



**Technical Specification for
FLAG, ORGANIZATIONAL,
Regimental Colours of the
Royal Marines (RM)**

Defence Clothing (DC)

PROPERTY OF
MINISTRY OF DEFENCE



PREFACE

TABLE 1 – PRODUCT LIST

Item Name (Generic):	FLAG, ORGANIZATIONAL, Regimental Colours of the Royal Marines (RM)	
NATO Stock No (NSN):	8345-99-869-0522	
	Item description:- FLAG, ORGANIZATIONAL	Pattern No.
	Regimental Colour, 40 Commando, RM	27663
	Regimental Colour, 42 Commando, RM	27663 TG
	Regimental Colour, 45 Commando, RM	27663 TG

NATO Stock No (NSN):	Item description:- (Ensemble Components for Queens Colour)	Pattern No.
8345-99-122-4809	MOUNT, ROYAL CREST	17014
8345-99-977-8814	CORD AND TASSELS, FLAG	22243 TG
8345-99-973-3226	SLING, FLAGSTAFF	1249A
8345-99-122-9124	PIKE	20164
8345-99-125-0989	CASE, FLAG	3344
8115-99-139-0345	CASE, WOOD	D02330

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
1	New specification superseding UK/SC/5356	23 January 2014

1. THE PRODUCT

- a. Use of the Product Description: The Regimental Colour is carried on ceremonial occasions. The colour stand ensemble comprises of the Colour, mount, cord and tassels, pike, sling, leather case and wooden case for transit.

FIGURE 1

FLAG ORGANIZATIONAL, Regimental Colour, 40 Commando, Royal Marines
Front view



Image for illustrative purposes only.

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 Part B02 Part E01 Part X12	Textiles. Tests for Colour fastness. Colour fastness to artificial light: Xenon arc fading lamp test Colour fastness to water Colour fastness to rubbing
BS EN 1049 Part 2	Textile. Woven fabrics. Construction. Method of Analysis. Determination of number of threads per unit length
BS EN 1773	Textiles. Fabrics. Determination of Width and Length
BS EN 12127	Textiles. Fabrics. Determination of mass per unit area using small samples
BS 946	Designation of yarns
BS 4973 Part 4	Interlinings. Woven sew in interlining
UK/SC/6422	Bugle Cords, Breast Cords, Drum Traces And Trumpet Cords
UK/SC/6719	Buff Leather Various Ceremonial Items
UK/SC/6723	Metal-Ware Various Ceremonial Items
UK/SC/6788	Ceremonial Items, Wood/Cane/Fibreglass
UK/SC/6844	Case Leather Standards Guidons And Colours
Shade Card for Silk Embroidery Threads	Available from DC, Pattern number 9561 as in Table 12

2. **PATTERNS**

- a. **Official Painting**: Copies of the official approved water-colour paintings supplied by the College of Arms, are obtainable from the DC and are to be used to provide the criteria for the detailed design for colours.
- 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.

3. PRODUCT DESIGN

- a. Flag, Organizational, Regimental Colour An embroidered and appliquéd reversible flag. The design is to follow the copy of the official approved water-colour painting supplied by The College of Arms
- b. Mount, Royal Crest Cast brass, electro gilt plated, lion and crown design. Fitted to top of staff
- c. Cord and Tassels, Flag The cord and tassels shall be made from alternate strands of gold wire and silk yarn. The shade of the silk yarn corresponds to the commando's lanyard.
- d. Pike Wooden staff with brass shoe at base and brass ferrule with two rings to secure cord and tassels
- e. Sling, Flagstaff Belt buff leather with gilt fittings for carrying the colour
- f. Case, Flag Leather case with polished brass top
- g. Case, wood Wooden Box for transporting finished stand of colours, nailed construction with screwed, removable lid

TABLE 4 – PRODUCT COMPONENTS

4.1 Main material	<p><u>Backing Cloth</u></p> <ul style="list-style-type: none"> • Cloth, silk super lute, Crimson. Pattern No. 8292U • Cloth, silk super lute, Blue. Pattern No. 8292R • Cloth, silk super lute, White. Pattern No. 8292A <p><u>Appliqué Cloth</u></p> <ul style="list-style-type: none"> • Cloth, silk super lute, refer to Table 12 for relevant shades • Construction and colour fastness to Table 7 and Table 9
4.2 Pike pocket	<ul style="list-style-type: none"> • Cloth, silk super lute, Crimson. Pattern No. 8292U
4.3 Pike pocket lining	<ul style="list-style-type: none"> • Holland 100% linen, as per standard pattern • Pattern No. T8443A (WS1), NSN: 8305-99-942-7523 or alternative approved by Defence Clothing • Specification: BS 4973 Part4
4.4 Yarn embroidery	<ul style="list-style-type: none"> • Silk yarn, dyed to shade to be as defined in the thread shade card Pattern 9561 available from DC. Refer to Table 12 for all relevant shades • Colour fastness is to comply with the requirements of Table 9.1
4.5 Wire threads	<ul style="list-style-type: none"> • Thread, gold wire as on the Standard Pattern and to meet requirements Table 10 • Size gauge as on standard pattern • Colour fastness is to comply with the requirements of Table 9.2
4.6 Metal eyelet	<ul style="list-style-type: none"> • Gilt metal, two part threaded eyelet • 16mm internal diameter, as on standard pattern
4.7 Mount, royal crest	<ul style="list-style-type: none"> • Pattern No. 17014, NSN: 8345-99-122-4809 • Specification UK/SC/6723
4.8 Cords and tassels, flag	<p><u>40 Commando</u></p> <ul style="list-style-type: none"> • Gold wire and light blue silk. Pattern No. 22243TG • Specification: UK/SC/6422 <p><u>42 Commando</u></p> <ul style="list-style-type: none"> • Gold wire and white silk. Pattern No. 22243TG • Specification: UK/SC/6422 <p><u>45 Commando</u></p> <ul style="list-style-type: none"> • Gold wire and scarlet silk. Pattern No. 22243TG • Specification: UK/SC/6422
4.9 Pike	<ul style="list-style-type: none"> • Pattern No. 20164, NSN: 8345-99-122-9124, • Specification UK/SC/6788
4.10 Sling, flagstaff	<ul style="list-style-type: none"> • Pattern No. 1249A, NSN: 8345-99-973-3226 • Specification UK/SC/6719

TABLE 4 – PRODUCT COMPONENTS continued

4.11 Case, leather	<ul style="list-style-type: none"> • Pattern No. 3344, NSN: 8345-99-125-0989 • Specification UK/SC/6844
4.12 Case, wood	<ul style="list-style-type: none"> • Pattern No. D02330, NSN: 8115-99-139-0345 • Specification UK/SC/6788

TABLE 5 – PRODUCT CONSTRUCTION

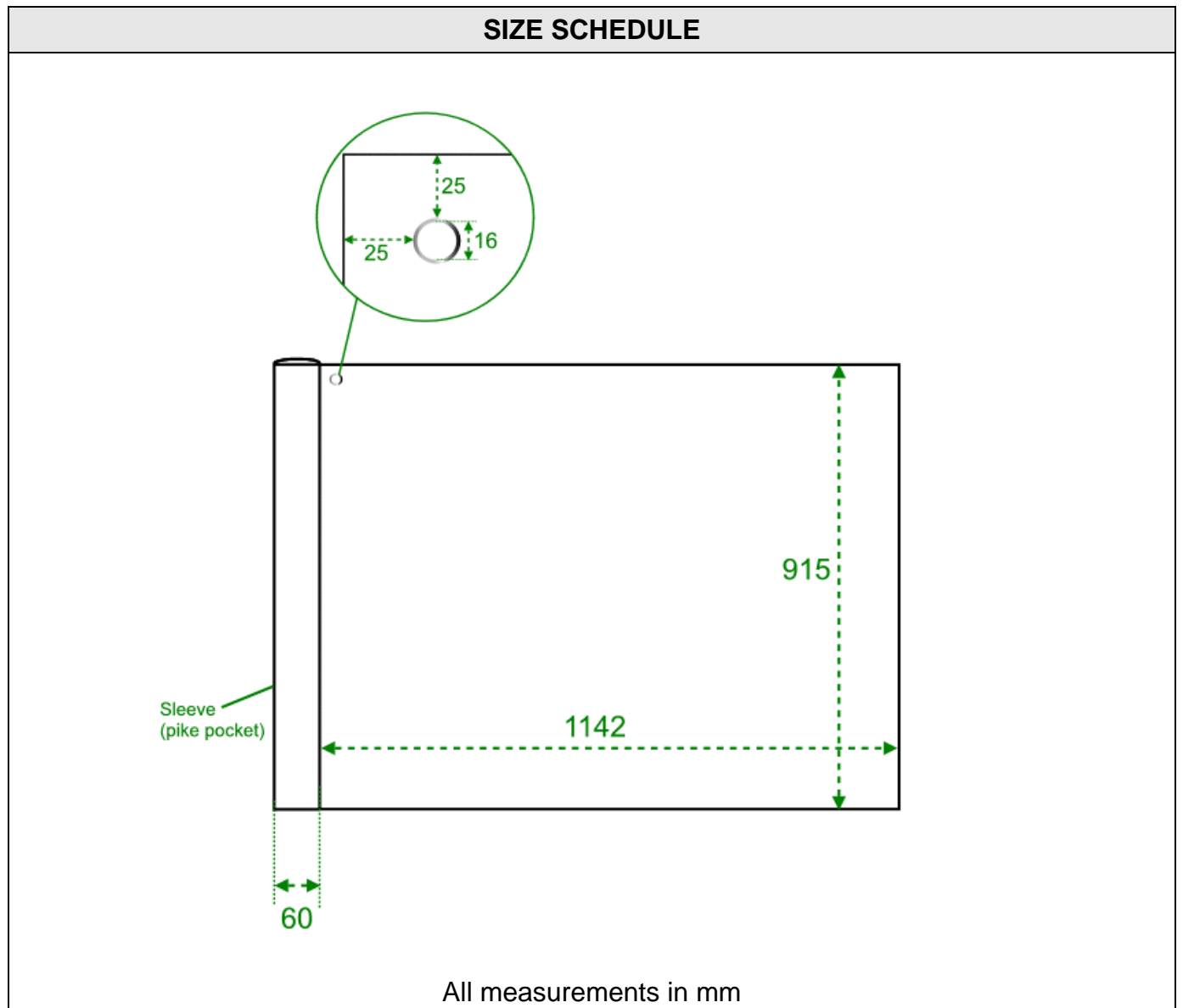


TABLE 6 – PRODUCT INFORMATION

<p>6.1 Fitting up</p>	<ul style="list-style-type: none"> • A small hole is to be cut in the top left corner of the union flag, with a clearance of approximately 25mm from the heading and top edge of the colour. • The area around the hole is to be strengthened with two patches of canvas covered in Cloth, Silk, Super lute, as main material. • The hole is further reinforced with a hand-sewn grommet and a gilt metal two part threaded eyelet of 16mm internal diameter inserted. • The cord is to be doubled at the centre; the bight passed through the metal eyelet and the rings on the top of the staff. The two tasselled ends are then passed through the bight and the cord pulled tight, after winding the top of the staff. • The cord tassels are to measure 685mm from the hole in the flag after fitting up.
<p>6.2 Assembly, storage and transportation</p>	<ul style="list-style-type: none"> • The colour, staff, mount, cords and tassels should be assembled for use. • The tassels on the cords should be wrapped in fully bleached, acid free lightweight unglazed tissue paper, care being taken that the cord is not twisted in the wrapping process • Fully bleached, acid free lightweight unglazed tissue paper be placed over the colour near the pike/staff and underneath the cord and tassels. This should be turned up and accommodated within the depth of the colour. • The colour should then be rolled with layers of sulphur free paper interleaved between the layers. • The mount in place on top of the colour should be covered in a protective packaging to ensure freedom from damage during transportation.
<p>6.3 Handling information</p>	<ul style="list-style-type: none"> • A statement is to be printed onto a label and adhered to the inside of the box lid. Refer to section 4 Table 11.

TABLE 7 – MATERIAL SCHEDULE

Ground cloth, Silk Super Lute requirements:

Property	Requirement	Method of test
Width (cm)	127 (minimum)	BS EN 1773
Mass g/m ²	130 +10% / -5%	BS EN 12127
Threads per cm Warp Weft	190 (minimum) 22 (minimum)	BS EN 1049-2
Composition Warp Weft	Pure Silk, Super Lute Silk, Organzine Silk, Tram	

TABLE 8 – EMBROIDERY SILKS

Embroidery yarns are to have the following construction:

Resultant denier	185	
Number of plies	2	
Single turns per cm	2.4	Direction of twist "Z"
Folding turns per cm	2.4	Direction of twist "S"
Resultant denier	588	
Number of plies	2	
Single turns per cm	3.1	Direction of twist "Z"
Folding turns per cm	3.0	Direction of twist "S"

TABLE 9 – COLOUR FASTNESS

9.1 The ground cloth and embroidery yarns are to comply with the following table for colour fastness.

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

TABLE 9 – COLOUR FASTNESS continued

9.2 The wire thread and all elements of metal, gold or silver embroidery are to comply with the following table for colour fastness.

Method of Test BS EN ISO 105		
B02	X12	
Light (XENON)	Rubbing	
Colour change	Dry	wet
6	4-5	

TABLE 10 – WIRE THREADS/METAL EMBROIDERY

10.1 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 9.2, and shall be of adequate strength and durability
10.2 Metal Wires	<ul style="list-style-type: none"> Metal yarns used shall be electroplated gold and silver as appropriate. Compositions are made up as follows with minimum proportions stated for gold and silver metal elements. <ol style="list-style-type: none"> Gold – 2% gold, 1% silver, 97% white metal * Silver – 50% silver, 50% white metal * The white metal to be 95% copper, 5% nickel
10.3 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
10.4 Metal Embroidery Threads	<ul style="list-style-type: none"> 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. 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
10.5 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 10 – WIRE THREADS/METAL EMBROIDERY continued

10.6 Appearance	<ul style="list-style-type: none"> 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
10.7 Finish	<ul style="list-style-type: none"> Items are to be free from cracks
10.8 Pliability	<ul style="list-style-type: none"> The completed embroidery and colour tassels shall be of equivalent pliability to the relevant Standard Pattern

4. LABELLING REQUIREMENTS

Labels	Colour	Position
Identification label	White	To be attached to the outside of the wooden case.
Handling information label	White	To be attached to the inside of the lid of the wooden case.

Identification Label

Information and format is to be as follows

Manufacturer Information

Under no circumstances should the contractor's name, logo or trademark appear on any form of labelling.

TABLE 11 – SPECIMEN LABELS

SPECIMEN LABELS

Identification Labels

<p>FLAG, ORGANIZATIONAL, Regimental Colour, 40 Commando, RM</p> <p>8345-99-869-0522</p> <p>Contract No:</p> <p>Year of Manufacture YYYY</p>	
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5. LABELLING REQUIREMENTS continued

TABLE 11 – SPECIMEN LABELS

**HANDLING INSTRUCTIONS FOR
COLOURS, STANDARDS AND GUIDONS**

Colours, Standards and Guidons are vulnerable items and require careful handling at all times. On no account are these items to be laundered or dry cleaned.

If an item becomes excessively soiled or marked consult with Defence Clothing Technical Team before attempting to clean.

Under no conditions are Colours, Standards, or Guidons to be packed away or rolled when wet. Should any of these items become wet they are to be dried carefully and thoroughly by being hung in a warm area and left to dry naturally. Never apply direct heat in an attempt to force dry. In hot and humid climates these items should be frequently aired and stored in a cool place. Ideally, when not in use on parade, they should be wrapped in sulphur-free paper and stored in the container in which they are issued. The continued display of these items involving exposure to bright sunlight and/or humidity causes rapid deterioration and should be limited to special occasions

TABLE 12 – PATTERN NO 9561 SHADE CARD FOR SILK EMBROIDERY THREADS

Reference used on Shade card	Reference used on Shade card
Red No 1	Purple No 1
Red No 2	Purple No 2
Red No 3	Purple No 3
Red No 4	Blue No 1
Red No 5	Brown No 1
Red No 6	Brown No 2
Yellow No 1	Brown No 3
Yellow No 2	Grey No 1
Yellow No 3	Grey No 2
Green No 1	Grey No 3
Green No 2	Black No 1
Green No 3	Cream No 1
Green No 4	
Green No 5	
Green No 6	
Green No 7	
Green No 8	
Green No 9	
Green No 10	
Green No 11	
Green No 12	
Green No 13	
Green No 14	

TABLE 13 – CLOTH, SILK SUPER LUTE, PATTERN NUMBER COLOURS TO THIS SPECIFICATION

Pattern No	Colour	NATO Stock Number
8122A	RAF Blue	8345-99-324-9878
8292A	White	8305-99-973-0931
8292B	Light Buff	8305-99-973-0918
8292C	Dark Buff	8305-99-973-0917
8292D	Yellow Primrose	8305-99-973-0934
8292E	Yellow No. 2 Primrose	8305-99-973-0935
8292F	Yellow Lemon	8305-99-973-0933
8292G	Yellow	8305-99-973-0932
8292H	Gosling Green	8305-99-973-0925
8292J	Green Grass	8305-99-973-0926
8292K	Green Lincoln	8305-99-973-0927
8292L	Green Emerald	8305-99-973-0924
8292M	Green Deep	8305-99-973-0923
8292N	Green Dark	8305-99-973-0922
8292P	Blue Empire	8305-99-973-0921
8292R	Blue	8305-99-973-0916
8292S	Purple	8305-99-973-0930
8292T	Maroon	8305-99-973-0928
8292U	Crimson	8305-99-973-0919
8292V	Black	8305-99-973-0915
8292W	Pearl Grey	8305-99-973-0929

NSN	8345-99-869-0522
Pattern No.	27763
Description	FLAG, ORGANIZATIONAL, Regimental Colours of the Royal Marines (RM)

DETAIL



This image is for illustrative purposes only.

MANUFACTURING INFORMATION

Design	<ul style="list-style-type: none"> • A flag design with embroidery and appliqué features • See size schedule Table 5 for dimensions • A blue flag with a small Union Flag in the canton nearest the pike head. There is a Queen's cypher surmounted by a St Edward's Crown in the other three corners. A fouled anchor interlaced with the cypher of George IV at the centre. Above that is, St Edward's Crown surmounted by a scroll inscribed 'Gibraltar'. Below is an image of the globe surrounded by a laurel wreath. Under that is a scroll inscribed with the Corps motto 'Per Mare Per Terram' with the relevant Commando numeral below. The cords and tassels are of gold interwoven with silks of the Commando's colour which corresponds to the Commando lanyards worn by all ranks. • Backing cloth: Cloth, Silk, Super lute, Blue. Refer to Table 4. • Small union flag in top left corner of the colour: Cloth, Silk, Super lute, Crimson, White and Blue. Refer to Table 4 • A staff (pike) pocket of the crimson silk and lined, is sewn on the left hand side of the colour • In the remaining three corners of the colour, an embroidered Queens Cypher appliquéd on surmounted by a St Edwards crown embroidered through. • In the centre, the Royal Cypher of George IV is interlaced with a fouled anchor surmounted by a St Edward's Crown embroidered through.
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CONTINUATION OF 8345-99-869-0522

MANUFACTURING INFORMATION continued

**Design
continued**

- Surmounting the St Edward's Crown, an appliquéd scroll in yellow, embroidered with 'GIBRALTER' in black.
- Below the fouled anchor and cypher the green laurel wreath is embroidered through, and the globe is worked off and appliquéd within the green laurel wreath.
- The regimental motto scroll is worked off and appliquéd below the globe and over laying the bottom of the laurel wreath, with wording 'PER MARE PER TERRAM' in black and embroidered below is the commando number.
- Cord and Tassels shall be made from alternate gold wire and silk yarn. Silk shade specific to 40, 42 and 45 Commando. Refer to Table 4.8.
- The whole design is to be placed centrally on the colour.