BREAST RED / YELLOW / BLUE	D00732
8455-99-975-1103	Infantry Regiments	CORD BREAST YELLOW	14583
8455-99-975-1106	The Rifles and Gurkha Regiments	CORD BREAST BLACK DRUMMERS	14581
8455-99-975-1109	Various Army	CORD BREAST BAND SCARLET / BLUE / YELLOW	15236
8455-99-975-1578	Queens Own Highlanders	CORD BREAST BLUE / GREY	29142
8345-99-977-8814	Army	CORD AND TASSELS, FLAG, CRIMSON AND GOLD	22243
8345-99-153-7868	Royal Navy	CORD AND TASSELS, FLAG, GOLD AND BLUE	D02331
8345-99-968-8963	Royal Air Force	CORD AND TASSELS, FLAG SILVER AND BLUE	D02366
8345-99-153-7869	Royal Air Force	CORD AND TASSELS, FLAG, GOLD AND BLUE	D02332

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
3	<p>Additions:</p> <p>8345-99-153-7868 Cord and Tassels, Flag, RN – D02331</p> <p>8345-99-968-8963 Cord and Tassels, Flag, RAF – D02366</p> <p>8345-99-153-7869 Cord and Tassels, Flag, RAF – D02332</p> <p>Removal of UK/SC/3933 Braid, Cord, Lace, Badges and Embroidery, Metal, Gold, Silver</p> <p>New Table 7: Wire Threads inserted</p> <p>Old Table 7: Renumbered to Table 8 and the specimen labels updated</p> <p>Section 4: Packaging & Labelling requirements updated</p>	22 January 2014
2	<p>Specification reviewed and reformatted</p> <p>The following NSN's deleted, 7720-99-: 122-2310 132-2122</p> <p>The following NSN's deleted, 8455-99-: 127-9332 132-2121 132-2131 975-1100 975-1101</p> <p>NSN 7720-99-137-6741 User - RGJ replaced by The Rifles</p> <p>Change to one pattern (D00732) for range of NSN's 8455-99-666-5766 to 666-5768</p> <p>Removal of following related documents as not referenced in this specification</p> <p>BS EN ISO 2060 BS ISO 6348 BS 947 UK/SC/5146</p>	20 September 2012

TABLE 2 – ISSUE RECORD continued

Issue No.	Comments	Issue Date																						
1	<p>Full specification review</p> <p>Addition of data sheets</p> <p>Rationalisation of dimensions and collation of like items as previously governed by the below specifications:</p> <p>UK/SC/4687</p> <table border="0"> <tr> <td>8415-99-446-3679</td> <td>8455-99-127-1680</td> </tr> <tr> <td>8455-99-127-9331</td> <td>8455-99-127-9332</td> </tr> <tr> <td>8455-99-132-2121</td> <td>8455-99-132-2131</td> </tr> <tr> <td>8455-99-975-1100</td> <td>8455-99-975-1101</td> </tr> <tr> <td>8455-99-975-1103</td> <td>8455-99-975-1106</td> </tr> <tr> <td>8455-99-975-1109</td> <td>8455-99-975-1578</td> </tr> </table> <p>UK/SC/4293</p> <table border="0"> <tr> <td>8455-99-666-5766</td> <td>8455-99-666-5767</td> </tr> <tr> <td>8455-99-666-5768</td> <td></td> </tr> </table> <p>UK/SC/3463</p> <table border="0"> <tr> <td>7720-99-122-2310</td> <td>7720-99-132-2122</td> </tr> <tr> <td>7720-99-137-6741</td> <td>7720-99-428-7196</td> </tr> <tr> <td>7720-99-666-5769</td> <td>8455-99-282-2557</td> </tr> </table> <p>UK/SC/5146</p> <p>7720-99-125-0992</p>	8415-99-446-3679	8455-99-127-1680	8455-99-127-9331	8455-99-127-9332	8455-99-132-2121	8455-99-132-2131	8455-99-975-1100	8455-99-975-1101	8455-99-975-1103	8455-99-975-1106	8455-99-975-1109	8455-99-975-1578	8455-99-666-5766	8455-99-666-5767	8455-99-666-5768		7720-99-122-2310	7720-99-132-2122	7720-99-137-6741	7720-99-428-7196	7720-99-666-5769	8455-99-282-2557	26 April 2007
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7720-99-666-5769	8455-99-282-2557																							

PART 1

1. THE PRODUCT

Use of the Product: Bugle Cords

Bugle Cords are worn by Bandsmen from various regiments as detailed in the Product List at table 1. The Bugle Cord is used so that the Bugle can hang freely at the side of the musician when not being held. Both ends of the cord are tied to the Bugle, forming a long strap that is passed over the head and onto the shoulder of the musician. The product is used by a variety of Bandsmen. This product is worn alongside the Breast Cord and should be matching in shade and style (See Figure 1).

Use of the Product: Breast Cords

Breast Cords are worn by Bandsmen from various regiments as detailed in the Product List at table 1. The Breast Cord is worn across the chest from the top buttonhole of the jacket, around the right-shoulder, back across the chest, finishing on the left-shoulder with the tassels hanging down at the front. This product is worn alongside the Bugle Cord and should be matching in shade and style (See Figure 1).

Use of the Product: Drum Tracers (Drag Ropes) RMBS Drum

These are supplied in pairs to the RMBS and are fixed to the drum such that they hang across the underside (See Figure 1).

FIGURE 1



1. THE PRODUCT continued

Use of the Product: Trumpet Cords HHC

The trumpet cord is a decorative cord that is tied off at both ends of the trumpet, so that a length of cord and tassel hang down at each end. The Household Cavalry Band Trumpeters uses the trumpet cord on State occasions or as ordered for other special ceremonial duties.

Use of the Product: Cord and Tassels, Colour Stand

The cord and tassel is a decorative cord that is tied off on the colour stand, so that the lengths of cord and tassels hang down. The cord and tassel is used with the Queens and Regimental Colours on special ceremonial occasions.

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105	Textiles. Tests for colour fastness
Part B02	Colour fastness to artificial light: Xenon arc fading lamp test
Part X12	Colour fastness to rubbing
Part E01	Colour fastness to water

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: Bugle Cords

Bugle Cords consist of a length of cord with a decorative tassel at each end in the same materials and colours. The cord and tassels are manufactured so that the tassels may be adjusted along the length of the cord, enabling the end user to set the length of cord to suit the individual's height.

b. Product Description: Breast Cords

Breast Cords consist of a length of cord with 2 plaited sections, 2 tassels, 2 turks heads and hooks for attachment.

c. Product Description: Drum Tracers (Drag Ropes) RMBS Drum

Drum Tracers consist of a length of cord with a central hand plaited section and knotted at each end.

d. Product Description: Trumpet Cord HHC

The Trumpet Cord consists of a length of braided cord with a decorative tassel at each end in the same material and colour.

e. Use of the Product: Cord and Tassels, Colour Stand

The Colour Stand Cord and Tassel consists of a length of braided cord with a turk's head and decorative tassel at each end in the same material and colour.

TABLE 4 – PRODUCT COMPONENTS

<p>4.1 Main Material Cord</p>	<ul style="list-style-type: none"> • Materials to give a comparable appearance and performance to the Standard Pattern. Acceptable materials include worsted wool, mercerised cotton, continuous filament viscose rayon, metallised polyester and 2% gold wire and thread, as appropriate • Should gold wire be used: Thread, gold wire as on the Standard Pattern and to meet requirements of Table 7. Size gauge as on standard pattern. Colour fastness is to comply with the requirements of Table 6 • Threads and yarns are to be of uniform thickness, are to be spun and folded evenly, be reasonably free from knots, short lengths and other defects • The shades of the coloured threads or yarns are to match those of the Standard Pattern unless otherwise specified by the tender or contract, and are to comply with the colour fastness requirements test in Table 6 • The contractor is responsible for using such counts of yarns as will produce a product to match the Standard Pattern • The data sheets define the yarns used in each item together with the yarn count. Yarn Count is defined in the metric system (nm) i.e. the number of kilometres of yarn per kilogram
<p>4.2 Core Threads</p>	<ul style="list-style-type: none"> • Cord core threads are to be 100% cotton, without impurities, un-dyed or dyed to a close shade of the darkest main material. Where coloured core threads are to be used they must meet the same levels of colour fastness as required in the main material • Cord core threads with excessive surface fibre or types producing lumpy cord are not acceptable
<p>4.3 Turks heads</p>	<ul style="list-style-type: none"> • Turks heads are worked onto a centre of PVC tubing or an approved alternative
<p>4.4 Turks heads String</p>	<ul style="list-style-type: none"> • Turk's head string is to be manufactured from the same yarns as used in the main material
<p>4.5 Sewing thread</p>	<ul style="list-style-type: none"> • All sewing threads are to be in a bonded nylon ticket 40's or an approved alternative
<p>4.6 Tassels</p>	<ul style="list-style-type: none"> • Moulds are to be Birch wood or an approved alternative • Fringes are to be manufactured from the same yarns as used in the main material • String is to be manufactured from the same yarns as used in the main material • Yarn for wrapping is to be the same as in the main material
<p>4.7 Hooks</p>	<ul style="list-style-type: none"> • The hooks size 15mm long, brass, nickel or black japanned as detailed in the datasheets and standard patterns

TABLE 5 – PRODUCT CONSTRUCTION

<p>5.1 General</p>	<ul style="list-style-type: none"> • Table 1 lists all products governed by this specification together with NATO stock numbers, pattern numbers, descriptions and users • The Data Sheets in Part 3 lists the bill of materials, manufacturing information, dimensions and images for each NSN listed in Table 1 • All dimensions are to be taken laid straight, without kinks but without imparting undue stretch • The design and shape of all aspects of the product shall be strictly in accordance with the relevant standard pattern • Relevant Standard Patterns are to be used to govern shade, all data sheet shades are for guidance only • Products are to be free from all loose ends of thread and be delivered in a clean condition
<p>5.2 Turk's heads</p>	<ul style="list-style-type: none"> • Turk's heads should be adjustable yet hold position in wear but not permanently distort or damage the cord with repeated movement • Turk's head lattice work must be full, firm, with even patterning
<p>5.3 Turk's head string</p>	<ul style="list-style-type: none"> • Twisted, Braided or Knit Braided turk's head string is acceptable so long as it does not distract visually from the finished design of the standard pattern • Turk's head string ends are to be fixed firmly underneath lattice work
<p>5.4 Tassels</p>	<ul style="list-style-type: none"> • Tassels shall be formed over the mould, assembled and fitted in accordance with the standard pattern. They shall be formed in twisted yarn taken from the same batches as used on the main material. All ends are to be tucked away securely • Mould shape - is to match the standard pattern
<p>5.5 Stitching</p>	<ul style="list-style-type: none"> • All ply cords used are to be stitched to prevent the unravelling of the cord plies – Refer to figure 2 • BUGLE CORDS ONLY - The tassels are to run free on the cord to enable adjustment by the user
<p>5.6 Plaiting</p>	<ul style="list-style-type: none"> • The plaited cord sections at either end of the Breast Cords are to be stitched together with the knots lined together – Refer to figure 3

FIGURE 2 – Stitching for ply cords

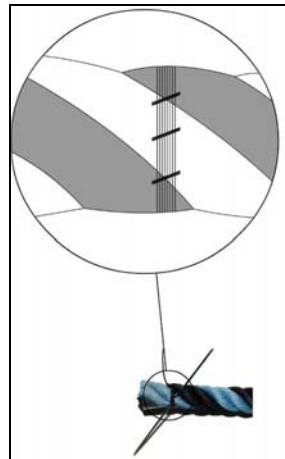


FIGURE 3 – Plaited section

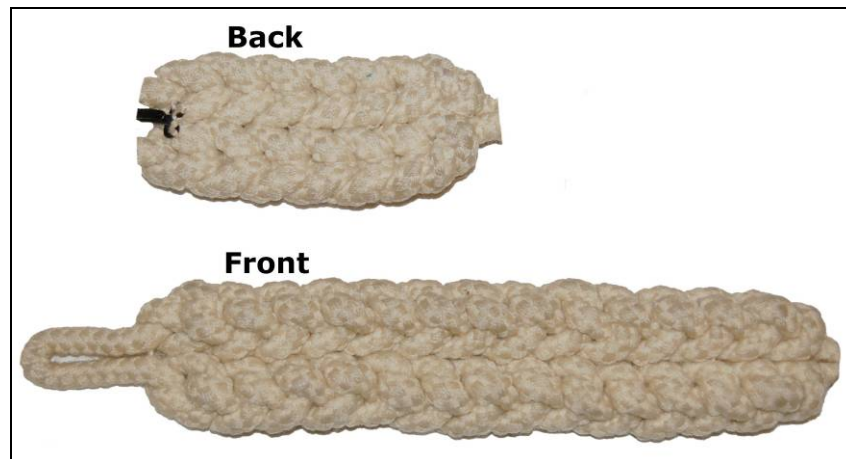


TABLE 6 – COLOUR FASTNESS REQUIREMENTS

Minimum ratings unless otherwise stated in the tender or contract

Method of Test BS EN ISO 105				
B02	E01		X12	
Light (XENON)	Water		Rubbing	
Colour Change	Colour Change	Staining	Colour Change	Staining
4-5	4-5	4-5	4	3

TABLE 7 WIRE THREADS/METAL EMBROIDERY

• Textile Yarn	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.
• Metal Wires	<p>Metal yarns used shall be electroplated gold and silver as appropriate.</p> <p>Compositions are made up as follows with minimum proportions stated for gold and silver metal elements.</p> <p>a. Gold – 2% gold, 1% silver, 97% white metal *</p> <p>b. Silver – 50% silver, 50% white metal</p> <p>* The white metal to be 95% copper, 5% nickel.</p>
• Composite Yarns	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.
• Metal Embroidery Threads	<p>All elements of metal, gold or silver embroidery must meet the minimum requirements in composition of gold and silver as stated in section 10.2.</p> <p>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.</p>
• Embroidery	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 7 WIRE THREADS/METAL EMBROIDERY continued


• Appearance	Tarnished items are not acceptable. Embroidery and metal yarns shall be manufactured to the highest standard and free from objectionable defects. Shall be of even width, construction and appearance and be correct and uniform throughout
• Finish	Items are to be free from cracks
• Pliability	The completed embroidery and colour tassels shall be of equivalent pliability to the relevant Standard Pattern

4. PACKAGING AND LABELLING REQUIREMENTS

- a. Each NSN is to be sealed in a clear polyurethane bag with a pressure sensitive self adhesive label affixed detailing the Item Description, NSN, Contract Number, Denomination and Year of Manufacture.
- b. Additionally, all packaging requirements quoted in the terms & conditions of the contract are to be adhered to.
- c. Items should always be packaged in a way to prevent damage during transit and storage.
- d. Multiple quantities of the same individually packaged NSN's may be shipped in the same box. Mixed NSN multiple packaging is not permitted.
- e. Multiple packaging labels - Each outer package is to be clearly labelled with the Item Description, NSN, Contract Number, Quantity, Denomination and year of manufacture.
- f. Under no circumstances should the contractor's name, logo or trademark appear on any form of labelling.

TABLE 8 – SPECIMEN LABELS

Item Description NSN Contract Number Quantity Denomination Year of Manufacture: MM/YYYY	
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Item Description NSN Contract Number Denomination Year of Manufacture: MM/YYYY	
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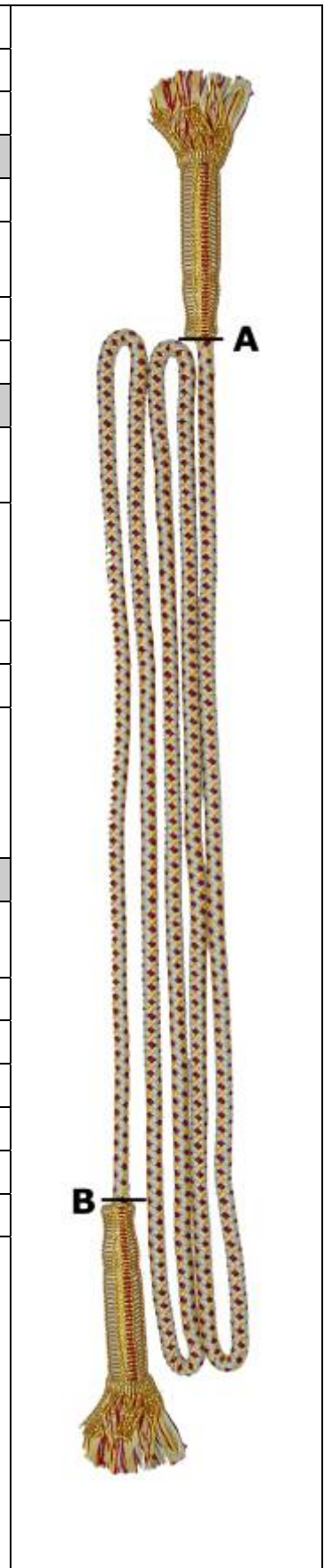
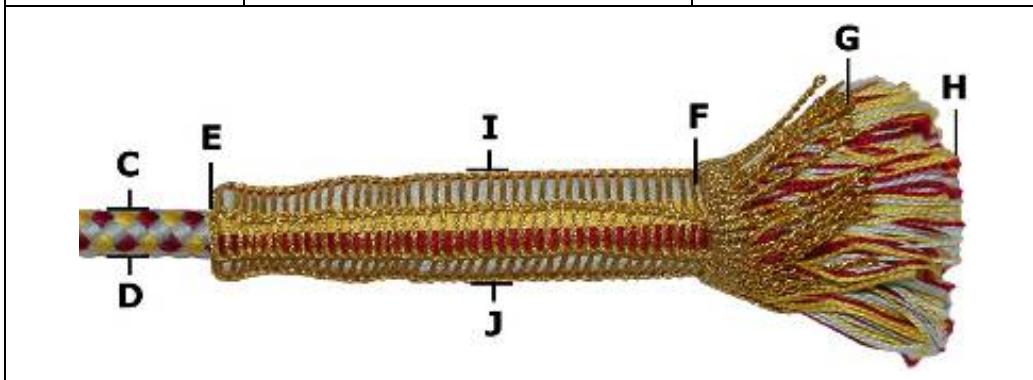
PART 3


5. DATA SHEETS

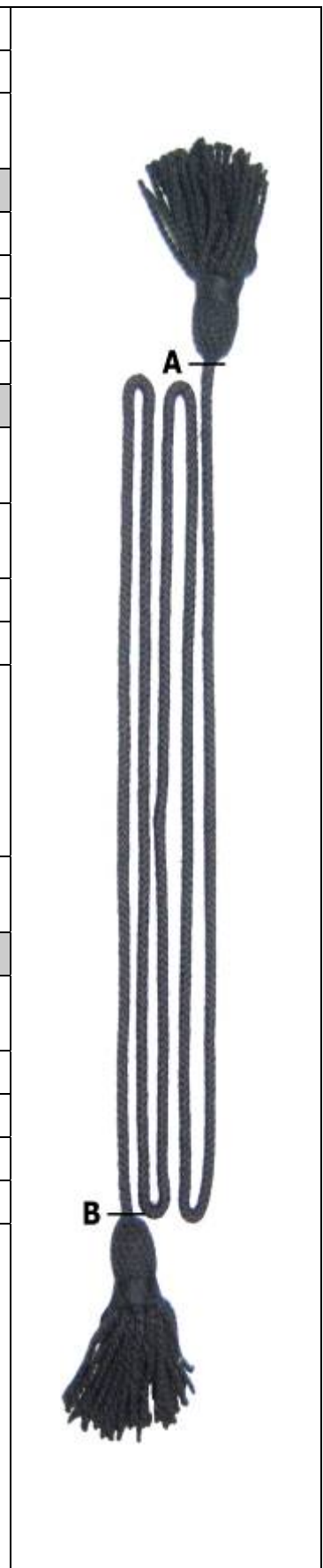
- a. The following section contains data sheets listing bill of materials, manufacturing information, dimensions and images for each NSN listed in table 1.
- b. Relevant Standard Patterns are to be used to govern shade, all shades depicted on data sheets are for guidance only.

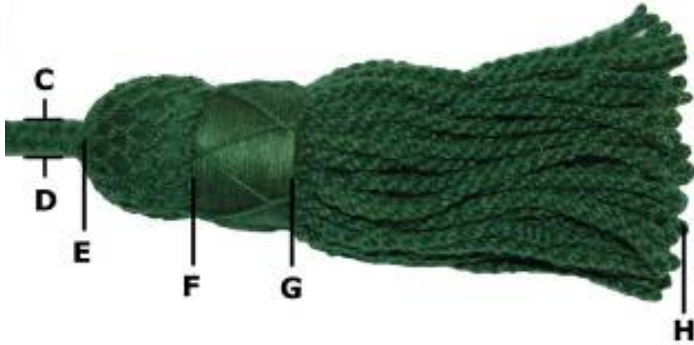
NSN	7720-99-125-0992
Pattern No.	9836A
Description	Cord Trumpet for use with Banner on HHC Trumpet
BILL OF MATERIALS	
Composition	Mercerised cotton and metallised polyester
Yarn Count	Metric 3/60nm cotton and metric 1/35nm metallised polyester
Shade	Maroon Pale Blue Yellow and Gold
Moulds	Birch Wood
MANUFACTURING COMPONENT INFORMATION	
Base Cord	Braided 16 spindles 8 pale blue 4 yellow 4 maroon Z direction 4 ends per spindle 2 over 2 plait
Fringe	Outer gold metallised polyester 46 - 50 twisted drops Inner Maroon Pale Blue Yellow cotton yarn mixture and matching standard pattern for volume
String	Braided 16 spindles gold metallised polyester
Trellis work	6 stitches 42 rows
Wrapping	All wrapping lay to be parallel and tight producing smooth contours and with yarn as used in base cord Over mould wrapping in bands of Maroon Pale Blue Yellow

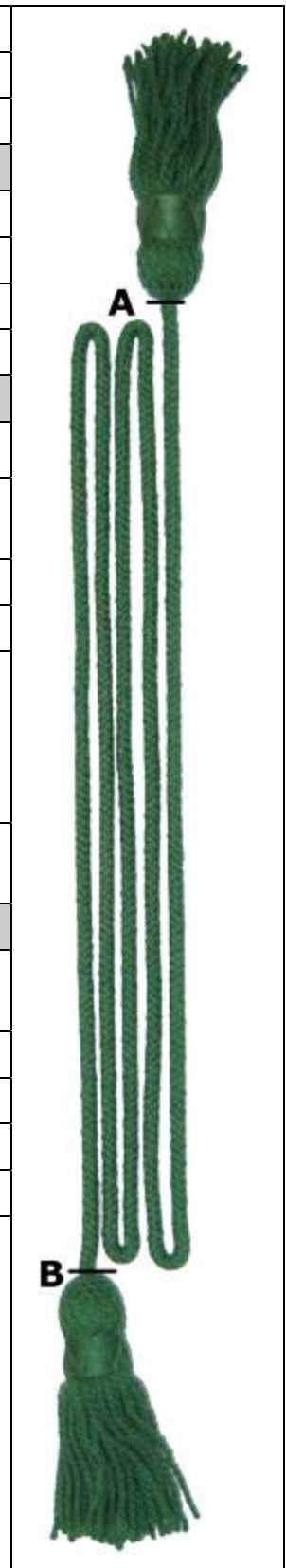
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	2940	20
C to D	Ø 8	0.5
E to F	90	3
F to G	32	2
F to H	46	2
I to J	20	2



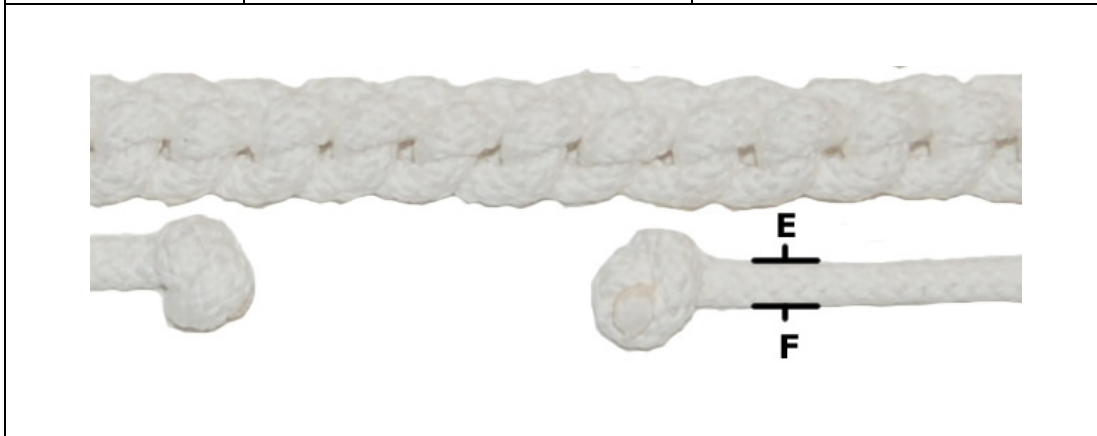
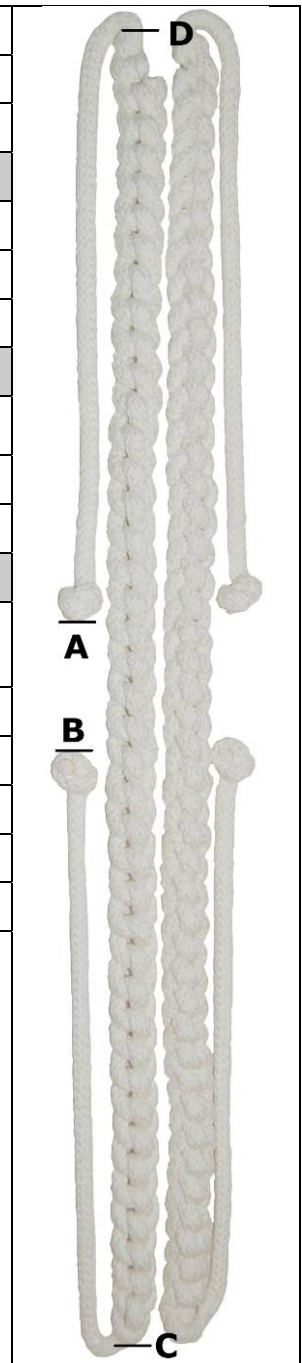
NSN	7720-99-137-6741	
Pattern No.	21016	
Description	Cord and Tassel Bugle Trumpet The Rifles and Gurkhas Black	
BILL OF MATERIALS		
Composition	Worsted Wool	
Yarn Count	Metric 3/22nm	
Shade	Black	
Moulds	Birch Wood	
MANUFACTURING COMPONENT INFORMATION		
Base Cord	Braided 16 spindles 4 yarn ends per spindle 2 over 2 plait	
Fringe	60 drops per shade each of 2 x 4 yarn ends, 2 ply S twist. 5 to 6 turns per 5cm.	
String	Twisted	
Trellis work	16 stitches with rows 8 rows from tassel top	
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in black Tassel waist wrapping in black, yarn ends not to be visible	
Criss-cross	Black criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping	
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	2440	20
C to D	Ø 8	0.5
E to H	130	6
F to G	15	2
		



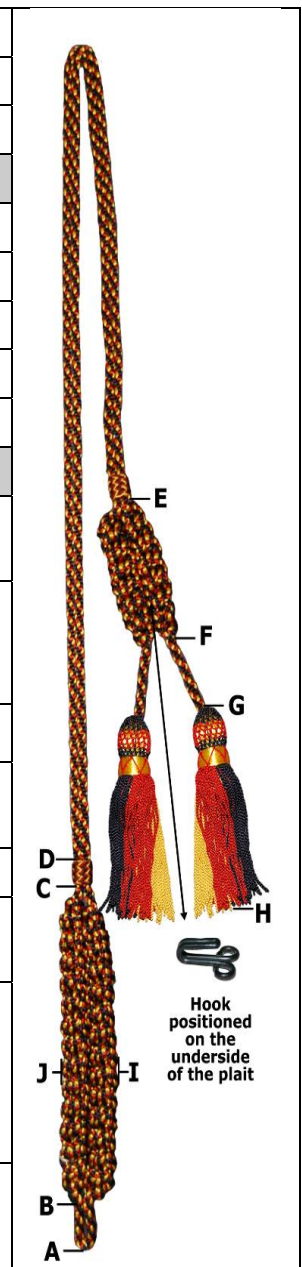
NSN	7720-99-428-7196	
Pattern No.	2627A	
Description	Cord and Tassel Bugle Trumpet Green	
BILL OF MATERIALS		
Composition	Worsted Wool	
Yarn Count	Metric 3/22nm	
Shade	Green	
Moulds	Birch Wood	
MANUFACTURING COMPONENT INFORMATION		
Base Cord	Braided 16 spindles 4 yarn ends per spindle 2 over 2 plait	
Fringe	60 drops per shade each of 2 x 4 yarn ends, 2 ply S twist. 5 to 6 turns per 5cm.	
String	Twisted	
Trellis work	16 stitches with rows 8 rows from tassel top	
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in green Tassel waist wrapping in green, yarn ends not to be visible	
Criss-cross	Green criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping	
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	2440	20
C to D	∅ 8	0.5
E to H	130	6
F to G	15	2
		



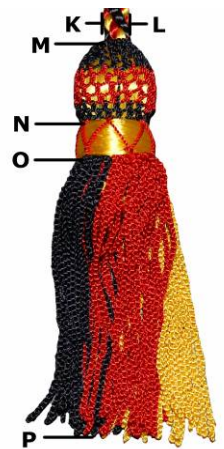
NSN	7720-99-666-5769	
Pattern No.	D00735	
Description	Tracer Drum White Plaited Rope Pairs RMBS	
BILL OF MATERIALS		
Composition	Cotton	
Yarn Count	Metric 4/20nm	
Shade	Bleached white	
MANUFACTURING COMPONENT INFORMATION		
Base Cord	Braided 24 spindles, 1 yarn ends per spindle, 2 over 2 plait	
Plaiting	8 hand plaits per 10 cm	
Knots	Cord ends finished neatly in a secure tight knot	
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	1120	20
C to D	560	6
A to D	280	2
B to C	280	2
E to F	Ø 8	0.5



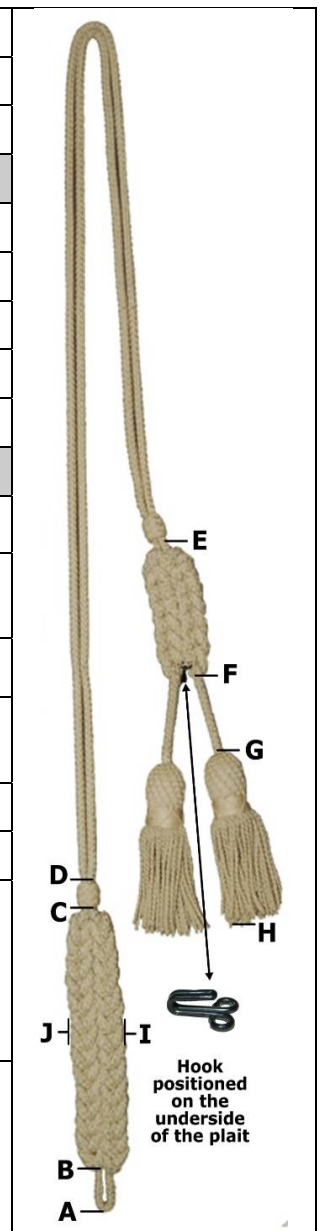
NSN	8415-99-446-3679
Pattern No.	V73431
Description	Cord Breast, Royal Silk Bugle Major Royal Marines
BILL OF MATERIALS	
Composition	Rayon
Yarn Count	Metric 1/30nm
Shade	Blue / Scarlet / Gold
Moulds	Tassels – Birch Wood, Turk’s Heads - PVC
Hooks	15mm brass black enamel
MANUFACTURING COMPONENT INFORMATION	
Base Cord	4 ply S twist (each 2 ply Z) cable twisted. 4 to 5 turns per 10 cm
Turk’s Heads	6 x 5 lattice pattern adjustable. (1 gold / 2 blue / 2 red) Worked on PVC centres with ends fixed firmly underneath lattice work
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side
Fringe	24 drops per shade each of 2 x 4 yarn ends, 2 ply, 10 to 11 turns per 5cm
String	Twisted
Trellis work	16 stitches with 9 rows sequenced from tassel top - 3 x blue, 3 x red, 3 x blue
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in gold Tassel waist wrapping in gold, yarn ends not to be visible
Criss-cross	Red criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping



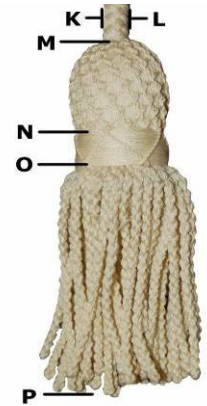
CONTINUATION OF 8415-99-446-3679		
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	45	6
B to C	200	6
C to D	18	2
C to E	1050	20
E to F	120	6
F to G	55	2
A to H	1625	20
I to J	50	4
K to L	Ø 8	0.5
M to P	155	6
N to O	15	2



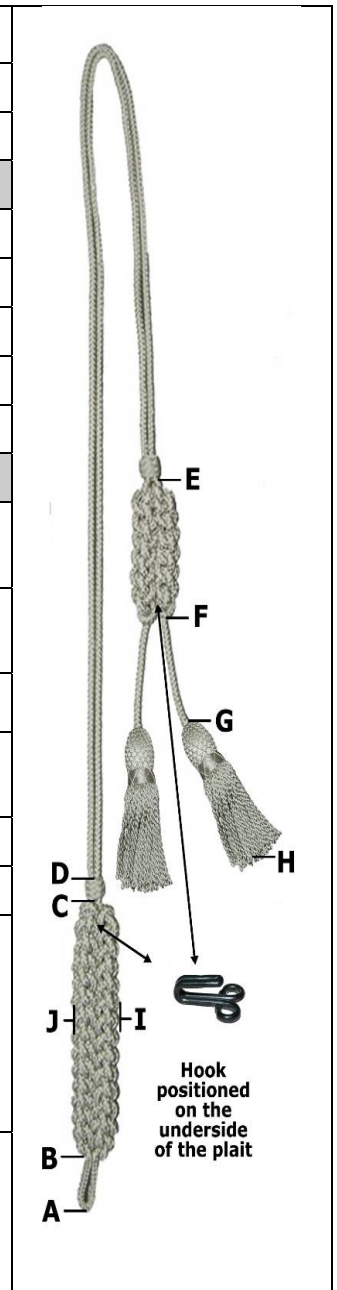
NSN	8455-99-127-1680
Pattern No.	35/R/636
Description	Cord Breast, White ATC
BILL OF MATERIALS	
Composition	Worsted Wool
Yarn Count	Metric 3/11nm
Shade	White
Moulds	Tassels - Birch Wood, Turk's Heads - PVC
Hooks	15mm brass black enamel
MANUFACTURING COMPONENT INFORMATION	
Base Cord	Braided 16 spindles, 2 yarn ends per spindle 2 over 2 plait
Turk's Heads	6 x4 lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side
Fringe	53 drops each of 2 x 4 yarn ends, 2 ply, 5 to 6 turns per 5cm
String	Twisted
Trellis work	16 stitches with 9 rows
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in white Tassel waist wrapping in white, yarn ends not to be visible
Criss-cross	White criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping



CONTINUATION OF 8455-99-127-1680		
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	45	6
B to C	200	6
C to D	18	2
C to E	1050	20
E to F	120	6
F to G	55	2
A to H	1600	20
I to J	50	4
K to L	Ø 8	0.5
M to P	130	6
N to O	15	2



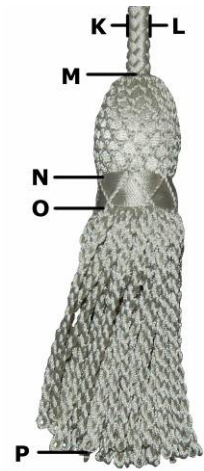
NSN	8455-99-127-9331
Pattern No.	19871
Description	Cord Breast, Royal Irish Rangers
BILL OF MATERIALS	
Composition	Polyester
Yarn Count	Metric 3/12nm
Shade	Silver Grey
Moulds	Tassels - Birch Wood, Turk's Heads - PVC
Hooks	15mm brass black enamel
MANUFACTURING COMPONENT INFORMATION	
Base Cord	Braided 16 spindles, 2 yarn ends per spindle 2 over 2 plait
Turk's Heads	6 x 4 lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side
Fringe	54 drops each of 2 x 8 yarn ends, 2 ply S twist, 5 to 6 turns per 5cm
String	Twisted
Trellis work	16 stitches with 9 rows
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in silver grey Tassel waist wrapping in silver grey, yarn ends not to be visible
Criss-cross	Silver Grey criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping




CONTINUATION OF 8455-99-127-9331

DIMENSIONS

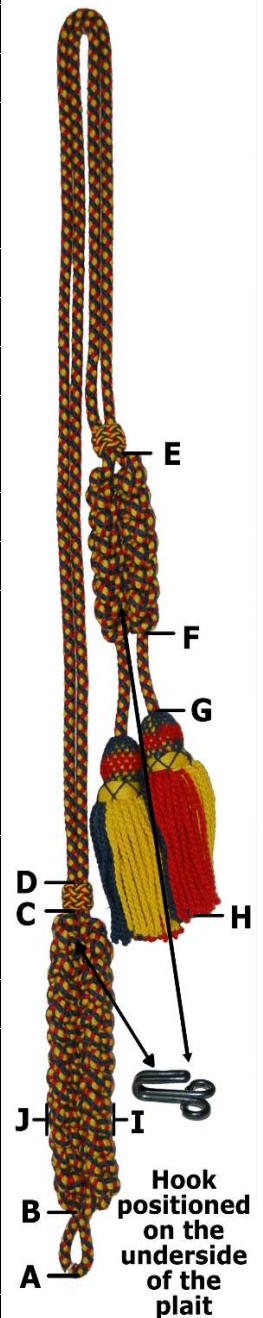
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	45	6
B to C	200	6
C to D	18	2
C to E	1050	20
E to F	120	6
F to G	55	2
A to H	1600	20
I to J	50	4
K to L	Ø 8	0.5
M to P	130	6
N to O	15	2



NSN	8455-99-282-2557	
Pattern No.	D00738	
Description	Aiguillette Cord Bugle, Red / Yellow / Blue	
BILL OF MATERIALS		
Composition	Worsted Wool	
Yarn Count	Metric 3/22nm	
Shade	Blue / Red / Yellow	
Moulds	Birch Wood	
MANUFACTURING COMPONENT INFORMATION		
Base Cord	Braided 16 spindles - 8 of blue S direction and 4 each of red and yellow 4 yarn ends per spindle, 2 over 2 plait	
Fringe	20 drops per shade each of 2 x 4 yarn ends, 2 ply S twist, 5 to 6 turns per 5cm	
String	Twisted	
Trellis work	16 stitches with rows sequenced from tassel top - 3 x blue, 3 x red, 3 x blue	
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in yellow Tassel waist wrapping in yellow, yarn ends not to be visible	
Criss-cross	Blue criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping	
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	2440	20
C to D	Ø 8	0.5
E to H	130	6
F to G	15	2
		



NSN	8455-99-666-5766 to 5768	
Pattern No.	D00732	
Description	Aiguillette Cord Breast, Red / Yellow / Blue	
Sizes	Small	NSN - 8455-99-666-5766
	Medium	NSN - 8455-99-666-5767
	Large	NSN - 8455-99-666-5768
BILL OF MATERIALS		
Composition	Worsted Wool	
Yarn Count	Metric 3/22nm	
Shade	Blue / Red / Yellow	
Moulds	Tassels - Birch Wood, Turk's Heads - PVC	
Hooks	15mm brass black enamel	
MANUFACTURING COMPONENT INFORMATION		
Base Cord	Braided 16 spindles, 8 of blue S direction and 4 each of red and yellow 4 yarn ends per spindle 2 over 2 plait	
Turk's Heads	6 x 3 (1 row of each shade) lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work	
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side	
Fringe	20 drops per shade each of 2 x 4 yarn ends, 2 ply S twist, 5 to 6 turns per 5cm	
String	Twisted	
Trellis work	16 stitches with 9 rows sequenced from tassel top - 3 x blue, 3 x red, 3 x blue	
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord	
	Over mould wrapping in yellow Tassel waist wrapping in yellow, yarn ends not to be visible	
Criss-cross	Blue criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping	



CONTINUATION OF 8455-99-666-5766 to 5768			
DIMENSIONS			
Reference Points	Distance between reference points in mm		Tolerance +/- mm
A to B	45		6
B to C	200		6
C to D	18		2
C to E	Small	870	20
	Medium	990	20
	Large	1110	20
E to F	120		6
F to G	55		2
A to H	Small	1420	20
	Medium	1540	20
	Large	1660	20
A to H	1420		20
I to J	50		4
K to L	Ø 8		0.5
M to P	130		6
N to O	15		2

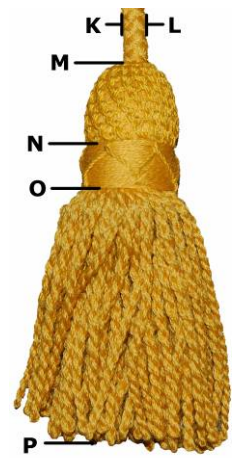


NSN	8455-99-975-1103	
Pattern No.	14583	
Description	Cord Breast, Yellow, Bandsman, Trumpeter and Bugler, Infantry Regiments	
BILL OF MATERIALS		
Composition	Worsted Wool	
Yarn Count	Metric 3/22nm	
Shade	Yellow	
Moulds	Tassels - Birch Wood, Turk's Heads - PVC	
Hooks	15mm brass black enamel	
MANUFACTURING COMPONENT INFORMATION		
Base Cord	Braided 16 spindles, 4 yarn ends per spindle 2 over 2 plait	
Turk's Heads	6 x 4 lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work	
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side	
Fringe	57 drops each of 2 x 4 yarn ends, 2 ply, 5 to 6 turns per 5cm	
String	Twisted	
Trellis work	16 stitches with 9 rows	
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in yellow Tassel waist wrapping in yellow, yarn ends not to be visible	
Criss-cross	Yellow criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping	

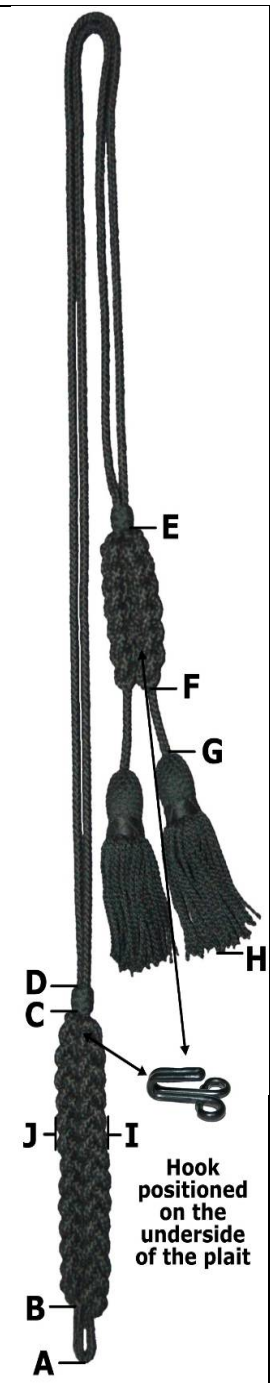
CONTINUATION OF 8455-99-975-1103

DIMENSIONS

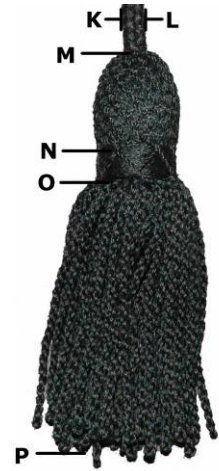
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	45	6
B to C	200	6
C to D	18	2
C to E	1050	20
E to F	120	6
F to G	55	2
A to H	1600	20
I to J	50	4
K to L	Ø 8	0.5
M to P	130	6
N to O	15	2



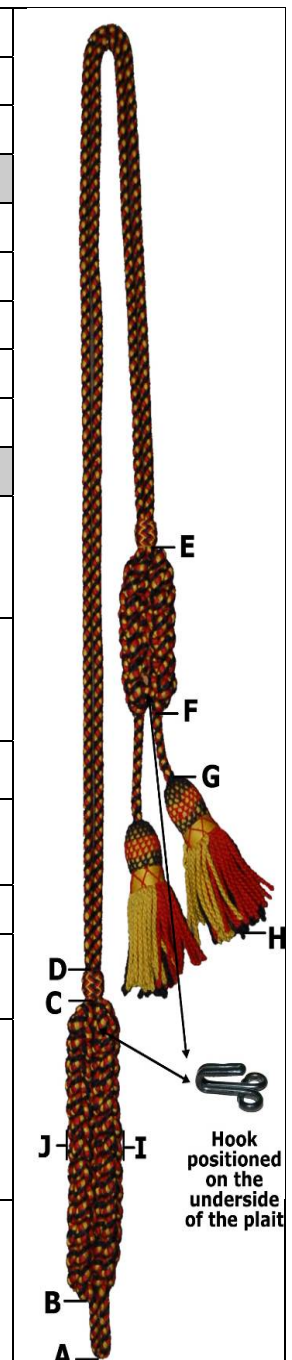
NSN	8455-99-975-1106
Pattern No.	14581
Description	Cord Breast, Black, Drummers, The Rifles and Gurkha Regiments
BILL OF MATERIALS	
Composition	Worsted Wool
Yarn Count	Metric 3/22nm
Shade	Black
Moulds	Tassels - Birch Wood, Turk's Heads - PVC
Hooks	15mm brass black enamel
MANUFACTURING COMPONENT INFORMATION	
Base Cord	Braided 16 spindles, 4 yarn ends per spindle 2 over 2 plait
Turk's Heads	6 x 4 lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side
Fringe	54 drops each of 2 x 4 yarn ends, 2 ply, 5 to 6 turns per 5cm
String	Twisted
Trellis work	16 stitches with 9 rows
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in black Tassel waist wrapping in black, yarn ends not to be visible
Criss-cross	Black criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping



CONTINUATION OF 8455-99-975-1106		
DIMENSIONS		
Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	45	6
B to C	200	6
C to D	18	2
C to E	1050	20
E to F	120	6
F to G	55	2
A to H	1600	20
I to J	50	4
K to L	Ø 8	0.5
M to P	130	6
N to O	15	2



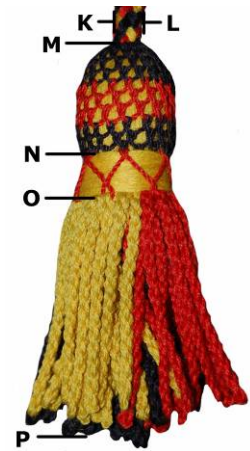
NSN	8455-99-975-1109
Pattern No.	15236
Description	Cord Breast, Band, Scarlet / Blue / Yellow
BILL OF MATERIALS	
Composition	Worsted Wool
Yarn Count	Metric 3/22nm
Shade	Scarlet /Blue / Yellow
Moulds	Tassels - Birch Wood, Turk's Heads - PVC
Hooks	15mm brass black enamel
MANUFACTURING COMPONENT INFORMATION	
Base Cord	Braided 16 spindles, 8 of blue Z direction and 4 each of red and yellow 4 yarn ends per spindle 2 over 2 plait
Turk's Heads	6 x 5 lattice pattern adjustable (1 yellow / 2 red / 2 blue) Worked on PVC centres with ends fixed firmly underneath lattice work
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side
Fringe	16 drops per shade each of 2 x 4 yarn ends, 2 ply, 5 to 6 turns per 5cm
String	Twisted
Trellis work	16 stitches with 9 rows sequenced from tassel top 3 x blue, 3 x red, 3 x blue
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in yellow Tassel waist wrapping in yellow, yarn ends not to be visible
Criss-cross	Red criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping



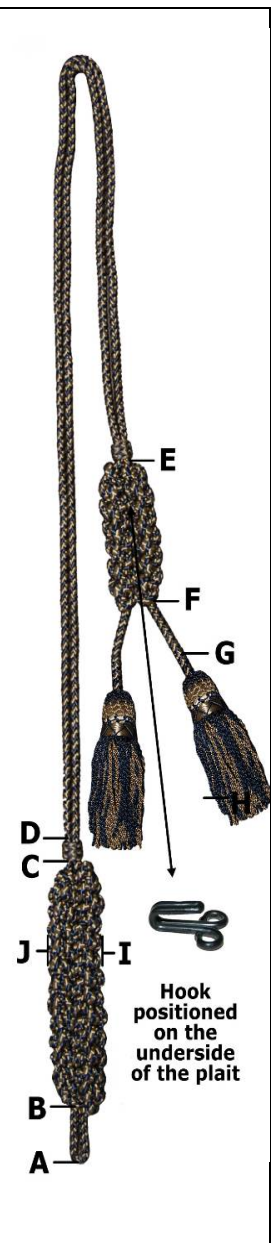
CONTINUATION OF 8455-99-975-1109

DIMENSIONS

Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	45	6
B to C	200	6
C to D	18	2
C to E	1050	20
E to F	120	6
F to G	55	2
A to H	1600	20
I to J	50	4
K to L	Ø 8	0.5
M to P	130	6
N to O	15	2



NSN	8455-99-975-1578
Pattern No.	29142
Description	Cord Breast, Blue / Grey, Queens Own Highlanders
BILL OF MATERIALS	
Composition	Rayon
Yarn Count	Metric 1/30nm
Shade	Blue and Grey
Moulds	Tassels – Birch Wood, Turk’s Heads - PVC
Hooks	15mm brass black enamel
MANUFACTURING COMPONENT INFORMATION	
Base Cord	Braided 16 spindles Z direction 8 spindles per shade 15 yarn ends per spindle 2 over 2 plait
Turk’s Heads	6 x 4 (2 rows of each grey and blue) lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work
Plaiting	7 plaits per 10 cm. Plaits stitched securely side by side
Fringe	33 drops per shade each of 2 x 4 yarn ends, 2 ply, 5 to 6 turns per 5cm
String	Twisted
Trellis work	16 stitches with 9 rows sequenced from tassel top 3 x grey, 3 x blue, 3 x grey
Wrapping	All wrapping lay to be parallel and tight producing smooth contours using yarn as in base cord Over mould wrapping in grey Tassel waist wrapping in grey, yarn ends not to be visible
Criss-cross	Blue criss-cross 6 points repeat top and bottom evenly spaced over waist wrapping

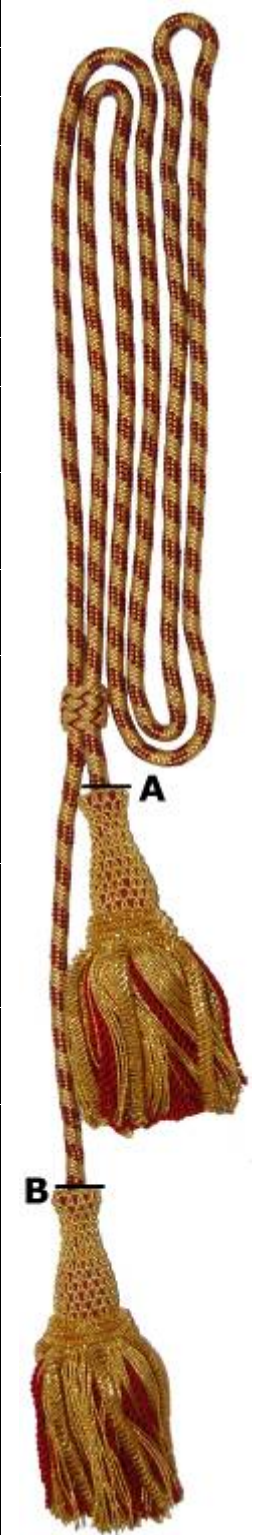


CONTINUATION OF 8455-99-975-1578

DIMENSIONS

Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	45	6
B to C	200	6
C to D	18	2
C to E	1050	20
E to F	120	6
F to G	55	2
A to H	1600	20
I to J	50	4
K to L	Ø 8	0.5
M to P	130	6
N to O	15	2

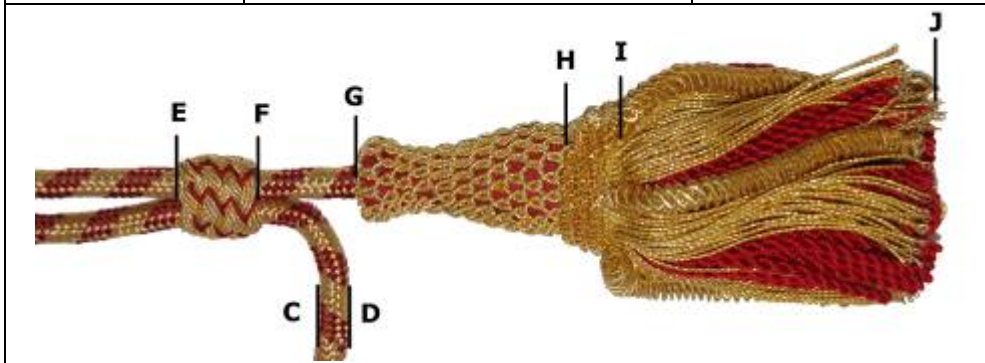


NSN	8345-99-977-8814	
Pattern No.	22243	
Description	Cord and Tassels, Flag, Army	
BILL OF MATERIALS		
Yarn composition and count	2% gold wire 71 micron 2% gold thread Metric 2nm Mercerised Cotton Metric 3/60nm	
Shade	Gold and crimson	
Cloth	Silk super lute, Shade to match, Crimson Pattern 8292U. NSN 8305-99-973-0919	
Moulds	Tassels - Birch Wood. Turk's Heads – PVC	
MANUFACTURING COMPONENT INFORMATION		
Gold	All gold materials to comply with the requirements of Table 7	
Cord	Braided 24 spindles, 16 x 4 yarn ends of gold and 8 x 3 yarn ends of crimson, S direction 2 over 2 plait	
Turk's Head	6 x 4 (3 rows gold 1 row crimson) lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work	
Fringe	Crimson, 88 drops, size and twist as standard pattern Gold, 168 drops, size and twist as standard pattern Bullion, 5 drops, size and twist as standard pattern	
String	Twisted	
Trellis work	12 stitches with rows 16 rows from tassel top	
Wrapping	Mould covering in crimson super lute cloth. Tassel waist wrapping in bullion, ends not to be visible	


CONTINUATION OF 8345-99-977-8814


DIMENSIONS

Reference Points	Distance between reference points in mm	Tolerance +/- mm
A to B	2032	20
C to D	Ø 7	0.5
E to F	18	2
G to J	127	5
H to I	10	1



NSN	8345-99-153-7868	
Pattern No.	D02331	
Description	Cord and Tassels, Flag, Royal Navy	
BILL OF MATERIALS		
Yarn composition and count	2% gold wire 71 micron 2% gold thread Metric 2nm Mercerised Cotton Metric 3/60nm	
Shade	Gold and Blue	
Cloth	Silk super lute, Shade to match Blue Pattern 8292R. NSN 8305-99-973-0916	
Moulds	Tassels - Birch Wood. Turk's Heads – PVC	
MANUFACTURING COMPONENT INFORMATION		
Gold	All gold materials to comply with the requirements of Table 7	
Cord	Braided 24 spindles, 16 x 4 yarn ends of gold and 8 x 3 yarn ends of blue, S direction 2 over 2 plait	
Turk's Head	6 x 4 (3 rows gold 1 row blue) lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work	
Fringe	Blue, 88 drops, size and twist as standard pattern Gold, 168 drops, size and twist as standard pattern Bullion, 5 drops, size and twist as standard pattern	
String	Twisted	
Trellis work	12 stitches with rows 16 rows from tassel top	
Wrapping	Mould covering in blue super lute cloth. Tassel waist wrapping in bullion, ends not to be visible	
DIMENSIONS		
Please refer to Pattern No 22243 for dimensions		

NSN	8345-99-968-8963	
Pattern No.	D02366	
Description	Cord and Tassels, Flag, Royal Air Force	
BILL OF MATERIALS		
Yarn composition and count	2% silver wire 71 micron 2% silver thread Metric 2nm Mercerised Cotton Metric 3/60nm	
Shade	Silver and Blue	
Cloth	Silk super lute, shade to match, RAF Blue Pattern 8122A. NSN 8345-99-324-9878	
Moulds	Tassels - Birch Wood. Turk's Heads – PVC	
MANUFACTURING COMPONENT INFORMATION		
Gold	All silver materials to comply with the requirements of Table 7	
Cord	Braided 24 spindles, 16 x 4 yarn ends of silver and 8 x 3 yarn ends of blue, S direction 2 over 2 plait	
Turk's Head	6 x 4 (3 rows silver 1 row blue) lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work	
Fringe	Blue, 88 drops, size and twist as standard pattern Silver, 168 drops, size and twist as standard pattern Bullion, 5 drops, size and twist as standard pattern	
String	Twisted	
Trellis work	12 stitches with rows 16 rows from tassel top	
Wrapping	Mould covering in blue super lute cloth. Tassel waist wrapping in bullion, ends not to be visible	
DIMENSIONS		
Please refer to Pattern No 22243 for dimensions		

NSN	8345-99-153-7869	
Pattern No.	D02332	
Description	Cord and Tassels, Flag , Royal Air Force	
BILL OF MATERIALS		
Yarn composition and count	2% gold wire 71 micron 2% gold thread Metric 2nm Mercerised Cotton Metric 3/60nm	
Shade	Gold and Blue	
Cloth	Silk super lute, shade to match RAF Blue Pattern 8122A. NSN 8345-99-324-9878	
Moulds	Tassels - Birch Wood. Turk's Heads – PVC	
MANUFACTURING COMPONENT INFORMATION		
Gold	All gold materials to comply with the requirements of Table 7	
Cord	Braided 24 spindles, 16 x 4 yarn ends of gold and 8 x 3 yarn ends of blue, S direction 2 over 2 plait	
Turk's Head	6 x 4 (3 rows gold 1 row blue) lattice pattern adjustable. Worked on PVC centres with ends fixed firmly underneath lattice work	
Fringe	Blue, 88 drops, size and twist as standard pattern gold, 168 drops, size and twist as standard pattern Bullion, 5 drops, size and twist as standard pattern	
String	Twisted	
Trellis work	12 stitches with rows 16 rows from tassel top	
Wrapping	Mould covering in blue super lute cloth. Tassel waist wrapping in bullion, ends not to be visible	
DIMENSIONS		
Please refer to Pattern No 22243 for dimensions		