



Ministry  
of Defence



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Reference: FOI2024/13877

06 September 2024

I am writing about your email of 25 June 2024, requesting the following information:

*I am placing this request to receive the full manufacturing specifications for the standard No2 FAD and the order in which additional components are added and at what position for the royal Anglian regiment and the army cadet force*

And your subsequent email of 28 July 2024, in which you clarified your request:

*The dress I am requesting info for is in fact the No 2 (Service) dress. By additional components I mean the buttons, rank insignia, belts, sashes and other items such as shoes that are worn by the royal Anglian regiment that are worn on or as part of the No 2 Dress*

I am treating your correspondence as a request for information under the Freedom of Information Act 2000 (FOI Act).

A search for the information has now been completed within the Ministry of Defence (MOD), and I can confirm that information in scope of your request is held. The information in scope of your request is attached, as follows:

- Annex A – UK/SC/5735 Issue 07 Technical Specification for Shoes Service, Black Leather, Working dated 28 October 2019
- Annex B – DC/MS/6941 Issue 04 Manufacturing Specification for Shirt, Woman's, Stone, Long Sleeve, RM & RAF, Shirt, Woman's, Fawn, Long Sleeve, Army, All Ranks dated 07 January 2021
- Annex C – UK/SC/3907 Issue 15 Technical Specification for Buttons Anodised Aluminium Gold and Silver dated 04 February 2021
- Annex D – UK/SC/2124 Issue 18 Technical Specification for Badges and Insignia Anodized Aluminium Alloy dated 22 February 2021
- Annex E – DC/MS/6264-2 Issue 12 Manufacturing Specification for Jacket, Woman's, No. 2 Dress Army (Separate Items), Skirt, Woman's, No. 2 Dress Army (Separate Items) dated 10 May 2022
- Annex F – DC/MS/6263-2 Issue 11 Manufacturing Specification for Jacket, Man's, No. 2 Dress, Army, All Ranks (Jacket only), Trousers, Man's, No.2 Dress, Army, All Ranks (Trousers only) dated 11 May 2022

- Annex G – DC/MS/6951 Issue 04 Manufacturing Specification for Shirt, Mans, Long Sleeve, Various dated 20 February 2023
- Annex H – DC/MS/7108 Issue 01 Manufacturing Specification for Trousers, Woman's, No. 2 Dress, Army, All Ranks, The Royal Dragoon Guards, OR and The Royal Hussars, OR dated 22 May 2023
- Annex J – UK/SC/3736 Issue 27 Technical Specification for Cap, Service, Man's, No. 1 and No. 2 Dress, Regt and Corps (except Household Brigade) and the MOD Guard Service dated 08 February 2024

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Yours sincerely,

DE&S Policy Secretariat



**Technical Specification for  
SHOES SERVICE, BLACK LEATHER, WORKING**

**Defence Clothing (DC)**

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MINISTRY OF DEFENCE

PREFACE

TABLE 1 – PRODUCT LIST

<b>Item Name</b>	SHOES SERVICE, BLACK LEATHER, WORKING	
<b>Development File No</b>	DC IPT/DP 4/4/16	
<b>Product Support File No.</b>		
<b>Nato Stock No(s) &amp; Team Leidos (TL) Nos</b>	<b>Description</b>	<b>Pattern No(s)</b>
8435-99-297-6319 to 6348	Female Shoe without Toe cap	29468
8430-99-297-6231 to 6272	Male Shoe without Toe cap	29464
8430-99-297-6275 to 6316	Male Shoe with Toe cap	29465A
	<b>Last - Female</b>	D01256
	<b>Last - Male</b>	D01869

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IPR STATEMENT

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**Technical documents in this specification refer to the edition current at the date of tender or contract unless otherwise stated.**

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
7	Change to Standard Pattern no. for Male Shoe with Toe cap to 29465A TL Numbers added	28 October 2019
6	Minor amendments to :- Table 3 – Related Specifications and Documents - Change to Sample Packs Reference Number for 'Foreign Object Damage (FOD) free' – New Standard Pattern No.D02700 4.1 - Leather for uppers and linings reformatted with minimum thickness reduced for leather linings to 0.9 - 1.2mm 4.3 – Eyelet stay tape changed to 12 to 15mm 4.4 Stiffeners – Minimum of Hard 4.5 Toe Puff – Minimum of Hard 4.6 Threads – Polyester permitted for uppers Table 6 – Joint girth and fitting grade shall be 6.5mm Table 11 – FOD requirement amendment	25 February 2016
5	Amendment to clause 4.7, bullet point 1 – add 'and Hot Contact Resistance' after 'state of cure' Amendment to Table 4, clause 4.13 – Footbed Addition to Table 5, clause 5.8 – Quality Minor amendment to Tables 7 & 8 – Last – Joint Girth	12 June 2013
4	Removal of Extra Wide Male Shoe with toe cap, NSN range 8430-99-347-5249 to 5269 Special measures made obsolete All references and documents associated with 'hot molded on soles' removed Addition of the following standards:- BS EN ISO 5084, BS EN ISO 13934 Part 1, BS 2471 and BS 5131 Part 5.4 New clauses 4.10 & 4.11 added	23 March 2011
3	Reformatted with minor text changes Removal of Female shoe with toe cap Last information added Addition of SATRA TM 144	06 November 2009

TABLE 2 – ISSUE RECORD continued

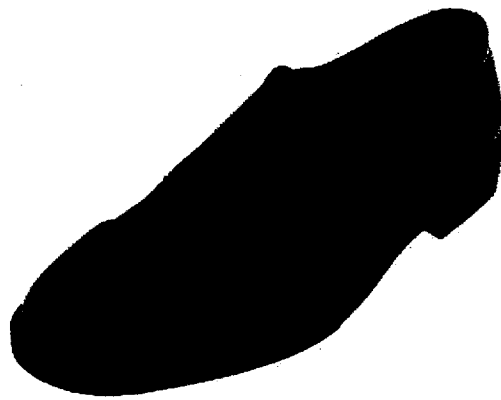
Issue No	Comments	Issue Date
2	Reformatted and Extra Wide Fitting Added Change of leather type. Updated Standard Nos	05 January 2005
1	This issue replaces the following specifications <ul style="list-style-type: none"> <li>• UK/SC/3359 Shoes Service, Black Leather, Direct Moulded Sole (DMS) – Youth's and Men's. 22 June 1993</li> <li>• UK/SC/3336 Shoes Service, DMS, Black leather. 27 May 1995</li> <li>• S&amp;TD/PS/P2822/1/96 Shoes Service, Black Leather, Working Non-Slip. 09 August 1996</li> <li>• UK/SC/4966 Shoes Service, DMS, Black leather, Non-marking "NP". 02 February 1996</li> </ul>	29 August 2002

PART 1

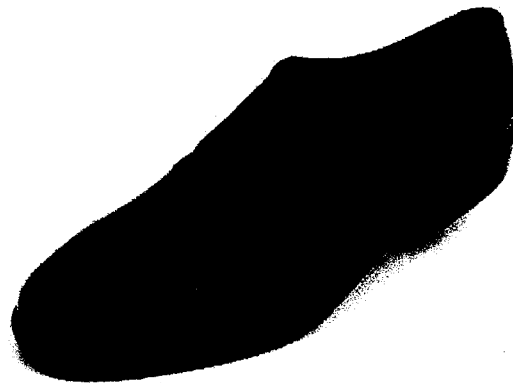
1. THE PRODUCT

- a Use of the Product. This Specification relates to leather Oxford Shoes, with or without toe caps, for non-safety related work duties ashore or on board ship for servicewomen and servicemen.

FIGURE 1: Illustrations of successful trial items:



Army and RAF Pattern



RN Pattern

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 5084	Textiles. Determination of thickness and textile products
BS EN ISO 13934 Part 1	Textiles. Tensile properties of fabrics Determination of maximum force and elongation at maximum force using the strip method
BS EN 12590	Textiles. Industrial sewing threads made wholly or partly from synthetic fibres
BS 2471	Methods of testing for textiles. Woven fabrics. Determination of mass per unit length and mass per unit area
BS 3870 Part 1	Titches and Seams Classification and Terminology of Stitch types
BS 5131 Part 5 Section 5.4	Methods of test for footwear and footwear materials Testing of complete footwear Sole bond peeling strength
BS 7141 Part 6	Narrow Fabrics Specification for laces for footwear and other purposes
UK/SC/2444	Toe puffs for Service footwear
UK/SC/3474	Stiffeners for service footwear
UK/SC/5611	Leather for footwear uppers and linings
UK/SC/5870	Shanks and insoles for service footwear
UK/SC/5907	Non-Leather soles for Service Footwear
Sample Packs Pattern Number D02700	'Foreign Object Damage (FOD) free'
SATRA TM 144	Physical Test Method for Slip Resistance
SATRA TM 223	Floor markings by soling or top pieces.
SATRA specifications and documents are obtainable from: SATRA Footwear Technology Centre, SATRA House, Rockingham Road, Kettering, Northants, NN16 9JH	

## 2. PATTERNS

- a. Master Patterns: DC holds a Master Patterns for these products. 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. Five eyelet, Oxford design upper, either with a plain vamp or with toecap.

A typical, but not definitive, sole tread pattern is shown at Figure 2.

Figure 2 - Typical sole tread pattern

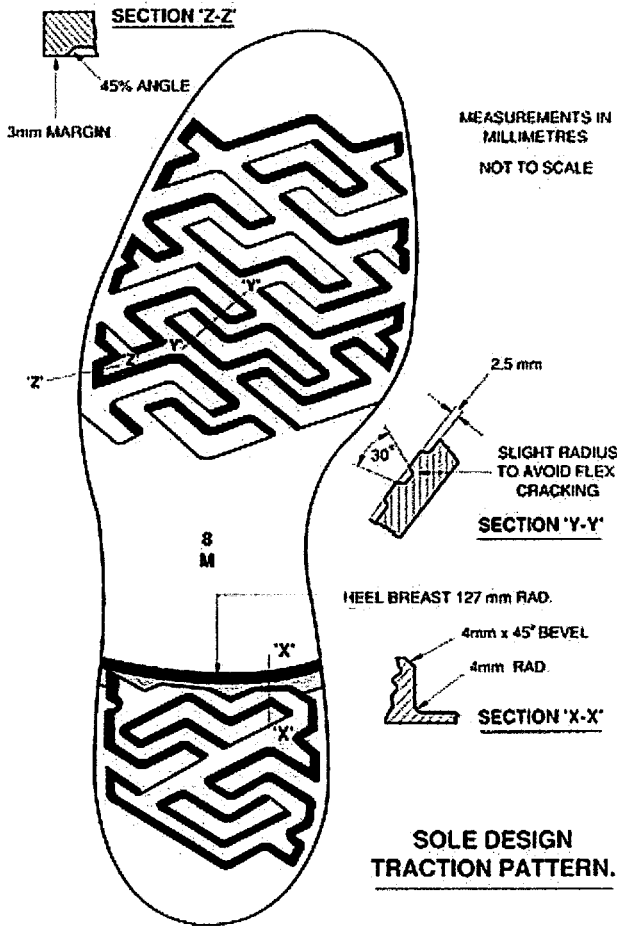


TABLE 4 – PRODUCT COMPONENTS

4.1 Leather for uppers and linings	<ul style="list-style-type: none"> <li>• Vamps, quarters and caps - Lightly corrected, black leather to UK/SC/5611 type B1, thickness 1.6 to 1.8mm as per the Standard Pattern.</li> <li>• Tongues - Lightly corrected, black leather to UK/SC/5611 type B1, thickness 1.0 to 1.2mm.</li> <li>• Leather for linings and Full Socks – Thickness 0.9 to 1.2mm, cow, colour to match Standard Pattern, complying with UK/SC/5611 Type A1.</li> </ul>
4.2 Insoles	<ul style="list-style-type: none"> <li>• Insoles, of 3mm thickness, complying with UK/SC/5870 performance level A</li> </ul>
4.3 Tape	<ul style="list-style-type: none"> <li>• The tape for back seams is to be nylon/polyester warp knit, pressure sensitive adhesive, coated, 14 to 15mm wide</li> <li>• Eyelet stay tape, non-woven pressure sensitive adhesive coated, 12 to 15mm wide</li> <li>• Beading reinforcement tape polyester/nylon, breaking load 150N (min)</li> </ul>
4.4 Stiffener	<ul style="list-style-type: none"> <li>• Minimum of Hard to Specification UK/SC/3474 performance grade 'B'</li> </ul>
4.5 Toe Puffs	<ul style="list-style-type: none"> <li>• Minimum of Hard to Specification UK/SC/2444 performance grade 'B'</li> </ul>
4.6 Threads	<p><u>Uppers</u></p> <ul style="list-style-type: none"> <li>• Thread is to be polyester or polyester/cotton corespun ticket No 36 for all sewing to Table 5 of BS EN 12590</li> </ul> <p><u>Soles</u></p> <ul style="list-style-type: none"> <li>• Sole sewing thread, where used, is to be polyester, 9 cord, colour black</li> </ul>
4.7 Sole Rubber Compound	<ul style="list-style-type: none"> <li>• Black, Butadiene-Acrylo-nitrile synthetic rubber, complying with UK/SC/5907 Table 4 Performance level A with the exception of 'state of cure' and Hot Contact Resistance.</li> <li>• Non-marking, when tested to SATRA TM 223 shall attain a rating of "slight to moderate"</li> <li>• Slip-resistant to SATRA TM 144</li> </ul>
4.8 Shank	<ul style="list-style-type: none"> <li>• 12 ± 1mm minimum Steel Fluted</li> </ul>
4.9 Tacks for Lasting	<ul style="list-style-type: none"> <li>• Tacks for lasting (if used only) are to be 8 ± 1mm</li> </ul>

TABLE 4 PRODUCT COMPONENTS continued

4.10 Lasting cement	<ul style="list-style-type: none"> <li>Hot melt, thermosetting quality</li> </ul>
4.11 Bottom Filler	<ul style="list-style-type: none"> <li>Granulated thermosetting composition or felt filler</li> </ul>
4.12 Eyelets	<ul style="list-style-type: none"> <li>Eyelets are to be nickel-plated blind type, 3mm internal diameter</li> </ul>
4.13 Footbed	<ul style="list-style-type: none"> <li>Non-woven 'welded' fabric type with nylon filament composition (Nylon 6 and Nylon 66), colour to match the quarter linings, the physical requirements of the material are to be as detailed in Table 10, combined to 3mm charcoal impregnated latex foam. The edge secured with a single row of stitching. Alternatively a leather facer to colour match the quarter lining is permitted.</li> <li>The seat region is to have a cut-out into which is secured, by adhesive, 3mm microporous polyurethane foam seat pad [Poron® has been found to satisfy the above requirements and is available from - Footwear Findings Ltd, Sheridan House, Bridge Industrial Estate, Speke Hall Rd., Liverpool L24 9HB]</li> </ul>
4.14 Laces	<ul style="list-style-type: none"> <li>Black cotton, tagged laces complying with BS 7141 Part 6 to the following size range: <ul style="list-style-type: none"> <li>Size 2 to 4½ lace length 600mm</li> <li>Size 5 to 9½ lace length 700mm</li> <li>Size 10 to 15 lace length 750mm</li> </ul> </li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Construction	<ul style="list-style-type: none"> <li>• Cement lasting reinforced with seat tacks and Blake sewing with bottoms formed by Pre-Moulded Sole (PMS) method</li> <li>• The Blake sewn stitch holes are to be sealed with a flexible sealant after stitching in a channel</li> </ul>
5.2 Lasts	<ul style="list-style-type: none"> <li>• Making lasts are to conform to last pattern number D01256 and D01869 in shape and dimensions of each size and fitting as stipulated in Tables 6 to 9</li> <li>• Standard Pattern lasts D01256 (ladies) and D01869 (men's) may be obtained from the DC</li> </ul>
5.3 Upper Closing	<ul style="list-style-type: none"> <li>• Stitch marking is to be by machine, stencil or removable ink and is not to be visible on the finished product. Prickers and indentations techniques are not acceptable</li> <li>• All upper components are to be skived and accurately fitted to the stitch marking</li> <li>• All seams are to be closed by lock-stitching, stitch type 301 of BS 3870 Part 1</li> <li>• Tops of the quarters are to be beaded and taped, and have a single row of sewing</li> <li>• Quarters, toe cap (if applicable) and tongue raw edges are to be stained</li> <li>• The quarters and toecaps (if applicable) are to have twin rows of sewing 3mm apart</li> <li>• Facings to have twin rows of decorative stitching 2mm apart</li> <li>• Tab stay to be stitched through quarters and tongue as per Standard Pattern</li> <li>• Back seams are to be taped and in-sewn and the extensions ('dog-ear') out-sewn. The in-sewn portion of the back seam is to be reinforced with self-adhesive cut fabric tape</li> <li>• The extension of the outside quarters over the inside quarters ('dog ear' style) is to be sewn as on the Standard Pattern</li> <li>• All seams are to have 10 to 12 stitches per 25mm. Excessively large needle holes are prohibited</li> <li>• Quarters are to be fitted with 5 blind eyelets spaced equidistantly over the available length</li> <li>• The uppers are to be laced, so that when lasted, the edge of the facings are 4 to 8mm apart for both the ladies and men's shoes, when measured level with the top eyelet pair</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION continued

5.4 Preparation	<ul style="list-style-type: none"> <li>• Insoles are to be moulded to conform to the bottom contour of the last and shall be temporarily attached, with a no tack system, to the last</li> </ul>
5.5 Making	<ul style="list-style-type: none"> <li>• Uppers are to be newly lasted and snugly bedded to the lasts</li> <li>• The lasting allowance is to be not less than 13mm at any point</li> <li>• The lasting allowance at the toe and seat is to be pounded and scoured to reduce unevenness and provide a clean and defined featheredge. The roughened area must not be visible after sole attachment</li> <li>• Seat lasting tacks (if used) are to be properly clenched</li> <li>• All round adhesive lasting, reinforced with tacks at the seat</li> <li>• A good proprietary brand of rubber or polyurethane based lasting adhesive is to be correctly applied according to the manufacturer's recommendations and care taken to ensure that seepage of adhesive onto the face of the insole or the exposed upper material does not occur</li> </ul>
5.6 Bottoming	<ul style="list-style-type: none"> <li>• The forepart cavity is to be completely filled</li> <li>• The outsole is to be attached under mechanical pressure to the upper according to the adhesive manufacturer's recommendations i.e. temperature and dwell time and shall meet the requirements of BS 5131 – Part 5 Section 5.4. The bond strength shall be a minimum of 4.0 N/mm unless the sole tears, then a minimum of 3.0 N/mm is required</li> <li>• Having been permanently attached with adhesive the sole is to be Blake sewn in a groove on the sole and the stitch holes sealed with an appropriate sealant. There are to be 3 to 4 stitches per 25mm using a No 47 awl and No 47 needle and employing polyester, colour to match the sole, 9 cord thread</li> <li>• At the start and end of the Blake sewing the thread ends are to be pulled through the insole into the shoe and neatly knotted or cemented down, in such a way as not to affect the comfort of the wearer. All sewing must penetrate the insole, no 'run-off' is permitted</li> <li>• At least 24 hours is to elapse from completion of the sole attaching operation before any tests are carried out</li> <li>• The shoes are to be suitable for use in Foreign Object Damage (FOD) free areas. That is the sole must not retain any foreign objects embedded in the material itself or the tread pattern when tested. Typical examples of "foreign objects", showing type and size, may be obtained from the DC in a "FOD free" sample package. Details of the procedure for "FOD free" testing are at Table 11</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION continued

5.7 Finishing	<ul style="list-style-type: none"> <li>• The uppers are to have a clean and smooth appearance</li> <li>• All shoes are to be inspected before the seat pad and footbed are fitted as specified</li> <li>• Each pair to be fitted with 1 pair of laces plus 1 spare pair</li> </ul>
5.8 Quality	<ul style="list-style-type: none"> <li>• All footwear making procedures are to be carried out such as to produce a high quality and aesthetically acceptable shoe. The quality of manufacture is to be such that the shoes are free from manufacturing faults. Typical examples of unacceptable faults are:             <ul style="list-style-type: none"> <li>a. Damage or contamination to upper and/or lining.</li> <li>b. Stitching not correctly finished off.</li> <li>c. Excessive roughing or over roughing.</li> <li>d. Poor sole attachment/adhesion.</li> <li>e. Poor attachment/or alignment of eyelets.</li> <li>f. Poor lasting or upper not tight to last shape</li> <li>g. Poor quality/finish/surface of leather upper</li> <li>h. Blake sewn threads not positioned/finished or secured correctly</li> <li>i. Finished shoe when placed on a flat surface should not exhibit excessive rocking on the sole</li> </ul> </li> </ul> <p>The list is not exhaustive but is to be used as a guide to indicate the quality of shoes to be supplied.</p>

**TABLE 6 – SCHEDULE OF NATO STOCK NUMBERS, TL Nos, SIZES AND LAST MEASUREMENTS – D01256**

Pattern No 29468, Shoes, Service, Black Leather, Working Women's Without Toe Cap

NATO STOCK NUMBERS	TL Nos.	ENGLISH SIZE	FITTING	STICK LENGTH (mm)	JOINT GIRTH (mm)
8435-99-297-6319	TL1076393	2	Medium		
8435-99-297-6320	TL1076394	2	Large		
8435-99-297-6321	TL1076395	2½	Medium		
8435-99-297-6322	TL1076396	2½	Large		
8435-99-297-6323	TL1076397	3	Medium		
8435-99-297-6324	TL1076398	3	Large		
8435-99-297-6325	TL1076399	3½	Medium		
8435-99-297-6326	TL1076400	3½	Large		
8435-99-297-6327	TL1076401	4	Medium		
8435-99-297-6328	TL1076402	4	Large		
8435-99-297-6329	TL1076403	4½	Medium		
8435-99-297-6330	TL1076404	4½	Large		
8435-99-297-6331	TL1076405	5	Medium	257	222
8435-99-297-6332	TL1076406	5	Large		
8435-99-297-6333	TL1076407	5½	Medium		
8435-99-297-6334	TL1076408	5½	Large		
8435-99-297-6335	TL1076409	6	Medium		
8435-99-297-6336	TL1076410	6	Large		
8435-99-297-6337	TL1076411	6½	Medium	Basic last dimensions and grading details:  Length grade: 8.5mm per size  Joint girth grade: 6.5mm per size  Fitting grade: 6.5mm	
8435-99-297-6338	TL1076412	6½	Large		
8435-99-297-6339	TL1076413	7	Medium		
8435-99-297-6340	TL1076414	7	Large		
8435-99-297-6341	TL1076415	7½	Medium		
8435-99-297-6342	TL1076416	7½	Large		
8435-99-297-6343	TL1076417	8	Medium		
8435-99-297-6344	TL1076418	8	Large		
8435-99-297-6345	TL1076419	8½	Medium		
8435-99-297-6346	TL1076420	8½	Large		
8435-99-297-6347	TL1076421	9	Medium		
8435-99-297-6348	TL1076422	9	Large		

**TABLE 7 – SCHEDULE OF NATO STOCK NUMBERS, TL Nos, SIZES AND LAST MEASUREMENTS – D01869**

**Pattern No 29464, Shoes, Service, Black Leather, Working, Men's Without Toe Cap**

NATO STOCK NUMBERS	TL Nos.	ENGLISH SIZE	FITTING	STICK LENGTH (mm)	JOINT GIRTH (mm)
8430-99-297-6231	TL1076185	5	Medium		
8430-99-297-6232	TL1076186	5	Large		
8430-99-297-6233	TL1076187	5½	Medium		
8430-99-297-6234	TL1076188	5½	Large		
8430-99-297-6235	TL1076189	6	Medium		
8430-99-297-6236	TL1076190	6	Large		
8430-99-297-6237	TL1076191	6½	Medium		
8430-99-297-6238	TL1076192	6½	Large		
8430-99-297-6239	TL1076193	7	Medium		
8430-99-297-6240	TL1076194	7	Large		
8430-99-297-6241	TL1076195	7½	Medium		
8430-99-297-6242	TL1076196	7½	Large		
8430-99-297-6243	TL1076197	8	Medium		
8430-99-297-6244	TL1076198	8	Large		
8430-99-297-6245	TL1076199	8½	Medium		
8430-99-297-6246	TL1076200	8½	Large		
8430-99-297-6247	TL1076201	9	Medium	292	261
8430-99-297-6248	TL1076202	9	Large		
8430-99-297-6249	TL1076203	9½	Medium		
8430-99-297-6250	TL1076204	9½	Large		
8430-99-297-6251	TL1076205	10	Medium		
8430-99-297-6252	TL1076206	10	Large		
8430-99-297-6253	TL1076207	10½	Medium		
8430-99-297-6254	TL1076208	10½	Large		
8430-99-297-6255	TL1076209	11	Medium		
8430-99-297-6256	TL1076210	11	Large		
8430-99-297-6257	TL1076211	11½	Medium		
8430-99-297-6258	TL1076212	11½	Large		
8430-99-297-6259	TL1076213	12	Medium	Basic last dimensions and grading details:  Length grade: 8.5mm per size  Joint girth grade: 6.5mm per size  Fitting grade: 6.5mm	
8430-99-297-6260	TL1076214	12	Large		
8430-99-297-6261	TL1076215	12½	Medium		
8430-99-297-6262	TL1076216	12½	Large		
8430-99-297-6263	TL1076217	13	Medium		
8430-99-297-6264	TL1076218	13	Large		
8430-99-297-6265	TL1076219	13½	Medium		
8430-99-297-6266	TL1076220	13½	Large		
8430-99-297-6267	TL1076221	14	Medium		
8430-99-297-6268	TL1076222	14	Large		
8430-99-297-6269	TL1076223	14½	Medium		
8430-99-297-6270	TL1076224	14½	Large		
8430-99-297-6271	TL1076225	15	Medium		
8430-99-297-6272	TL1076226	15	Large		



**TABLE 8 – SCHEDULE OF NATO STOCK NUMBERS, TL Nos, SIZES AND LAST MEASUREMENTS – D01869**

**Pattern No 29465, Shoes, Service, Black Leather, Working, Men's With Toe Cap**

NATO STOCK NUMBERS	TL Nos	ENGLISH SIZE	FITTING	STICK LENGTH (mm)	JOINT GIRTH (mm)
8430-99-297-6275	TL1076227	5	Medium		
8430-99-297-6276	TL1076228	5	Large		
8430-99-297-6277	TL1076229	5½	Medium		
8430-99-297-6278	TL1076230	5½	Large		
8430-99-297-6279	TL1076231	6	Medium		
8430-99-297-6280	TL1076232	6	Large		
8430-99-297-6281	TL1076233	6½	Medium		
8430-99-297-6282	TL1076234	6½	Large		
8430-99-297-6283	TL1076235	7	Medium		
8430-99-297-6284	TL1076236	7	Large		
8430-99-297-6285	TL1076237	7½	Medium		
8430-99-297-6286	TL1076238	7½	Large		
8430-99-297-6287	TL1076239	8	Medium		
8430-99-297-6288	TL1076240	8	Large		
8430-99-297-6289	TL1076241	8½	Medium		
8430-99-297-6290	TL1076242	8½	Large		
8430-99-297-6291	TL1076243	9	Medium	292	261
8430-99-297-6292	TL1076244	9	Large		
8430-99-297-6293	TL1076245	9½	Medium		
8430-99-297-6294	TL1076246	9½	Large		
8430-99-297-6295	TL1076247	10	Medium		
8430-99-297-6296	TL1076248	10	Large		
8430-99-297-6297	TL1076249	10½	Medium		
8430-99-297-6298	TL1076250	10½	Large		
8430-99-297-6299	TL1076251	11	Medium		
8430-99-297-6300	TL1076252	11	Large		
8430-99-297-6301	TL1076253	11½	Medium		
8430-99-297-6302	TL1076254	11½	Large		
8430-99-297-6303	TL1076255	12	Medium		
8430-99-297-6304	TL1076256	12	Large		
8430-99-297-6305	TL1076257	12½	Medium	Basic last dimensions and grading details:  Length grade: 8.5mm per size  Joint girth grade: 6.5mm per size  Fitting grade: 6.5mm	
8430-99-297-6306	TL1076258	12½	Large		
8430-99-297-6307	TL1076259	13	Medium		
8430-99-297-6308	TL1076260	13	Large		
8430-99-297-6309	TL1076262	13½	Medium		
8430-99-297-6310	TL1076263	13½	Large		
8430-99-297-6311	TL1076264	14	Medium		
8430-99-297-6312	TL1076265	14	Large		
8430-99-297-6313	TL1076266	14½	Medium		
8430-99-297-6314	TL1076267	14½	Large		
8430-99-297-6315	TL1076268	15	Medium		
8430-99-297-6316	TL1076269	15	Large		

TABLE 10 – REQUIREMENTS FOR FOOTBED FACER FABRIC

Property	Requirement		Test Method
Mass Per Unit Area Min g/m <sup>2</sup>	140		BS 2471
Thickness Min mm (under 100g/cm <sup>2</sup> pressure)	0.5		BS EN ISO 5084
Tensile Test Breaking Load Min N Extn (%) Rate of test (mm/min)	Test Direction		BS EN ISO 13934 Part 1
	Along	Across	
	150	275	
	50 to 60	32 to 37	
	220	150	

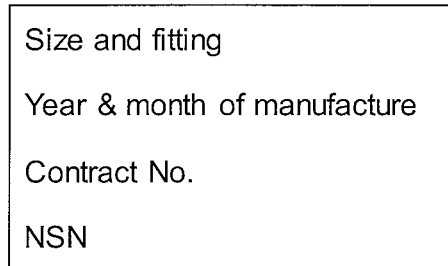
TABLE 11 – METHOD OF EVALUATING TREAD PATTERN TO DETERMINE WHETHER "FOREIGN OBJECT DAMAGE (FOD) FREE".- Pattern Number D02700

<ul style="list-style-type: none"> <li>• The footwear is secured with the tread pattern facing upwards.</li> <li>• Standard samples of "foreign objects" are then pressed into the tread pattern of both sole and heel. The standard samples of "foreign objects" to be used are shown in the table below. A set of standard samples of "foreign objects" may be obtained from the DC.</li> <li>• If the tread pattern accepts any of the items, the footwear is to be inverted to its normal position and if any items are still retained, the tread pattern is to be considered unacceptable.</li> <li>• If the various items drop out of the sole and heel without flexing the footwear, the tread pattern is to be considered "FOD free".</li> </ul>		
FOD Description	Test Observations	Pass/Fail
<p>A number of items to include:-                      Various sizes of washers, bolts, split pins, screws, rivets, terminal lugs, ball end wire ropes.</p>		
<ul style="list-style-type: none"> <li>• This is an in-house test devised by the DC. Pass or fail statements issued by DC on trial items are an indication of the performance of the specific test item and not necessarily of future items. Nor are there guarantees that the item will be considered satisfactory by DC, who would be responsible for carrying out type tests prior to contract placement.</li> </ul>		

4. LABELLING REQUIREMENTS

- The shoes are to be clearly and indelibly marked with  $3 \pm 0.1$  mm figures/letters on the inside quarter lining, with the size and fitting, year and month of manufacture, contract number, NATO Stock Number and other such markings as the contract may require. See Figure 2.

Figure 2 - Example labelling requirements



5. CARE AND MAINTENANCE

- Each pair of shoes is to contain a care label advising the users how the shoes are to be cleaned.



**Manufacturing Specification for  
SHIRT, WOMAN'S, Stone, Long Sleeve, RM & RAF,  
SHIRT, WOMAN'S, Fawn, Long Sleeve, Army, All Ranks**

**Defence Clothing (DC)**

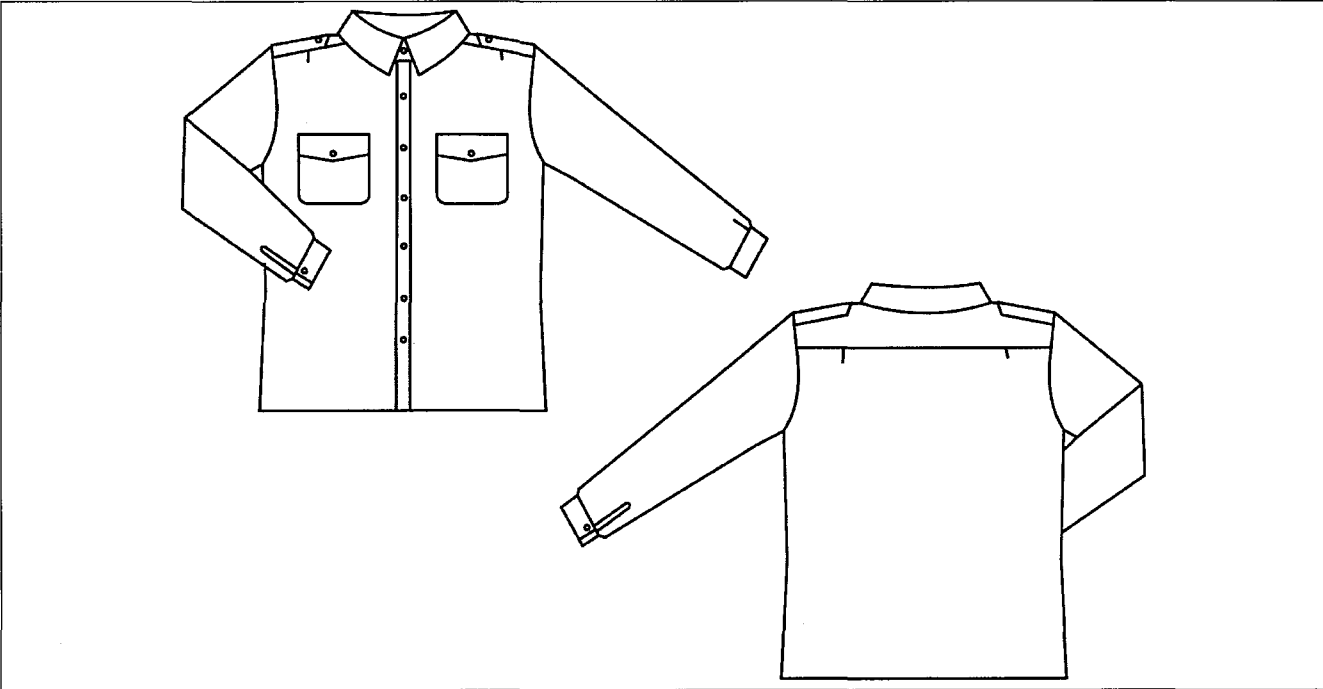
PROPERTY OF  
MINISTRY OF DEFENCE



**1. THE ITEM**

Item	Pattern No.	Electronic Pattern No.
SHIRT, WOMAN'S, Stone, Long Sleeve, RM & RAF	D02977	D02977SH
SHIRT, WOMAN'S, Fawn, Long Sleeve, Army, All Ranks	D02981	D02977SH to guide

Use: A long sleeved shirt made from stone or fawn cotton and polyester fabric. Designed for wear by the RM, RAF and Army all Ranks (when worn with No.2 dress). The size schedule provides for sixteen sizes and outsize for each colourway.



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

**IPR STATEMENT**

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**Technical documents in this specification refer to the edition current at the date of tender or contract unless otherwise stated.**

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## 2. ISSUE RECORD

Issue No.	Comments	Issue Date
04	<p>Specification reformatted and layout updated</p> <p>4: New size table added with new size range</p> <p>Annex A title changed to Performance of Laminates in Fusible Interlinings. Bullet points incorporate construction method</p> <p>5.1,5.2 &amp; 5.3: Positioning tables changed to incorporate new sizing</p> <p>All new TLs, NSNs and pattern number</p> <p>'Extra-long sleeve' deleted from main title</p> <p>Extra-long sleeve NSNs, TLs and measurements deleted as new size table incorporates these instead.</p>	07 January 2021
03	<p>Specification reformatted and layout updated</p> <p>Section 4: Garment sizing and components deleted</p> <p>Performance of laminates moved to the back of the specification</p> <p>Garment sizing table wording updated</p> <p>Section 5: seam type diagrams added and wording in table updated. Quality and design table updated</p> <p>Sections 5.2 to 5.6: diagrams and wording updated</p> <p>Section 6: labelling requirements, specimen labels, and wash care label updated. NSN table amended, TL Numbers added</p> <p>Section 7: packaging diagrams updated and details amended</p> <p>Section 8: item description: UK/SC/6557 deleted, replaced with UK/SC/6363. 8710D Pattern number deleted, replaced with MAT0022F</p> <p>Section 9: Bill of materials updated</p>	21 March 2018
02	<p>Electronic Pattern number amended.</p> <p>Section 5.1 Diagram amended.</p>	14 May 2015
01	<p>New specification derived from and superseding DCMS/5510-3 and DC/MS/5510-7.</p> <p>Combined like items into one specification for ease of future management of item</p>	28 April 2015

### 3. TECHNICAL DATA

#### 3.1 RELATED DOCUMENTS

Document	Title
BS EN ISO 3758	Textiles. Care labelling code using symbols
BS EN 12590	Industrial sewing threads made wholly or partly from synthetic fibres
BS 3866	Specification for holes and shanks for buttons
BS 3870	Stitches and seams
Part 1	Classification and terminology of stitch type
Part 2	Classification and terminology of seam type
BS 4162	Methods of test for buttons
BS 4973	Interlinings
Part 3	Woven and knitted fusible interlinings
BS 5742	Textile labels requiring to be washed and/or dry cleaned
UK/SC/6363	Cloth plain weave cotton and polyester
MAT0022A	Cloth, Plain weave, polyester and cotton, Fawn
MAT0022F	Cloth, Plain weave, polyester and cotton, Stone



**3.2 BILL OF MATERIALS**

<b>MAIN MATERIAL(S)</b>		
Reference	Description	Notes/NATO Stock No.
UK/SC/6363 Pattern No. MAT0022A	MAIN MATERIAL FAWN SHIRTS Cloths, plain weave, cotton and polyester, fawn	
UK/SC/6363 Pattern No. MAT0022F	MAIN MATERIAL STONE SHIRTS Cloths, plain weave, cotton and polyester, stone	

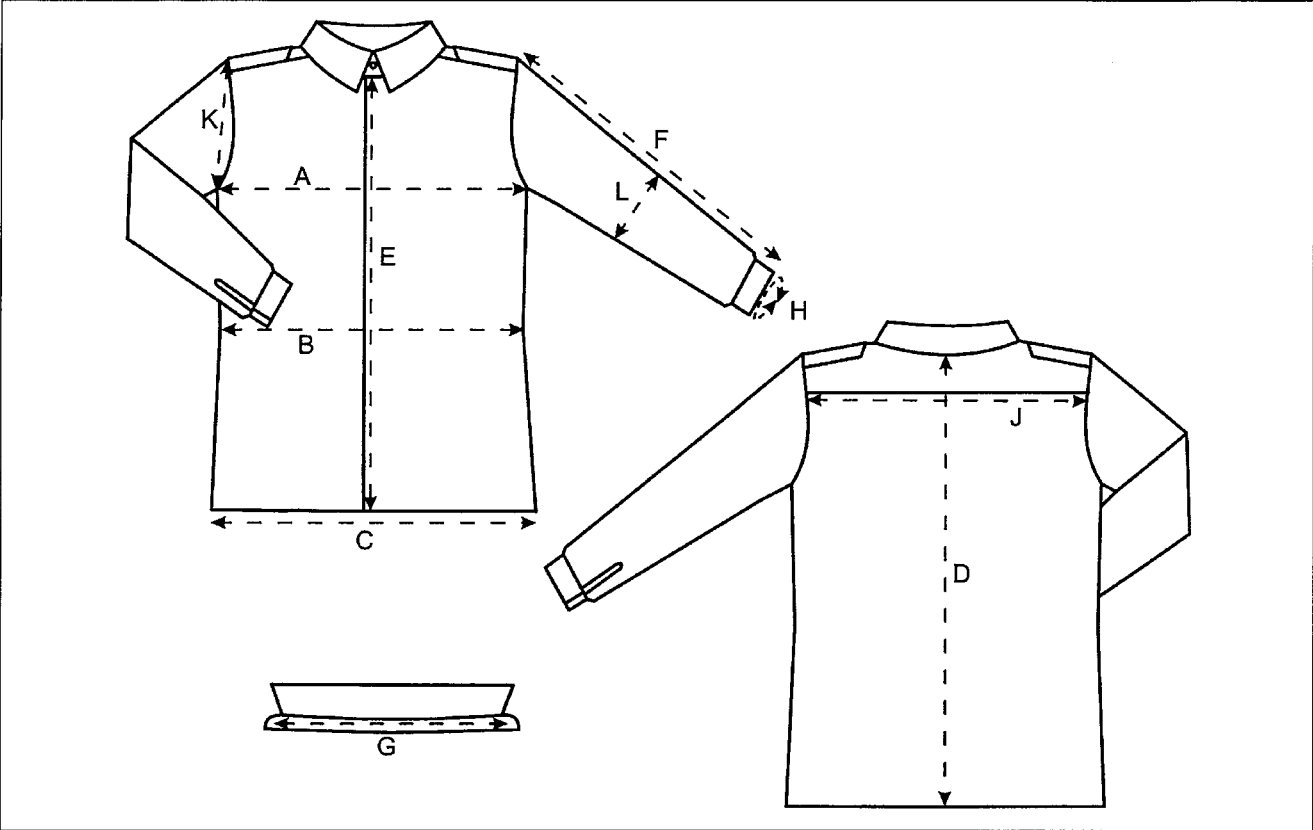
<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Buttons	Shade to match standard pattern  11mm	FRONT, CUFFS, POCKETS, SHOULDERS	Style and shade to match standard pattern.
		Button, sewing hole, 2 hole	Must comply with BS 3866 and BS 4162
Interlining	White	COLLAR, CUFFS, POCKET FLAPS AND SHOULDER STRAPS  Interlining, fusible, plain weave, cotton	BS 4973 Part 3 Ref. FWK2  See section 3.3
Interlining for	White  38mm wide	FRONT STRAP  Interlining, fusible, plain weave, polyester	BS 4973 Part 3 Ref. FWK1  See section 3.3
Stiffener		COLLAR  Stiffener, polyamide	Or a suitable alternative to be approved by DC
Identification/ care instruction label	White	Refer to section 6 for details	BS 5742 Paragraph 3 BS EN ISO 3758
Thread	To match main material	Polyester	BS EN 12590
Ticket No.	120	ALL SEWING	Table 6

### **3.3 PERFORMANCE OF LAMINATES IN FUSIBLE INTERLININGS**

- The main contractor is to ensure that the interlining is laminated strictly in accordance with the interlining manufacturer's recommendations; these recommendations are to be specific to the specified outer cloth for the related garment.
- The fusible interlining recommended must allow the garment to be washed, ironed, dry cleaned and tumble dried as recommended on the care label, throughout the garment life without any visible signs of delamination, puckering, loss of appearance and handle or excessive shrinkage.
- Fusing is to be continuous so that the laminate is free from 'blisters' and there is no 'strike through' of the adhesive onto the face of the laminate or 'strike back' through the interlining.
- The recommendations of the interlining manufacturer regarding fusing must be strictly observed and where those recommendations call for careful control of temperature, time and mechanical pressure, suitable controlled presses must be used.
- The main contractor is to be able to provide evidence to DC on request, of recommendations made by the interlining suppliers and the contractor is to demonstrate compliance with these recommendations throughout the contract.
- The fusible interlining must be suitable for use with the garment fabric and fused in accordance with the manufacturers recommendations.

4. **GARMENT SIZING**

All measurements in centimetres.



**4. GARMENT SIZING continued**

Size Bust/Collar (Inches)	Around fastened and laid flat			Length					Width of shoulder across bottom of yoke	Depth of armhole	Width across elbow (half underarm excluding cuff)
	Under arm	Waist 14cm below underarm	Bottom edge at hem	From collar Seam at centre		From crown of sleeve to bottom (including cuff)	Of collar from centre of buttonhole to centre of button	Of cuff from end to end			
				Back	Front						
85/31(12")	95	87	95	70	66	57	31(12")	22	36	22	15
85/33(13")	95	87	95	71	66.5	57	33(13")	22	36	22	15
90/33(13")	100	92	100	71	66.5	58	33(13")	22	37	23	15.5
90/35(14")	100	92	100	72	67	58	35(14")	22	37	23	15.5
95/35(14")	105	97	105	72	67	59	35(14")	22	38.5	24	16
95/36(14½")	105	97	105	73	67.5	59	36(14½")	22	38.5	24	16
100/36(14½")	110	106	110	73	67.5	60	36(14½")	23	39.5	25	17
100/38(15")	110	106	110	74	68	60	38(15")	23	39.5	25	17
105/38(15")	115	111	115	74	68	61	38(15")	23	41	26	17.5
105/39(15½")	115	111	115	75	68.5	61	39(15½")	23	41	26	17.5
110/39(15½")	120	116	120	75	68.5	62	39(15½")	23	42	27	18.5
110/40(16")	120	116	120	76	69	62	40(16")	23	42	27	18.5
115/40(16")	125	121	125	76	69	64	40(16")	24	43.5	28	19
115/42(16½")	125	121	125	77	69.5	64	42(16½")	24	43.5	28	19
120/42(16½")	130	126	130	77	69.5	66	42(16½")	24	44.5	29	20
120/43(17")	130	126	130	77	69.5	66	43(17")	24	44.5	29	20
Tolerance	±1	±1	±1	±1	±1	±1	-0+0.5	±0.5	±1	±1	±0.5

Outsize garments are to be made for the person whose measurements are supplied on the Outsize Form. The size chart is to be used as a guide for the allowance over the measurements supplied and measurements not shown on the form.

## 5. CONSTRUCTION

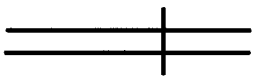

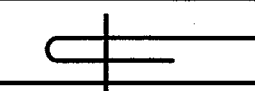

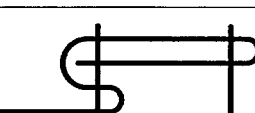
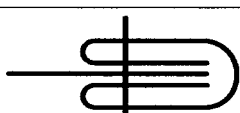
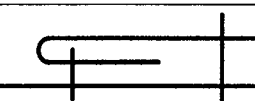
QUALITY
<ul style="list-style-type: none"><li>• The garment is to be made to a high quality.</li><li>• Attention must be paid to features which have a bearing on a neat, smooth superior finish</li><li>• Garments are to be free from all ends of sewing thread, be cleanly pressed and delivered in a clean condition.</li><li>• Uniformity in appearance is essential, therefore there is to be no noticeable variation between production garments and the Standard Pattern</li><li>• Garment parts are correctly aligned in assembly.</li><li>• There is to be no variation in paired features i.e. pockets collar ends, cuffs etc</li><li>• Sleevehead fullness is correctly distributed, sleeves correctly pitched.</li></ul>

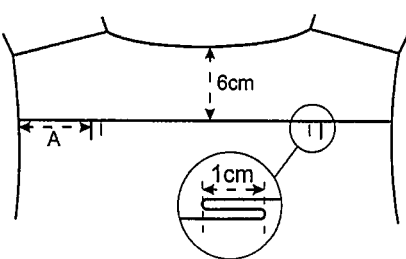
DESIGN
<ul style="list-style-type: none"><li>• Top fused two piece collar</li><li>• Buttoned placket front</li><li>• One pleat in each front</li><li>• Breast pockets with flaps</li><li>• Left breast pocket with pen slot <b><u>(D02977 only)</u></b></li><li>• Two back pleats</li><li>• One piece set-in long sleeve</li><li>• Two knife pleats at cuff</li><li>• Single buttoned cuff</li><li>• Shoulder straps</li></ul>

SEAMS AND STITCHING to BS 3870
<ul style="list-style-type: none"><li>• Yoke, side and armhole seams are to be seam type 1.01.01, stitch type 301 or 401 and raw edges overlocked.</li><li>• All other raw edges to be finished with stitch type 502, 503, 504 or 505</li><li>• All other stitching is to be stitch type 301</li><li>• All seams to have at 8 to 10 stitches per 2cm and be correctly tensioned</li><li>• Buttonholes are to have 22 stitches per 2cm minimum</li><li>• Buttons are to be securely sewn with at least 16 stitches minimum through each hole.</li><li>• Edges of collars, shoulder straps, pocket flaps and cuffs are to be stitched 0.6cm from the edge (where applicable). The stitching is to be regular and unbroken</li></ul>

5. **CONSTRUCTION continued**

The following seam types are referenced in this specification:

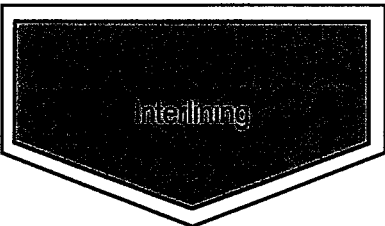
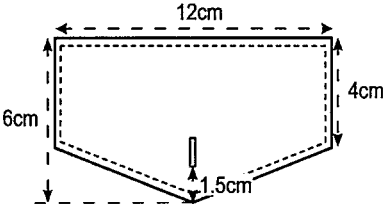
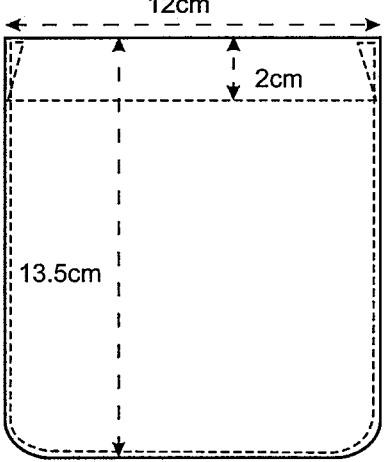
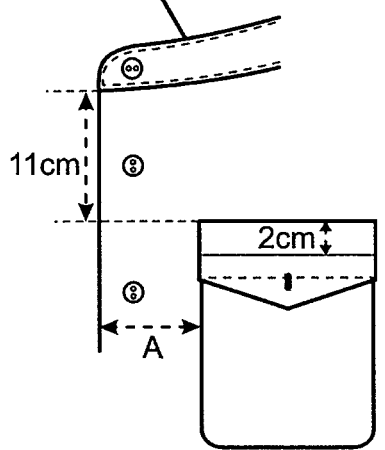
	1.01.01		6.03.01
	5.31.01		2.42.03
	6.08.01		3.05.01
	5.31.05		

PART	DETAIL		SEAM REF
5.1 BACK	<ul style="list-style-type: none"> <li>Two ply yoke, 6cm deep at centre back</li> <li>Yoke to be securely attached to back and front panels</li> <li>Two 1cm knife pleats to be worked in back panel (armhole facing)</li> <li>Positioned as follows:</li> </ul>		
	Size	Distance from armhole A (cm)	
	85	6	
	90	6.5	
	95-100	7.5	
	105	8.5	
	110	9	
	115-120	10	

5. **CONSTRUCTION continued**

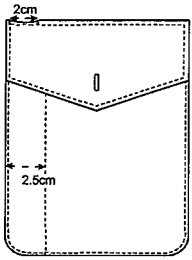
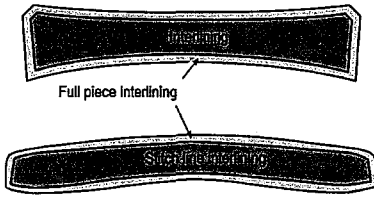
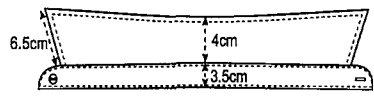
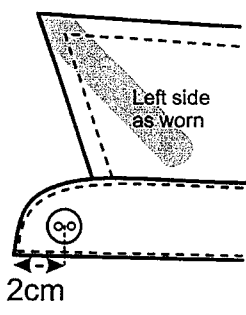
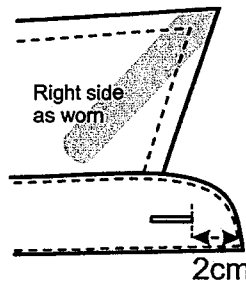
PART	DETAIL	SEAM REF								
<p>5.2 FRONT Right side as worn</p> <p>Left side as worn</p> <p>Right side as worn</p> <p>Inside view</p>	<ul style="list-style-type: none"> <li>• One 1cm knife pleat to be worked in each front panel (armhole facing)</li> <li>• Positioned as follows:</li> </ul> <table border="1" data-bbox="555 515 1228 750"> <thead> <tr> <th>Size</th> <th>Distance from armhole B (cm)</th> </tr> </thead> <tbody> <tr> <td>85/31 to 90/33</td> <td>6</td> </tr> <tr> <td>90/35 to 95/35</td> <td>6.5</td> </tr> <tr> <td>All other sizes</td> <td>7</td> </tr> </tbody> </table> <p><u>Left front</u></p> <ul style="list-style-type: none"> <li>• To have grown on facing 5cm deep, finished 4cm</li> <li>• Facing to be finished with a 1cm in-turn</li> <li>• Six buttons, positioned vertically</li> <li>• Positioned 2cm from front edge</li> <li>• 1<sup>st</sup> button centre to be positioned 6.5cm from collar seam</li> <li>• Additional 5 buttons positioned 8.5cm apart</li> </ul> <p><u>Right front</u></p> <ul style="list-style-type: none"> <li>• To have grown on placket, finished width 4cm</li> <li>• Six vertical buttonholes, 1.2cm usable opening</li> <li>• Positioned centrally in placket (2cm from front edge)</li> <li>• 1<sup>st</sup> buttonhole centre to be positioned 6.5cm from collar seam</li> <li>• Additional 5 buttonholes positioned 8.5cm apart</li> <li>• Buttons and buttonholes should be correctly aligned so there is no distortion of front when shirt buttoned-up.</li> </ul> <p><u>Spare button</u></p> <ul style="list-style-type: none"> <li>• One button to be securely sewn to the left front in-turn (stitching not to penetrate both layers)</li> <li>• Positioned approximately 10cm from the bottom edge</li> </ul>	Size	Distance from armhole B (cm)	85/31 to 90/33	6	90/35 to 95/35	6.5	All other sizes	7	<p>6.03.01</p> <p>6.08.01</p>
Size	Distance from armhole B (cm)									
85/31 to 90/33	6									
90/35 to 95/35	6.5									
All other sizes	7									

5. **CONSTRUCTION continued**

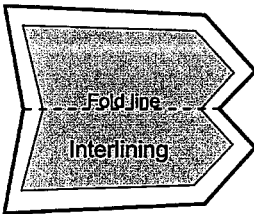
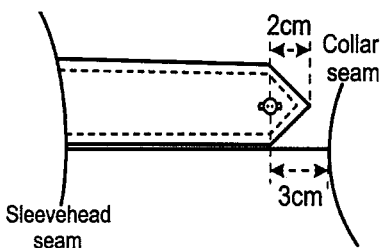
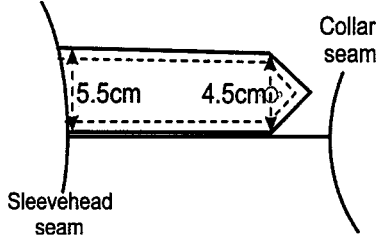
PART	DETAIL	SEAM REF										
<p>5.3 POCKETS Fusible Interlining</p>  <p>Interlining</p> <p>Flap</p>    <p>Left side as worn</p>	<p><u>Flap</u></p> <ul style="list-style-type: none"> <li>Flap two ply of main material, shaped as standard pattern</li> <li>Top ply of flap to be interlined (as diagram)</li> <li>6cm deep at point, 4cm deep at sides, and 12cm wide</li> <li>A vertical buttonhole, 1.2cm usable opening, to be worked centrally in flap.</li> <li>Positioned 1.5cm from point</li> </ul> <p><u>Patch</u></p> <ul style="list-style-type: none"> <li>Patch one ply main material, shaped as standard pattern, with curved corners</li> <li>13.5cm deep and 12cm wide</li> <li>Top edge to have a 2cm in-turn</li> <li>Button to be positioned centrally and in line with buttonhole</li> </ul> <ul style="list-style-type: none"> <li>Flap to be securely attached to the shirt fronts, 11cm from collar seam</li> <li>Patch to be securely attached to the shirt fronts, edge stitched with triangular turn back in stitching</li> <li>Patch to be positioned 2cm below top edge of flap</li> <li>Flap and patch positioned as follows:</li> </ul> <table border="1" data-bbox="560 1765 1225 2051"> <thead> <tr> <th>Size</th> <th>Distance from front edge A (cm)</th> </tr> </thead> <tbody> <tr> <td>85-90</td> <td>5.5</td> </tr> <tr> <td>95-100</td> <td>6</td> </tr> <tr> <td>105-110</td> <td>6.5</td> </tr> <tr> <td>115-120</td> <td>7</td> </tr> </tbody> </table>	Size	Distance from front edge A (cm)	85-90	5.5	95-100	6	105-110	6.5	115-120	7	<p></p> <p>6.03.01</p> <p>5.31.05</p> <p>5.31.01</p>
Size	Distance from front edge A (cm)											
85-90	5.5											
95-100	6											
105-110	6.5											
115-120	7											



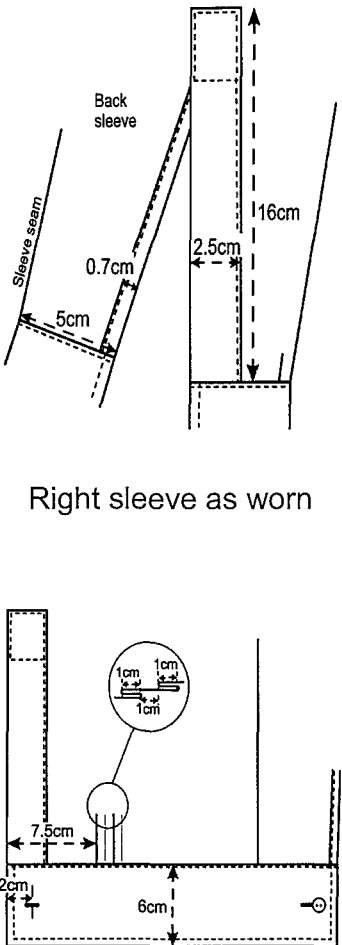
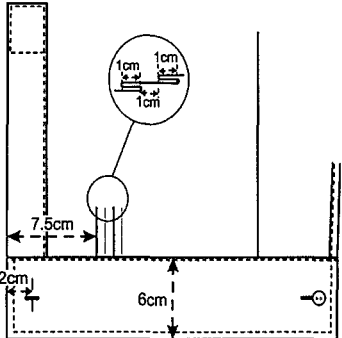
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.3 POCKETS continued</p> 	<p><b>Pattern No D02977 only</b></p> <ul style="list-style-type: none"> <li>• Left patch, as worn, to have a vertical row of stitching, 2.5cm from front edge</li> <li>• Flap to have a 2cm opening left in the top, edges of opening bar-tacked</li> </ul>	
<p>5.4 COLLAR</p> <p>Fusible Interlining</p>  <p>Collar</p>   	<ul style="list-style-type: none"> <li>• Two piece, stand and fall, shaped as on the Standard Pattern</li> <li>• Dimensions: fall at back 4cm at points 6.5cm, stand at back 3.5cm.</li> <li>• Collar to be interlined (as diagram)</li> <li>• Top collar with a two-ply fusible interlining, first ply cut to full dimensions of collar pieces.</li> <li>• The second ply cut to clear the fall edge, sewing lines and the break line.</li> <li>• A stiffener is to be inserted into the collar point and to be retained by top stitching.</li> <li>• The stand, outside of shirt, to be securely attached to the shirt at the neck edge.</li> <li>• The stand, inside of shirt, to be turned in and edge stitched to the neck seam.</li> <li>• A button is sewn centrally on the left side of the collar stand 2cm from the end.</li> <li>• A buttonhole, 1.2cm usable opening, is worked horizontally and centrally in the right side of the collar stand</li> <li>• Positioned 2cm from the end.</li> </ul>	<p>2.42.03</p>

5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.5 SHOULDER STRAPS</p> <p>Fusible Interlining</p>  <p>Shoulder Strap</p>  	<ul style="list-style-type: none"> <li>• Shoulder straps shaped as standard pattern with pointed free end.</li> <li>• Cut one piece and folded</li> <li>• Fold line to be positioned to front of garment</li> <li>• Shoulder strap to be interlined (as diagram)</li> <li>• Length as required by the shoulder button</li> <li>• 5.5cm wide at the sleevehead tapering to 4.5cm wide at the buttonhole.</li> <li>• A buttonhole, 1.2cm usable opening, worked centrally in the strap with the centre 2cm from the point.</li> <li>• Shoulder strap to be topstitched 0.6cm</li> <li>• A button sewn to the shoulder 3cm from the collar seam.</li> <li>• The strap to be sewn in the sleevehead seam, with the front edge aligned with the front yoke seam.</li> </ul>	

5. **CONSTRUCTION continued**


PART	DETAIL	SEAM REF
<p>5.6 SLEEVES</p>  <p>Right sleeve as worn</p>  <p>Right sleeve as worn</p>	<p><u>Guarded Vent</u></p> <ul style="list-style-type: none"> <li>• Vent to be cut in the back of the sleeve, 5cm from under-arm seam</li> <li>• 0.7cm wide guard to be securely attached to the back edge</li> <li>• 2.5cm wide and 16cm long guard to be securely attached to the front edge</li> <li>• Box stitched at top and edge stitched</li> </ul> <p><u>Pleats</u></p> <ul style="list-style-type: none"> <li>• Two 1cm knife pleats, positioned 1cm apart are to be worked in the sleeve end</li> <li>• 1<sup>st</sup> pleat positioned 7.5cm from the edge of the vent</li> </ul> <p><u>Cuff</u></p> <ul style="list-style-type: none"> <li>• Cuff, two ply material 6cm deep</li> <li>• Outside ply of cuff to have fusible interlining</li> <li>• The outside ply to be securely attached to the bottom sleeve</li> <li>• The inside ply is to be turned back and edge stitched</li> <li>• Cuff to be topstitched on 3 sides 0.6cm</li> <li>• A buttonhole, 1.2cm effective length, is worked in each end of the cuff</li> <li>• Positioned horizontally and centrally with the centre of each hole 2cm from the end of the cuff</li> <li>• A button is to be sewn to the outside of the underlap end of the cuff, positioned at the end of the buttonhole</li> </ul>	<p>3.05.03</p> <p>3.05.01</p> <p>2.42.03</p>
<p>5.7 HEM</p>	<ul style="list-style-type: none"> <li>• Finished with a 0.6cm upturn</li> </ul>	<p>6.03.01</p>

**6. LABELLING REQUIREMENTS**


Labels	Position
Identification and garment care labels	Attached to side seam 10cm from hem

Identification Label

Stock sizes






SHIRT, WOMANS Stone, Long Sleeve, RM & RAF 8410-99-671-1358 Size: 85/31(12")  Contract No: Date of Manufacture: MM/YYYY Name: No: (Fibre content to be added here)	
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Outsize

SHIRT, WOMANS Stone, Long Sleeve, RM & RAF 8410-99-671-1374 Collar:* Bust:* Contract No: Date of Manufacture: MM/YYYY Name: No: (Fibre content to be added here)	
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\*Size as appropriate for measurements supplied

Care Label

	Wash as cotton Medium Wash
	DO NOT BLEACH
	Tumble Dry Higher heat setting
	Warm Iron
	DO NOT DRY CLEAN

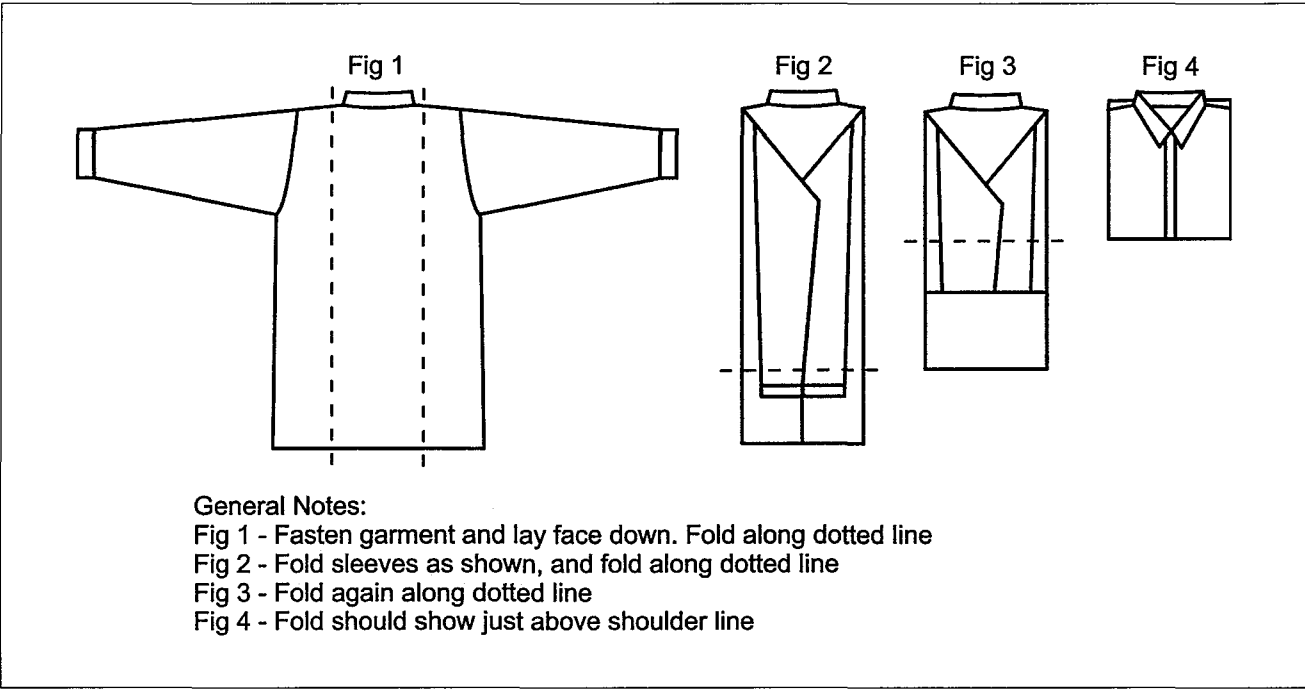
Manufacturer Information

The contractor's name, logo or trademark should not appear on any labels, garment bags or packaging.

**7. PACKAGING**

All shirts are to be folded as illustrated. Boarded including collar support, secured by non-metallic fasteners and packed individually in a transparent polythene bag.

Identification label to be attached to the outside of the polythene bag, including item name, NSN, Size and Contract Number.



**8. TL NUMBER, NATO STOCK NUMBER AND SIZE**

<b>Pattern D02977</b>		
<b>TL Number</b>	<b>NATO Stock No (Stone)</b>	<b>Size (Inches)</b>
TL1092187	8410-99-671-1358	85/31(12")
TL1092188	8410-99-671-1359	85/33(13")
TL1092189	8410-99-671-1360	90/33(13")
TL1092190	8410-99-671-1361	90/35(14")
TL1092191	8410-99-671-1362	95/35(14")
TL1092192	8410-99-671-1363	95/36(14½")
TL1092193	8410-99-671-1364	100/36(14½")
TL1092194	8410-99-671-1365	100/38(15")
TL1092195	8410-99-671-1366	105/38(15")
TL1092196	8410-99-671-1367	105/39(15½")
TL1092197	8410-99-671-1368	110/39(15½")
TL1092198	8410-99-671-1369	110/40(16")
TL1092199	8410-99-671-1370	115/40(16")
TL1092200	8410-99-671-1371	115/42(16½")
TL1092201	8410-99-671-1372	120/42(16½")
TL1092202	8410-99-671-1373	120/43(17")
TL1092203	8410-99-671-1374	Outsize
<b>Pattern D02981</b>		
<b>TL Number</b>	<b>NATO Stock No (Fawn)</b>	<b>Size (Inches)</b>
TL1092204	8410-99-671-1375	85/31(12")
TL1092205	8410-99-671-1376	85/33(13")
TL1092206	8410-99-671-1377	90/33(13")
TL1092207	8410-99-671-1378	90/35(14")
TL1092208	8410-99-671-1379	95/35(14")
TL1092209	8410-99-671-1380	95/36(14½")
TL1092210	8410-99-671-1381	100/36(14½")
TL1092211	8410-99-671-1382	100/38(15")
TL1092212	8410-99-671-1383	105/38(15")
TL1092213	8410-99-671-1384	105/39(15½")
TL1092214	8410-99-671-1385	110/39(15½")
TL1092215	8410-99-671-1386	110/40(16")
TL1092216	8410-99-671-1387	115/40(16")
TL1092217	8410-99-671-1388	115/42(16½")
TL1092218	8410-99-671-1389	120/42(16½")
TL1092219	8410-99-671-1390	120/43(17")
TL1092220	8410-99-671-1391	Outsize



**Technical Specification for  
BUTTONS ANODISED ALUMINIUM  
GOLD AND SILVER**

Defence Clothing (DC)

PROPERTY OF  
MINISTRY OF DEFENCE



PREFACE

TABLE 1 – PRODUCT LIST

<b>Item Name</b>	BUTTONS ANODISED ALUMINIUM GOLD AND SILVER
<b>NATO Stock Number (NSN)</b>	Various (See Table 8)
<b>Pattern No(s)</b>	According to Item (See Table 8)

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

IPR STATEMENT

This specification contains information which is proprietary to the Secretary of State for Defence and shall remain the property of the Secretary of State. It is issued in strict confidence and must not be seen by any unauthorised person. The specification is supplied solely for the purpose of Information/Tender/Contract and shall not be copied or reproduced or used for any other purpose whatsoever without the express prior written permission of the Secretary of State as represented by the Intellectual property rights group.

**Technical documents in this specification refer to the edition current at the date of tender  
or contract unless otherwise stated.**

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
15	Obsolete NSN deleted: 8455-99-973-0351 NSN re-instated: 8315-99-973-0059 Reformatted throughout	04 February 2021
14	TL Numbers added Obsolete NSN deleted: 8315-99-973-0059 Obsolete NSN's deleted: 8455-99-: 869-2407 973-0362 973-0418 973-0419 973- 0424 973-0425 Size of NSN 8455-99-130-3915 corrected	28 April 2020
13	Para's 5 and 6 combined and amended into new Para 5 Addition of NSN 8455-99-130-3913 Obsolete NSN's deleted: 8455-99-: 135-9987 135-9988 135-9989 178-5073 526- 0664 973-0075 973-0077 973-0103 973-0370 973- 0411 973-0412 NSN 8455-99-978-4472 - Size corrected to 17mm as per Master Pattern	30 August 2017
12	Addition of NSN's: 8455-99-130-4261 and 8455-99-668-3917 to 668-3919 Reinstatement of NSN's 8455-99-:973-0075 and 973-0077 The following NSN's have been deleted: 8455-99- 432-8591 432-8592 129-8566 130-4262 973- 1222 973-0050 977-2242 Size of the following NSN's corrected - 8455-99-: 973-0353 137-4687 973-1124	17 September 2013
	For previous issues refer to archived specifications	

PART 1

1. THE PRODUCT

- a. Use of the Product. This specification describes the requirements of anodised aluminium buttons in gold or silver, for wear by the Armed Forces, Constabulary, Fire Service and various MOD Civilian personnel.

TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS ISO 2135	Anodizing of aluminium and its alloys - Accelerated test of light fastness of coloured anodic oxidation coatings using artificial light
BS EN ISO 7599	Anodizing of aluminium and its alloys - General specifications for anodic oxidation coatings on aluminium
BS EN 485 Part 1 Part 2 Part 3 Part 4	Aluminium and aluminium alloys - Sheet, strip and plate Technical conditions for inspection and delivery Mechanical properties Tolerances on shape and dimensions for hot rolled-products Tolerances on shape and dimensions for cold-rolled products
BS EN 515	Aluminium and aluminium alloys - Wrought products - Temper designations
BS EN 573 Part 3	Aluminium and aluminium alloys - Chemical composition and form of wrought products Chemical composition
BS EN 1301 Part 1 Part 2 Part 3	Aluminium and aluminium alloys – Drawn wire Technical conditions for inspection and delivery Mechanical properties Tolerances and dimensions
BS EN 1652	Copper and copper alloys - Plate, sheet, strip and circles for general purposes
BS 3866	Holes and shanks for buttons

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. Various buttons, in different sizes, with shank or screw fitting complete with base plate (See Table 8).

TABLE 4 – PRODUCT COMPONENTS

4.1 Button – front face	Bright anodising quality aluminium sheet to meet the requirements of AW-1080A/H14 of: BS EN 485 Parts 1, 2, 3 and 4 BS EN 515 BS EN 573 Parts 3																
4.2 Button – back	Bright anodising quality aluminium sheet to meet the requirements of AW-1200/H16 of: BS EN 485 Parts 1, 2, 3 and 4 BS EN 515 BS EN 573 Parts 3																
4.3 Button - shank	Bright anodising quality aluminium wire to meet the requirements of AW-1050/H18 of BS EN 1301 Parts 1, 2 and 3																
4.4 Brass plate/threaded insert	To comply with the requirements of BS EN 1652																
<p>The fronts may be of a heavier gauge of aluminium to enable the definition of the Standard Pattern to be reproduced</p> <p>The metal used is to be of the following minimum thicknesses</p> <table border="1"> <thead> <tr> <th><u>Button size</u></th> <th><u>Fronts</u></th> <th><u>Backs</u></th> <th><u>Shank diameter</u></th> </tr> </thead> <tbody> <tr> <td>25mm</td> <td>0.5mm</td> <td>0.86mm</td> <td>1.6mm</td> </tr> <tr> <td>19mm</td> <td>0.46mm</td> <td>0.86mm</td> <td>1.6mm</td> </tr> <tr> <td>14mm</td> <td>0.41mm</td> <td>0.86mm</td> <td>1.2mm</td> </tr> </tbody> </table>		<u>Button size</u>	<u>Fronts</u>	<u>Backs</u>	<u>Shank diameter</u>	25mm	0.5mm	0.86mm	1.6mm	19mm	0.46mm	0.86mm	1.6mm	14mm	0.41mm	0.86mm	1.2mm
<u>Button size</u>	<u>Fronts</u>	<u>Backs</u>	<u>Shank diameter</u>														
25mm	0.5mm	0.86mm	1.6mm														
19mm	0.46mm	0.86mm	1.6mm														
14mm	0.41mm	0.86mm	1.2mm														

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Front face	The face of the button is to be clearly struck using a suitable press tool.
5.2 Back and Shank or Screw/Post	<p>The backs are to be made using a suitable press tool, with two drainage holes and a central shank hole. The position of the drain holes relative to the shank hole are to be such that the strength is not adversely affected or the drain holes blocked when the wire shank is splayed and clenched. A peripheral rebate portion or step is to be provided.</p> <p>The shank is to be formed using a suitable bending machine to provide a loop or eye. The length and thickness of the shank is to comply with the requirements of BS 3866 Table 3.</p> <p>The assembly of the shank to the back is to be by the insertion of the ends of the shank in the back, which are to be spayed apart then clenched down so that the shank is rigidly attached.</p> <p>The assembly of the screw to the back is to be by inserting the screw through the back and securely soldering to the base. Dimensions to be as on the appropriate Standard Pattern.</p> <p>The threaded insert post is to be assembled to the base plate. Dimensions to be as on the appropriate Standard Pattern.</p>
5.3 Assembly, back to front	<p>The front is to be placed in a die, and the back with the shank/screw attached inserted into the front beneath a rolling tool. The wall of the front is to be rolled to overlap the peripheral rebate portion of the back so that the back is rigidly attached to the front and a neat smooth button is produced.</p> <p>The shank is to either horizontal or vertical in relationship to the insignia on the front as on the appropriate Standard Pattern.</p>
5.4 Polishing/Anodising	<p>The assembled button is to be degreased, electro and/or chemically polished, bright anodised gold or silver, sealed and dried.</p> <p>At stages throughout the process the button is to be neutralised in ammonia and any liquid left in the button drained out.</p> <p>a) <u>Army</u>: The shade boxes containing Standard Pattern No.19508 for gold anodised buttons is to be judged to either Set A (detailed design) or Set B (plain or inconspicuous design).</p> <p>The shade box containing Standard Pattern No.15456 for silver anodised buttons is to constitute the brightness and colour acceptable.</p> <p>b) <u>RN</u>: The shade box containing Standard Pattern No.27790 for gold anodised buttons is to constitute the brightness and colour acceptable.</p> <p>The significant surface is the button front.</p>

## 4. PERFORMANCE

a. Visual Requirement of Finished Buttons

The buttons are to be compared against the appropriate Standard Pattern for mechanical imperfections and any streakiness or unequal colouring of the dyed film. They are to be viewed, under no magnification, at a distance of between 30cm to 40cm in daylight or in a daylight colour-matching booth. The colour and brightness are to conform to the Polishing/Anodising clause in Table 5 of this specification.

## b. Anodic Film requirements are to be as Table 6

TABLE 6 – ANODIC FILM REQUIREMENTS

Property	Requirement	Method of Test
Coating thickness	Class AA10	To Clause 6 of BS EN ISO 7599
Quality of sealing	No bloom after 24 hours exposure to test conditions	To Clauses 7 of BS EN ISO 7599
Fastness to light	Standard 8	To BS ISO 2135
Dry cleaning	No visible change	Four sample buttons are to be placed in a stoppered flask of a suitable size being half filled with perchloroethylene and placed in a fume cupboard for 2 hours.  At the end of this period the sample will be removed and examined. If none of the buttons have changed in appearance the buttons are acceptable.
Tropical exposure	No visible contrast with the Standard Pattern	Four buttons are to be stored in a suitable tropical chamber for a period of 28 days at 32° and 90% RH.  After this period if none of the buttons have changes in appearance the buttons are acceptable.
Abrasion Resistance	The buttons are to have no significant change in appearance	The buttons are to be securely mounted face side down, onto each of the four moving heads of a Martindale abrasion tester. (One convenient method is to remove the thread loop and attach the button directly to the moving head using double-sided tape).  The heads are to be mounted onto the abrasion tester and a load of 576gms applied and rubbed against the standard worsted abradant fabric (detailed in Table 7) for 60 minutes. At the end of the test the buttons are to be removed and examined.

TABLE 7 – ABRADANT FABRIC REQUIREMENTS

The Abradant is to be crossbred worsted fabric with the following finished particulars.

	Warp	Weft
Yarn count	R55 tex/2	R74 tex/2
Singles Twist turns/metre	490 ± 20Z	550 ± 20 Z
Folding test turns/metre	470 ± 20 S	410 ± 20 S
Fibre fineness	19 µm	19 µm
Threads/cm	19	12
Mass	185 g/m <sup>2</sup>	-

5. 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. Buttons are to be provided 25 buttons to a card and then sealed in a clear polythene bag.
- d. Under no circumstances should the contractor's name, logo or trademark appear on the items or packaging.

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

Item No.	TL Number	NATO Stock Number 8315-99-	Pattern No.	Description	Additional Information
1.	TL1030577	973-0049	21959	BUTTON, STAPLE, 14mm The Queen's Royal Hussars	Aluminium, anodised gold. Shade to conform to pattern 19508. All Ranks
2.	TL1030578	973-0051	22763	BUTTON, STAPLE, 19mm, BALL The Queen's Royal Hussars	Aluminium, anodised gold. Shade to conform to pattern 19508. All Ranks
3.	TL1030579	973-0052	20814	BUTTON, STAPLE, 17mm The Queen's Royal Hussars	Aluminium, anodised gold. Shade to conform to pattern 19508. All Ranks
4.	TL1030580	973-0058	23656	BUTTON, STAPLE, 22mm The Light Dragoons	Aluminium, anodised gold. Shade to conform to pattern 19508. All Ranks
5.	TL1030581	973-0059	21967	BUTTON, STAPLE, 17mm The Light Dragoons	Aluminium, anodised gold. Shade to conform to pattern 19508. All Ranks.
6.	TL1030582	973-0405	21918	BUTTON, STAPLE, 14mm The Queen's Own Yeomanry B Sqn North Irish Horse	Aluminium, anodised silver. Shade to conform to pattern 15456



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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
7.	TL1041996	122-1864	20676	BUTTON, INSIGNIA, 25mm Royal Irish Rangers, Pipers	Aluminium, anodised silver. Shade to conform to pattern 15456.
8.	TL1041997	122-1865	22523	BUTTON, INSIGNIA, 19mm Royal Irish Rangers, Soldiers	Aluminium, anodised silver. Shade to conform to pattern 15456.
9.	TL1042016	122-3840	22545	BUTTON, INSIGNIA, 25mm Blues And Royals, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
10.	TL1042017	122-3841	20987	BUTTON, INSIGNIA, 19mm Blues And Royals, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
11.	TL1042018	122-3842	21348	BUTTON, INSIGNIA, 14mm Blues And Royals, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
12.	TL1042021	122-4121	35/R/1563A	BUTTON, INSIGNIA, 17mm, SCREW FIT Royal Air Force, Air Officer	Aluminium, anodised gold. Shade to conform to pattern 19508.
13.	TL1042023	122-5721	20736	BUTTON, INSIGNIA, 14mm The Royal Anglian Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
14.	TL1042024	122-5722	20156	BUTTON, INSIGNIA, 25mm The Royal Anglian Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
15.	TL1042025	122-5723	20709	BUTTON, INSIGNIA, 19mm The Royal Anglian Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
16.	TL1042104	130-2693	22460	BUTTON, INSIGNIA, 30mm Royal Navy, Ratings	Aluminium, anodised gold. Shade to conform to pattern 27790.
17.	TL1042121	130-3516	30016	BUTTON, INSIGNIA, 19mm, SCREW FIT The Queen's Dragoon Guards, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
18.	TL1042122	130-3517	30017	BUTTON, INSIGNIA, 14mm The Queen's Dragoon Guards, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
19.	TL1042133	130-3566	30485	BUTTON, INSIGNIA, 19mm, SCREW FIT Royal Tank Regiment, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
20.	TL1042148	130-3588	30088	BUTTON, INSIGNIA, 19mm Coldstream Guards, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
21.	TL1042168	130-3612	30112	BUTTON, INSIGNIA, 22mm Welsh Guards, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
22.	TL1042176	130-3622	30122	BUTTON, INSIGNIA, 19mm, SCREW FIT Royal Engineers, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
23.	TL1042179	130-3627	30127	BUTTON, INSIGNIA, 19mm, SCREW FIT Royal Corps Of Signals, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
24.	TL1042187	130-3680	30180	BUTTON, INSIGNIA, 19mm, SCREW FIT The Royal Anglian Regiment, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
25.	TL1042189	130-3760	30260	BUTTON, INSIGNIA, 19mm, SCREW FIT The Parachute Regiment, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
26.	TL1042191	130-3784	30284	BUTTON, INSIGNIA, 19mm, SCREW FIT The Queen's Gurkha Engineers, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
27.	TL1042192	130-3796	30296	BUTTON, INSIGNIA, 19mm, SCREW FIT Army Air Corps, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
28.	TL1042205	130-3828	30328	BUTTON, INSIGNIA, 19mm, SCREW FIT Royal Army Medical Corps, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
29.	TL1042207	130-3836	30336	BUTTON, INSIGNIA, 19mm, SCREW FIT Royal Electrical & Mechanical Engineers	Aluminium, anodised gold. Shade to conform to pattern 19508.
30.	TL1042209	130-3839	30339	BUTTON, INSIGNIA, 14mm AGC, Royal Military Police, Officers	Aluminium, anodised silver. Shade to conform to pattern 15456.
31.	TL1042210	130-3840	30340	BUTTON, INSIGNIA, 19mm, SCREW FIT AGC, Royal Military Police, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
32.	TL1042213	130-3866	30366	BUTTON, INSIGNIA, 19mm, SCREW FIT Intelligence Corps, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
33.	TL1042215	130-3869	30369	BUTTON, INSIGNIA, 19mm, SCREW FIT Army Physical Training Corps, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.
34.	TL1042217	130-3880	30380	BUTTON, INSIGNIA, 25mm AGC, Army Legal Services, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508. Officers
35.	TL1042218	130-3881	30381	BUTTON, INSIGNIA, 19mm AGC, Army Legal Services, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508. Officers
36.	TL1042219	130-3882	30382	BUTTON, INSIGNIA, 14mm AGC, Army Legal Services, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508. Officers
37.	TL1042220	130-3883	30383	BUTTON, INSIGNIA, 19mm, SCREW FIT AGC, Army Legal Services, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508. Officers
38.	TL1042221	130-3886	30386	BUTTON, INSIGNIA, 19mm, SCREW FIT Honourable Artillery Company, Officers	Aluminium, anodised silver. Shade to conform to pattern 15456. Officers
39.	TL1042224	130-3904	30404	BUTTON, INSIGNIA, 19mm, SCREW FIT General List	Aluminium, anodised gold. Shade to conform to pattern 19508
40.	TL1042225	130-3913	30413A	BUTTON, INSIGNIA, 25mm Officers Of General Rank	Aluminium, anodised gold. Shade to conform to pattern 19508
41.	TL1042226	130-3914	30414	BUTTON, INSIGNIA, 19mm Officers Of General Rank	Aluminium, anodised gold. Shade to conform to pattern 19508
42.	TL1042227	130-3915	30415	BUTTON, INSIGNIA, 14mm Officers Of General Rank	Aluminium, anodised gold. Shade to conform to pattern 19508
43.	TL1042228	130-3916	30416	BUTTON, INSIGNIA, 19mm, SCREW FIT Officers Of General Rank	Aluminium, anodised gold. Shade to conform to pattern 19508
44.	TL1042230	130-3918	30418	BUTTON, INSIGNIA, 25mm Brigadiers & Colonels (Staff)	Aluminium, anodised gold. Shade to conform to pattern 19508
45.	TL1042231	130-3919	30419	BUTTON, INSIGNIA, 19mm Brigadiers & Colonels (Staff)	Aluminium, anodised gold. Shade to conform to pattern 19508

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
46.	TL1042232	130-3920	30420	BUTTON, INSIGNIA, 14mm Brigadiers & Colonels (Staff)	Aluminium, anodised gold. Shade to conform to pattern 19508
47.	TL1042233	130-3921	30421	BUTTON, INSIGNIA, 19mm, SCREW FIT Brigadiers & Colonels (Staff)	Aluminium, anodised gold. Shade to conform to pattern 19508
48.	TL1042249	130-4261	22354	BUTTON, INSIGNIA, 19mm BERKSHIRE YEOMANRY SQUADRON of 71 (YEOMANRY) SIGNALS REGIMENT	Aluminium, anodised gold. Shade to conform to pattern 19508
49.	TL1042396	132-3627	21966	BUTTON, INSIGNIA, 23mm (37L) Royal Navy, Chief Petty Officer	Aluminium, anodised gold. Shade to conform to pattern 27790. Without shank. Rim to be diamond turned.
50.	TL1042480	133-8183	D01133	BUTTON INSIGNIA, 19mm, SCREW FIT The Yorkshire Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
51.	TL1042538	135-6478	22917	BUTTON, INSIGNIA, 14mm The Queen's Gurkha Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
52.	TL1042541	135-7449	20329	BUTTON, INSIGNIA, 25mm Royal Scots Dragoon Guards, Pipers	Aluminium, anodised silver. Shade to conform to pattern 15456.
53.	TL1042542	135-7450	20330	BUTTON, INSIGNIA, 19mm Royal Scots Dragoon Guards, Pipers	Aluminium, anodised silver. Shade to conform to pattern 15456.
54.	TL1042543	135-7451	20331	BUTTON, INSIGNIA, 25mm Royal Scots Dragoon Guards, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
55.	TL1042544	135-7452	20332	BUTTON, INSIGNIA, 19mm Royal Scots Dragoon Guards, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
56.	TL1042545	135-7453	20333	BUTTON, INSIGNIA, 14mm Royal Scots Dragoon Guards, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
57.	TL1042584	136-7234	35/R/1718A	BUTTON, INSIGNIA, 17mm (27L) Royal Air Force, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
58.	TL1042588	136-9632	20658A	BUTTON, INSIGNIA, 23mm (37L) Royal Navy, Chief Petty Officer	Aluminium, anodised gold. Shade to conform to pattern 27790. Rim to be diamond turned.
59.	TL1042595	137-1055	35/R/1739A	BUTTON, INSIGNIA, 23mm (37L) Royal Air Force, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
60.	TL1042600	137-2398	20811	BUTTON, INSIGNIA, 14mm Royal Navy, Ratings	Aluminium, anodised gold. Shade to conform to pattern 27790. Rim to be diamond turned
61.	TL1042604	137-4076	20876A	BUTTON, INSIGNIA, 23mm (37L) Royal Fleet Auxiliary, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
62.	TL1042605	137-4077	20877	BUTTON, INSIGNIA, 19mm Royal Fleet Auxiliary, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
63.	TL1042606	137-4078	20878	BUTTON, INSIGNIA, 17mm Royal Fleet Auxiliary, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
64.	TL1042608	137-4438	35/R/1766A	BUTTON, INSIGNIA, 14mm Royal Air Force, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
65.	TL1042611	137-4684	20919	BUTTON, INSIGNIA, 23mm (37L) Royal Navy, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
66.	TL1042612	137-4685	20920	BUTTON, INSIGNIA, 19mm Royal Navy, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
67.	TL1042613	137-4686	20921	BUTTON, INSIGNIA, 17mm Royal Navy, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
68.	TL1042614	137-4687	20922	BUTTON, INSIGNIA, 23mm (37L) Royal Marines, Other Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
69.	TL1042615	137-4688	20923	BUTTON, INSIGNIA, 17mm (27L) Royal Marines, Other Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
70.	TL1042642	138-0528	21162	BUTTON, INSIGNIA, 23mm (37L) Royal Navy, Flag officers	Aluminium, anodised gold. Shade to conform to pattern 27790.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
71.	TL1042643	138-0529	21163	BUTTON, INSIGNIA, 19mm Royal Navy, Flag officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
72.	TL1042644	138-0530	21164	BUTTON, INSIGNIA, 17mm Royal Navy, Flag officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
73.	TL1042655	138-5923	21341	BUTTON, INSIGNIA, 23mm (36L) Port Auxiliary Service, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
74.	TL1042656	138-5924	21342	BUTTON, INSIGNIA, 16mm (25L) Port Auxiliary Service, Officers	Aluminium, anodised gold. Shade to conform to pattern 27790.
75.	TL1042684	147-9710	D01134	BUTTON, INSIGNIA, 25mm The Yorkshire Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
76.	TL1042688	151-5805	D02013	BUTTON, INSIGNIA, 14mm Scots Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
77.	TL1042689	151-5806	D02014	BUTTON INSIGNIA, 19mm, Scots Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
78.	TL1042850	334-0177	D01995	BUTTON, INSIGNIA, 17mm, Grenadier Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
79.	TL1042851	334-0178	D01996	BUTTON, INSIGNIA, 22mm, Grenadier Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
80.	TL1042873	355-4618	D01859	BUTTON, INSIGNIA, 25mm The Gibraltar Regiment	Aluminium, anodised gold. Shade to conform to pattern 19508
81.	TL1043225	424-6413	D01170	BUTTON, INSIGNIA, 14mm The Royal Welsh, Officers	Aluminium, anodised bronze finish.
82.	TL1043226	424-6414	D01171	BUTTON, INSIGNIA, 19mm The Royal Welsh, Officers	Aluminium, anodised bronze finish.
83.	TL1043227	424-6415	D01172	BUTTON, INSIGNIA, 25mm The Royal Welsh, Officers	Aluminium, anodised bronze finish.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
84.	TL1043229	426-3172	D00864	BUTTON, INSIGNIA, 14mm The Royal Welsh	Aluminium, anodised gold. Shade to conform to pattern 19508
85.	TL1043230	426-3173	D00865	BUTTON, INSIGNIA, 19mm The Royal Welsh	Aluminium, anodised gold. Shade to conform to pattern 19508
86.	TL1043231	426-3174	D00866	BUTTON, INSIGNIA, 25mm The Royal Welsh	Aluminium, anodised gold. Shade to conform to pattern 19508
87.	TL1043285	476-5984	D01131	BUTTON, INSIGNIA, 14mm The Yorkshire Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
88.	TL1043287	480-8176	D01132	BUTTON, INSIGNIA, 19mm The Yorkshire Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
89.	TL1043655	668-3917	D02278	BUTTON, INSIGNIA, 14mm The Royal Yeomanry	Aluminium, anodised silver. Shade to conform to pattern 15456
90.	TL1043656	668-3918	D02279	BUTTON, INSIGNIA, 19mm The Royal Yeomanry	Aluminium, anodised silver. Shade to conform to pattern 15456
91.	TL1043657	668-3919	D02280	BUTTON, INSIGNIA, 25mm The Royal Yeomanry	Aluminium, anodised silver. Shade to conform to pattern 15456
92.	TL1043804	789-6430	D01150	BUTTON, INSIGNIA, 19mm, SCREW FIT The Royal Welsh	Aluminium, anodised gold. Shade to conform to pattern 19508
93.	TL1043838	814-4372	D02190	BUTTON, INSIGNIA, 17mm Queens Own Yeomanry	Aluminium, anodised silver. Shade to conform to pattern 15456
94.	TL1043839	814-4373	D02191	BUTTON, INSIGNIA, 22mm Queens Own Yeomanry	Aluminium, anodised silver. Shade to conform to pattern 15456
95.	TL1043909	869-1196	27780	BUTTON, INSIGNIA, 19mm Royal Navy, Senior Ratings	Aluminium, anodised gold. Shade to conform to pattern 27790.
96.	TL1043928	869-2206	28077	BUTTON, INSIGNIA, 14mm Royal Marines	Aluminium, anodised gold. Shade to conform to pattern 19508

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
97.	TL1043956	869-4026	28431	BUTTON, INSIGNIA, 14mm Adjutant General's Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
98.	TL1043957	869-4027	28432	BUTTON, INSIGNIA, 19mm Adjutant General's Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
99.	TL1043958	869-4028	28433	BUTTON, INSIGNIA, 25mm Adjutant General's Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
100.	TL1043959	869-4029	28434	BUTTON, INSIGNIA, 19mm, SCREW FIT Adjutant General's Corps , All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
101.	TL1044093	973-0026	21360	BUTTON, INSIGNIA, 14mm The Life Guards, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
102.	TL1044094	973-0027	20838	BUTTON, INSIGNIA, 25mm The Life Guards, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
103.	TL1044095	973-0028	21848	BUTTON, INSIGNIA, 19mm The Life Guards, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
104.	TL1044098	973-0078	22167	BALL BUTTON, INSIGNIA, 18mm (28L) BALL Royal Horse Artillery, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
105.	TL1044099	973-0079	23000	BUTTON, INSIGNIA, 25mm Royal Tank Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
106.	TL1044100	973-0080	21312	BUTTON, INSIGNIA, 19mm Royal Tank Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
107.	TL1044101	973-0081	21349	BUTTON, INSIGNIA, 14mm Royal Artillery, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
108.	TL1044102	973-0082	18597	BUTTON, INSIGNIA, 25mm Royal Artillery, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.



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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
109.	TL1044103	973-0083	20688	BUTTON, INSIGNIA, 19mm Royal Artillery, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
110.	TL1044104	973-0084	21553	BUTTON, INSIGNIA, 14mm Royal Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
111.	TL1044105	973-0085	17858	BUTTON, INSIGNIA, 25mm Royal Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
112.	TL1044106	973-0086	20746	BUTTON, INSIGNIA, 19mm Royal Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
113.	TL1044107	973-0087	20732	BUTTON, INSIGNIA, 14mm Royal Corps of Signals, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
114.	TL1044108	973-0088	15448	BUTTON, INSIGNIA, 25mm Royal Corps of Signals, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
115.	TL1044109	973-0089	20710	BUTTON, INSIGNIA, 19mm Royal Corps of Signals, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
116.	TL1044110	973-0090	20948	BUTTON, INSIGNIA, 14mm Grenadier Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
117.	TL1044111	973-0091	20849	BUTTON, INSIGNIA, 25mm Grenadier Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
118.	TL1044112	973-0092	20850	BUTTON, INSIGNIA, 19mm Grenadier Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
119.	TL1044113	973-0093	21008	BUTTON, INSIGNIA, 14mm Coldstream Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
120.	TL1044114	973-0094	20737	BUTTON, INSIGNIA, 25mm Coldstream Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
121.	TL1044115	973-0095	20851	BUTTON, INSIGNIA, 19mm Coldstream Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
122.	TL1044116	973-0096	19102	BUTTON, INSIGNIA, 14mm Scots Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
123.	TL1044117	973-0097	19088	BUTTON, INSIGNIA, 18mm (28L) Scots Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
124.	TL1044118	973-0098	20852	BUTTON, INSIGNIA, 25mm Scots Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
125.	TL1044119	973-0099	20949	BUTTON, INSIGNIA, 17mm (27L) Scots Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
126.	TL1044120	973-0100	21050	BUTTON, INSIGNIA, 25mm Scots Guards Pipers, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
127.	TL1044121	973-0101	22379	BUTTON, INSIGNIA, 18mm (28L) Scots Guards Pipers, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
128.	TL1044122	973-0102	20892	BUTTON, INSIGNIA, 14mm Irish Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
129.	TL1044124	973-0104	21221	BUTTON, INSIGNIA, 25mm Irish Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
130.	TL1044125	973-0105	21586	BUTTON, INSIGNIA, 19mm Irish Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
131.	TL1044126	973-0106	20831	BUTTON, INSIGNIA, 25mm Irish Guards, Pipers	Aluminium, anodised silver. Shade to conform to pattern 15456
132.	TL1044127	973-0107	24177	BUTTON, INSIGNIA, 19mm Irish Guards, Pipers	Aluminium, anodised silver. Shade to conform to pattern 15456
133.	TL1044128	973-0108	20891	BUTTON, INSIGNIA, 15mm (24L) Welsh Guards, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
134.	TL1044129	973-0109	20853	BUTTON, INSIGNIA, 25mm Welsh Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
135.	TL1044130	973-0110	20950	BUTTON, INSIGNIA, 19mm Welsh Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
136.	TL1044131	973-0202	23171	BUTTON, INSIGNIA, 25mm The Parachute Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
137.	TL1044132	973-0203	21735	BUTTON, INSIGNIA, 19mm The Parachute Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
138.	TL1044133	973-0250	20657	BUTTON, INSIGNIA, 14mm Royal Regiment Of Fusiliers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
139.	TL1044134	973-0251	19204	BUTTON, INSIGNIA, 25mm Royal Regiment Of Fusiliers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
140.	TL1044135	973-0252	21958	BUTTON, INSIGNIA, 19mm Royal Regiment Of Fusiliers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
141.	TL1044136	973-0291	21847	BUTTON, INSIGNIA, 14mm Army Physical Training Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
142.	TL1044137	973-0292	20501	BUTTON, INSIGNIA, 25mm Army Physical Training Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
143.	TL1044138	973-0293	21307A	BUTTON, INSIGNIA, 19mm Army Physical Training Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
144.	TL1044139	973-0295	20666	BUTTON, INSIGNIA, 25mm Intelligence Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
145.	TL1044140	973-0296	20650	BUTTON, INSIGNIA, 19mm Intelligence Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
146.	TL1044141	973-0297	15893	BUTTON, INSIGNIA, 14mm AGC, Military Provost Staff, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
147.	TL1044142	973-0298	15712	BUTTON, INSIGNIA, 25mm AGC, Military Provost Staff, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
148.	TL1044143	973-0299	22562	BUTTON, INSIGNIA, 18mm (28L) AGC, Military Provost Staff, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
149.	TL1044144	973-0303	20742A	BUTTON, INSIGNIA, 14mm Queen Alexandra's Royal Army Nursing Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
150.	TL1044145	973-0304	16688	BUTTON, INSIGNIA, 25mm Queen Alexandra's Royal Army Nursing Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
151.	TL1044146	973-0305	20741	BUTTON, INSIGNIA, 22mm Queen Alexandra's Royal Army Nursing Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
152.	TL1044147	973-0306	20680	BUTTON, INSIGNIA, 19mm Queen Alexandra's Royal Army Nursing Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
153.	TL1044148	973-0307	18595	BUTTON, INSIGNIA, 25mm Royal Armoured Corps, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
154.	TL1044149	973-0308	18596	BUTTON, INSIGNIA, 19mm Royal Armoured Corps, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
155.	TL1044150	973-0309	20915	BUTTON, INSIGNIA, 14mm Royal Army Dental Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
156.	TL1044151	973-0310	23972	BUTTON, INSIGNIA, 25mm Royal Army Dental Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
157.	TL1044152	973-0311	20907	BUTTON, INSIGNIA, 19mm Royal Army Dental Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
158.	TL1044153	973-0315	21734A	BUTTON, INSIGNIA, 14mm Royal Army Medical Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
159.	TL1044154	973-0316	18583	BUTTON, INSIGNIA, 25mm Royal Army Medical Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
160.	TL1044155	973-0317	22663	BUTTON, INSIGNIA, 19mm Royal Army Medical Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
161.	TL1044156	973-0327	23258	BUTTON, INSIGNIA, 14mm Royal Army Veterinary Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
162.	TL1044157	973-0328	27214	BUTTON, INSIGNIA, 25mm Royal Army Veterinary Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
163.	TL1044158	973-0329	23188	BUTTON, INSIGNIA, 19mm Royal Army Veterinary Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
164.	TL1044159	973-0330	21310	BUTTON, INSIGNIA, 14mm Royal Electrical & Mechanical Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
165.	TL1044160	973-0331	16719	BUTTON, INSIGNIA, 25mm Royal Electrical & Mechanical Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
166.	TL1044161	973-0332	20686	BUTTON, INSIGNIA, 19mm Royal Electrical & Mechanical Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
167.	TL1044162	973-0333	20993	BUTTON, INSIGNIA, 14mm AGC, Royal Military Police, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
168.	TL1044163	973-0334	21417	BUTTON, INSIGNIA, 25mm AGC, Royal Military Police, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
169.	TL1044164	973-0335	21013	BUTTON, INSIGNIA, 19mm AGC, Royal Military Police, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
170.	TL1044165	973-0349	20994	BUTTON, INSIGNIA, 14mm Duke of York's Royal Military School, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
171.	TL1044167	973-0353	25018A	BUTTON, INSIGNIA, 19 Queen Victoria's School	Aluminium, anodised gold. Shade to conform to pattern 19508
172.	TL1044168	973-0354	17096	BUTTON, INSIGNIA, 14mm General List, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
173.	TL1044169	973-0355	22857	BUTTON, INSIGNIA, 25mm General List, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
174.	TL1044170	973-0356	22856	BUTTON, INSIGNIA, 19mm General List, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
175.	TL1044172	973-0366	22471	BUTTON, INSIGNIA, 14mm Royal Military Academy Sandhurst, Officer Cadets	Aluminium, anodised silver. Shade to conform to pattern 15456.
176.	TL1044173	973-0368	20836	BUTTON, INSIGNIA, 19mm Royal Military Academy Sandhurst	Aluminium, anodised gold. Shade to conform to pattern 19508
177.	TL1044174	973-0369	23288	BUTTON, INSIGNIA, 14mm Royal Military Academy Sandhurst, Officer Cadets	Aluminium, anodised gold. Shade to conform to pattern 19508. For use on gorget patch
178.	TL1044179	973-0377	20846	BUTTON, INSIGNIA, 14mm Welbeck College, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
179.	TL1044180	973-0379	20813	BUTTON, INSIGNIA, 19mm Welbeck College, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
180.	TL1044187	973-0441	21588	BUTTON, INSIGNIA, 14mm Honourable Artillery Company, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
181.	TL1044188	973-0443	23966	BUTTON, INSIGNIA, 19mm Honourable Artillery Company, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
182.	TL1044189	973-0444	23547	BUTTON, INSIGNIA, 18mm (28L) Honourable Artillery Company, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
183.	TL1044190	973-0513	23497	BUTTON, INSIGNIA, 14mm Honourable Artillery Company, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
184.	TL1044191	973-0514	15748	BUTTON, INSIGNIA, 25mm Honourable Artillery Company, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
185.	TL1044192	973-0515	23498	BUTTON, INSIGNIA, 19mm Honourable Artillery Company, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
186.	TL1044193	973-0522	23163	BUTTON, INSIGNIA, 19mm The London Scottish Company, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
187.	TL1044194	973-0529	21687	BUTTON, INSIGNIA, 14mm Special Air Service Regiment, Officers	Aluminium, anodised silver. Shade to conform to pattern 15456.
188.	TL1044195	973-0530	19914	BUTTON, INSIGNIA, 25mm Special Air Service Regiment, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
189.	TL1044196	973-0531	20706	BUTTON, INSIGNIA, 19mm Special Air Service Regiment, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
190.	TL1044212	973-1123	21006	BUTTON, INSIGNIA, 14mm The Queen's Dragoon Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
191.	TL1044213	973-1124	17870	BUTTON, INSIGNIA, 25mm The Queen's Dragoon Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
192.	TL1044214	973-1125	23162	BUTTON, INSIGNIA, 19mm The Queen's Dragoon Guards, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
193.	TL1044215	973-1145	21018	BUTTON, INSIGNIA, 25mm Army Air Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
194.	TL1044216	973-1146	20649	BUTTON, INSIGNIA, 19mm Army Air Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.

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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
195.	TL1044217	973-1149	24040	BUTTON, INSIGNIA, 14mm The Gibraltar Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
196.	TL1044218	973-1151	23686	BUTTON, INSIGNIA, 19mm The Gibraltar Regiment, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
197.	TL1044219	973-1156	22678	BUTTON, INSIGNIA, 25mm The Queen's Gurkha Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
198.	TL1044220	973-1157	22918	BUTTON, INSIGNIA, 19mm The Queen's Gurkha Engineers, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
199.	TL1044221	973-1207	21361	BUTTON, INSIGNIA, 14mm Royal Armoured Corps, Soldiers	Aluminium, anodised gold. Shade to conform to pattern 19508.
200.	TL1044222	973-1228	20829	BUTTON, INSIGNIA, 14mm Small Arms School Corps, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
201.	TL1044223	973-1230	23103	BUTTON, INSIGNIA, 19mm Small Arms School Corps, All Ranks	Aluminium, anodised silver. Shade to conform to pattern 15456.
202.	TL1044224	973-1288	20943A	BUTTON, INSIGNIA, 23mm (37L) Queen Victoria's School, Pipers	Aluminium, anodised silver. Shade to conform to pattern 15456
203.	TL1044225	973-1289	22378	BUTTON, INSIGNIA, 19mm Queen Victoria's School, Pipers	Aluminium, anodised silver. Shade to conform to pattern 15456.
204.	TL1044835	978-4472	22620	BUTTON, INSIGNIA, 17mm Royal Navy, Flag Officer	Aluminium, anodised gold. Shade to conform to pattern 27790. Supplied with cotter pin. Shank to be 9mm in length
205.	TL1044836	978-4473	22619	BUTTON, INSIGNIA, 17mm Royal Navy, Queen Alexandra's Royal Naval Nursing Service	Aluminium, anodised gold. Shade to conform to pattern 27790. Supplied with cotter pin. Shank to be 9mm in length
206.	TL1044837	978-4474	22621	BUTTON, INSIGNIA, 17mm Royal Navy Marine Services, Flag Officer	Aluminium, anodised gold. Shade to conform to pattern 27790. Supplied with cotter pin. Shank to be 9mm in length



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

Item No.	TL Number	NATO Stock Number 8455-99-	Pattern No.	Description	Additional Information
207.	TL1044916	978-8919	35/R/2199	BUTTON, INSIGNIA, 19mm Royal Air Force, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
208.	TL1044920	978-8935	24790	BUTTON, INSIGNIA, 14mm Royal Logistic Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
209.	TL1044921	978-8936	24791	BUTTON, INSIGNIA, 19mm Royal Logistic Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
210.	TL1044922	978-8937	24792	BUTTON, INSIGNIA, 25mm Royal Logistic Corps, All Ranks	Aluminium, anodised gold. Shade to conform to pattern 19508.
211.	TL1044923	978-8938	24793	BUTTON, INSIGNIA, 19mm, SCREW FIT Royal Logistic Corps, Officers	Aluminium, anodised gold. Shade to conform to pattern 19508.



**Technical Specification for  
BADGES AND INSIGNIA  
ANODIZED ALUMINIUM ALLOY**

**Defence Clothing (DC)**

PROPERTY OF  
MINISTRY OF DEFENCE



PREFACE

TABLE 1 – PRODUCT LIST

Item Name	Badges and Insignia, Anodised Aluminium Alloy		
TL Ref.No.	NATO Stock No 8465-99-:	Description	Pattern No.
See Table 7	See Table 7	Various Badges and Insignia	See Table 7

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

IPR STATEMENT

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**Technical documents in this specification refer to the edition current at the date of tender or contract unless otherwise stated.**

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date																				
18	NSN 8455-99-551-5186 Pattern updated to 'A' version	22 February 2021																				
17	Deletion of obsolete NSNs 8455-99-973-9930 Reformatted throughout	19 August 2020																				
16	<p>Specification title changed to better reflect contents</p> <p>BS EN 485 and BS EN 515 removed from Table 3 and Table 4.1 to 4.2. Not required to specify required aluminium grade</p> <p>TL Numbers added to Table 8</p> <p>Table 4.4, removed melton cloth as not used in specification and added more detail for velvet cloth</p> <p>Table 5.4, removed suggested degreaser - perchloroethylene</p> <p>Table 5.5 to 5.11, inserted details of insignia back fittings</p> <p>Table 5.12, inserted details of velvet</p> <p>Table 5.15, "Stop-off/Masking" re-inserted (deleted at Issue 15)</p> <p>Table 5 existing entries renumbered to accommodate insertions above</p> <p>Table 6 – test requirements for dry cleaning and abrasion resistance removed. Subsequent Tables, renumbered.</p> <p>Table 7 – additional information reviewed and updated as necessary for all items</p> <p>NSN 8455-99-130-3809 – pattern up-issued for</p> <p>NSN 8455-99-122-2900 – additional information corrected, remove "Supplied in pairs"</p> <p>Deletion of obsolete NSNs 8455-99-:</p> <table border="0" data-bbox="311 1429 1125 1563"> <tr> <td>136-4540</td> <td>136-5271</td> <td>138-3960</td> <td>517-5529</td> <td>517-5544</td> </tr> <tr> <td>517-5548</td> <td>724-8162</td> <td>724-8166</td> <td>724-8176</td> <td>883-3371</td> </tr> <tr> <td>973-8867</td> <td>973-9092</td> <td>973-9510</td> <td>973-9513</td> <td>973-9514</td> </tr> <tr> <td>974-0420</td> <td>974-2230</td> <td></td> <td></td> <td></td> </tr> </table>	136-4540	136-5271	138-3960	517-5529	517-5544	517-5548	724-8162	724-8166	724-8176	883-3371	973-8867	973-9092	973-9510	973-9513	973-9514	974-0420	974-2230				16 March 2020
136-4540	136-5271	138-3960	517-5529	517-5544																		
517-5548	724-8162	724-8166	724-8176	883-3371																		
973-8867	973-9092	973-9510	973-9513	973-9514																		
974-0420	974-2230																					
15	<p>Para 5 - Packaging &amp; Labelling Requirements– amended</p> <p>Deletion of obsolete NSNs 8455-99-:</p> <table border="0" data-bbox="311 1664 1125 1731"> <tr> <td>517-5540</td> <td>724-8150</td> <td>961-3552</td> <td>973-9382</td> <td>974-0366</td> </tr> <tr> <td>974-1233</td> <td>974-2178</td> <td>974-2182</td> <td></td> <td></td> </tr> </table> <p>Deletion of NSN 8315-99-973-0644, transferred to UK/SC/6723 at Issue 5</p>	517-5540	724-8150	961-3552	973-9382	974-0366	974-1233	974-2178	974-2182			29 August 2017										
517-5540	724-8150	961-3552	973-9382	974-0366																		
974-1233	974-2178	974-2182																				
	See Issue 14 for previous table of amendments																					

PART 1

1. THE PRODUCT

Anodised aluminium badges and insignia in gold, silver and black, for wear by the Armed Forces.

TABLE 3 - RELATED SPECIFICATIONS AND DOCUMENTS

<b>Specification/Document</b>	<b>Detail</b>
BS EN ISO 7599	Anodizing of aluminium and its alloys - General specifications for anodic oxidation coatings on aluminium
BS EN 573 Part 3	Aluminium and aluminium alloys - Chemical composition and form of wrought products Chemical composition and form of products
BS EN 1652	Copper and copper alloys - Plate, sheet, strip and circles for general purposes
BS ISO 2135	Anodizing of aluminium and its alloys - Accelerated test of light fastness of coloured anodic oxidation coatings using artificial light

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

This specification defines the requirements for aluminium badges, insignia and other distinguishing items, and the components used in their construction.

TABLE 4 – PRODUCT COMPONENTS

4.1 Insignia	Bright anodising quality, aluminium sheet to meet the requirements of BS EN 573 Part 3, EN AW-1080A-H14 or an alternative approved by DC.  The metal used is to be 1.65mm minimum thickness. The insignia may be of a heavier gauge of aluminium to enable the definition of Standard Pattern to be reproduced.
4.2 Vertical hook, fusion pins and lugs	Bright anodising quality aluminium sheet to meet the requirements of BS EN 573 Part 3, EN AW-1200-H16 or an alternative approved by DC.
4.3 Brass backing plates and cotter pins	To comply with the requirements of BS EN 1652 or an alternative approved by DC.
4.4 Embellishments	Cloth, velvet, of good commercial quality to match cloth used on Standard Pattern.  Colour of velvet to be a good match to the Standard Pattern.

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Stamping	The Insignia is to be formed using a suitable die to raise the impression of the design, using either a flat force or a shell backed force.  The clearness and fullness of the die design is to be impressed and have a well-defined struck edge.
5.2 Clipping	The surplus material from the stamping is to be removed using a suitable press tool.  The edges of the Insignia are to be clean and free from burrs or rough edges.
5.3 Piercing	The Insignia is to be correctly located in the piercing bed to ensure a clean finish.  All edges and piercings are to be clean and free from burrs or rough edges.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

5.4 Degreasing	The Insignia are to be immersed in a suitable degreasing agent, for a minimum of twenty seconds.
5.5 Lugs	The lugs are to be formed from wire, strip or stamped/pierced sheet. The hole shall be between 2.5mm and 3mm diameter. Alternatively for stamped/pierced lugs a slot 1.5mm by 4mm may be used. The height of the lugs shall be measured from the back face of the insignia to the centre of the hole.
5.6 Cotter pin	The cotter pin shall be formed from 1.0mm diameter brass wire. The length of the cotter pin shall be such that the open end protrudes between 5mm and 10mm from lug when inserted through a pair of lugs. For a single lug it shall protrude 15mm to 20mm.
5.7 Backing plate	The plate shall be stamped and pierced from 0.5mm thick brass sheet. The holes shall be positioned so that lugs on insignia pass cleanly through.
5.8 Vertical hook	The hook shall be formed from 1.5mm thick by 6mm wide strip. The hook shall have a 5mm long turn for attachment to back of badge/insignia. The hook shall have an overall length of 40mm.
5.9 Fusion pin	Fusion pins shall be formed from 1.0mm diameter wire with a 2.5mm diameter fusion head. The pin shall have an overall length of 8.0mm and be finished with a point. The pin shall have 3 grooves positioned 2mm from point and then 2mm apart.
5.10 Clutch fastener	The clutch fastener shall be formed from self finish brass and be complete with a pair of spring butterfly's which shall firmly grip the fusion pin at 5.9. The clutch fastener is to be 12mm diameter by 5mm high.
5.11 Folding tags	The tags shall be made from 0.6mm thick aluminium. They shall be 15mm long by 4mm wide with pointed ends. To be supplied unfolded.
5.12 Velvet	Velvet to be securely retained on back of insignia by brass backing plate Velvet to be cut to fully fill behind pierced area of insignia with no excess material visible beyond the external edges of the insignia.

TABLE 5 – PRODUCT CONSTRUCTION CONTINUED

<p>5.13 Soldering or fusion welding of vertical hooks, folding tags, fusion pins and lugs</p>	<p>When possible the operations of soldering or fusion welding should be completed before anodizing is commenced.</p> <p>All parts to be soldered are to be completely joined with the minimum of solder.</p> <p>Flux and excess solder is to be removed, leaving all joins clean, strong and smooth.</p> <p>Burned or reduced areas will not be acceptable.</p> <p>Fusion welding when used is to result in a clean finish with no burning to the front of the Insignia.</p> <p>Extruded lugs used on multi-part Insignia are to be firmly secured to ensure no movement of the mount.</p>
<p>5.14 Cleaning</p>	<p>The Insignia are to be thoroughly cleaned with a suitable cleaning agent to remove all undesirable matter such as oil, grease and metallic particles accumulated from the manufacturing process.</p> <p>The Insignia are to be well rinsed to remove any remaining cleaning agent.</p>
<p>5.15 Stop-off / Masking</p>	<p>For two colour single part Insignia it will be necessary to use a suitable masking agent, which is to be cleaned after sealing or bleeding out.</p> <p>No trace of the agent is to be visible.</p>
<p>5.16 Polishing / Anodising</p>	<p>The complete Insignia is to be degreased, electro and/or chemically polished, bright anodised, sealed and dried.</p> <p>For Army, RAF and Royal Marines gold items, Standard Pattern No.19508 shade box shall be used to judge for colour variation to either Set A (detailed design) or Set B (plain or inconspicuous design).</p> <p>For Royal Navy gold items, Standard Pattern No.27790 shade box shall be used to judge for colour variation to either Set A (detailed design) or Set B (plain or inconspicuous design).</p> <p>For all silver items, Standard Pattern No.15456 shade box shall be used to judge for colour variation.</p> <p>Black items to be to the relevant Standard Pattern indicated by pattern number in Table 7 for brightness and colour.</p> <p>The significant surface is the Insignia front.</p>



4. PERFORMANCE

a. Visual Requirement of Finished Insignia

The Insignia are to be compared against the appropriate Standard Pattern for mechanical imperfections and any streakiness or unequal colouring of the dyed film. They are to be viewed, under no magnification, at a distance of between 30cm to 40cm in daylight or in a daylight colour-matching booth. The colour and brightness are to conform to the Polishing/Anodising clause in Table 5 of this specification.

b. Anodic Film requirements are to be as Table 6

TABLE 6 – ANODIC FILM REQUIREMENTS

Property	Requirement	Method of Test
Coating thickness	Class AA10	To Clause 6 of BS EN ISO 7599
Quality of sealing	No bloom after 24 hours exposure to test conditions	To Clauses 7 of BS EN ISO 7599
Fastness to light	Standard 8	To BS ISO 2135
Tropical exposure	No visible contrast with the Standard Pattern	Four insignia are to be stored in a suitable tropical chamber for a period of 28 days at 32° and 90% RH After this period if none of the insignia have changes in appearance the insignia are acceptable

5. PACKAGING & 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. Badges, insignia, titles etc are to be fully assembled i.e. backing plates and cotter pins attached where applicable. They are to be sealed (pairs or each) in a clear polythene bag.
- d. Under no circumstances should the contractor's name, logo or trademark appear on the items or packaging.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
1.	TL1041991	000-4822	30395	Insignia, Rank, Shoulder Strap Field Marshall, Army	Aluminium, anodised gold. Two piece design. Crossed Batons in Wreath – H26mm x W30mm, St Edwards Crown – H13mm x W14mm. 2 x horizontal lugs on each part H6mm, 22mm apart on wreath and 7mm apart on crown, mounted centrally. Complete with 2 cotter pins. Supplied in pairs.
2.	TL1042001	122-2890	35/R/1596	Badge, Qualification, Sleeve Drummer, Royal Air Force	Aluminium, anodised gold. Drum – H31mm x W26mm. 2 x vertical lugs H3mm, 17mm apart, mounted centrally. Complete with cotter pin and back plate.
3.	TL1042002	122-2892	35/R/1573	Badge, Qualification, Sleeve Volunteer Bandsman, Royal Air Force	Aluminium, anodised gold. Lyre – H36mm x W44mm. 2 x horizontal lugs H6mm, 36mm apart, mounted centrally. Complete with cotter pin and back plate.
4.	TL1042003	122-2893	35/R/1581A	Badge, Qualification, Collar Dental Orderly, Royal Air Force	Aluminium, anodised gold. 'DB' within a wreath of laurels with wings either side – H13mm x W39mm. 2 x horizontal lugs H6mm, 22mm apart, mounted centrally. Complete with cotter pin and back plate.
5.	TL1042004	122-2894	35/R/1566	Badge, Qualification, Arm Aircrew, Royal Air Force	Aluminium, anodised gold. RAF eagle, left facing – H12mm x W37mm 2 x horizontal lugs H6mm, 36mm apart, mounted centrally. Complete with back plate and cotter pin. Worn on left arm
6.	TL1042005	122-2895	35/R/1583	Badge, Qualification, Arm Aircrew, Royal Air Force	Aluminium, anodised gold. RAF eagle, right facing – H12mm x W37mm 2 x horizontal lugs H6mm, 36mm apart, mounted centrally. Complete with back plate and cotter pin. Worn on right arm.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
7.	TL1042006	122-2897	35/R/1598	Badge, Qualification, Arm Bandsman, Royal Air Force	Aluminium, anodised gold. Lyre – H50mm x W42mm. 2 x vertical lugs H6mm, 32mm apart, mounted centrally. Complete with cotter pin and back plate.
8.	TL1042007	122-2898	35/R/1565	Insignia, Rank, Arm Flight Sergeant, Royal Air Force	Aluminium, anodised gold. St Edwards Crown – H28mm x W29mm. 2 x vertical lugs H3mm, 16mm apart, mounted centrally. Complete with cotter pin.
9.	TL1042008	122-2900	35/R/1557	Badge, Qualification, Collar Medical, Royal Air Force	Aluminium, anodised gold. Winged Caduceus with St Edwards crown – H27mm x W23mm. 1 x horizontal lugs H4mm, mounted centrally. Complete with cotter pin and back plate.
10.	TL1042009	122-2902	35/R/1574	Insignia, Organisation, Shoulder Title Air Training Corps	Aluminium, anodised gold. Letters 'ATC' – H10mm x W23mm. 2 x horizontal lugs H4mm, 13mm apart, mounted centrally. Complete with cotter pin. Supplied in pairs,
11.	TL1042010	122-2904	35/R/1560	Insignia, Organisation, Cap Airman, Royal Air Force	Aluminium, anodised gold. Letters 'RAF' in wreath with crown – H44mm x W39mm. 2 x horizontal lugs H10mm, 30mm apart, mounted centrally. Complete with cotter pin and back plate.
12.	TL1042011	122-2907	35/R/1559	Insignia, Organisation, Cap, Small Warrant Officer & Master Aircrew, Royal Air Force	Aluminium, anodised gold. Black paint between eagle and crown Eagle over four leaves surmounted by St Edwards crown backed with a half plate covered in red velvet – H42mm x W41mm 2 x horizontal lugs H7mm, 30mm apart, mounted centrally Complete with cotter pin.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
13.	TL1042019	122-4096	19989	Insignia, Organisation, Cap Royal Army Medical Corps, Soldiers	Aluminium, anodised gold and silver. The Rod of Aesculapius in gold with a Serpent entwined in silver, within a gold wreath of laurels surmounted by a St Edwards crown. Below is a silver scroll inscribed 'IN ARDUIS FIDELIS'. – H43mm x W30mm. With vertical hook mounted 7mm from top.
14.	TL1042022	122-5469	20066	Badge, Qualification Drummers, Army	Aluminium, anodised silver. Drum – H31mm x W26mm. 2 x vertical lugs H3mm, 17mm apart, mounted centrally. Complete with cotter pin and back plate.
15.	TL1042026	122-6970	20116	Insignia, Organisation, Cap East Midlands Universities Officer Training Corps	Aluminium, anodised gold and silver. Silver maltese Cross, wreath and stag, surmounted by a crown, gold scroll beneath 'EAST MIDLANDS' – H51mm x W43mm With vertical hook. mounted 7mm from top.
16.	TL1042098	127-9653	21238	Insignia, Organisation. Shoulder Title Royal Regiment of Fusiliers, All Ranks	Aluminium, anodised gold. Letters 'RRF' – H10mm x W25mm. 2 x horizontal fusion pins, 19mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
17.	TL1042105	130-2736	20780	Insignia, Organisation, Shoulder Title The Queen's Dragoon Guards, All Ranks	Aluminium, anodised gold. Letters 'QDG' – H10mm x W24mm. 2 x horizontal fusion pins, 17mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
18.	TL1042184	130-3670	30170	Insignia, Rank, Shoulder Strap Eversleigh Star, Royal Welsh	Aluminium, anodised gold, 2 part design Low bake enamelled, green wreath, red garter and dark blue motto. Front to be attached to rear with 2 fold over tabs. – H/W 28.5mm. 2 x horizontal lugs H7mm, 20mm apart, mounted centrally. Complete with cotter pin.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
19.	TL1042185	130-3671	30171	Insignia, Rank, Shoulder Strap Crown, Small, Royal Welsh	Aluminium, anodised gold. St Edwards Crown with crimson velvet backing and brass backplate – H28mm x W26mm. 2 x vertical lugs H3mm, 17mm apart, mounted centrally. Complete with cotter pin.
20.	TL1042195	130-3799	30299	Insignia, Organisation, Cap Royal Army Chaplains' Department, Christian Officers	Aluminium, painted gloss black. Upon a wreath of laurel and oak a Maltese Cross. In the centre a quatrefoil voided with a circle inscribed with the motto: 'IN THIS SIGN CONQUER'. The whole ensigned with the Crown – H44m x W33mm. 2 x horizontal folding tags 27mm apart on sides of cross.
21.	TL1042198	130-3809	30309A	Insignia, Organisation, Cap Royal Army Chaplains Department, Jewish Officers	Aluminium, painted gloss black. Upon a wreath of a laurel and oak a Star of David. In the centre of the Star, a circle containing a quatrefoil voided. The whole ensigned with the Crown – H45m x W35mm. 2 x horizontal folding tags 27mm apart.
22.	TL1042236	130-3924	30424	Insignia, Rank, Shoulder Strap Crown, Large	Aluminium, anodised gold. St Edwards Crown with scarlet velvet backing and brass backplate – H25mm x W23mm. 2 x vertical fusion pins, 20mm apart, mounted centrally. Complete with 2 clutch fasteners.
23.	TL1042237	130-3925	30425	Insignia, Rank, Shoulder Strap Crown, Small	Aluminium, anodised gold. St Edwards Crown with crimson velvet backing and brass backplate – H21mm x W21mm. 2 x vertical fusion pins, 14mm apart, mounted centrally. Complete with 2 clutch fasteners.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
24.	TL1042239	130-3929	30429	Insignia, Rank, Shoulder Strap Bath Star, Large	Aluminium, anodised gold. Low bake enamelled, green wreath and dark red moto. Star surmounted by Maltese Cross, wreath of laurels, Order of Bath moto 'TRIA JUNCTA IN UNO' with three crowns in centre – H/W 31mm point to point. 2 x horizontal fusion pins, 19mm apart, mounted centrally. Complete with 2 clutch fasteners.
25.	TL1042240	130-3930	30430	Insignia, Rank, Shoulder Strap Bath Star, Small	Aluminium, anodised gold. Low bake enamelled, green wreath and dark red moto. Star surmounted by Maltese Cross, wreath of laurels, Order of Bath moto 'TRIA JUNCTA IN UNO' with three crowns in centre – H/W 23mm point to point. 2 x horizontal fusion pins, 18mm apart, mounted centrally. Complete with 2 clutch fasteners.
26.	TL1042243	130-3946	30444	Insignia, Rank, Shoulder Strap Crown, Large	Aluminium, anodised gold and silver. St Edwards Crown with scarlet velvet backing and brass backplate – H24mm x W24.5mm. 2 x vertical fusion pins, 16mm apart, mounted centrally. Complete with 2 clutch fasteners.
27.	TL1042244	130-3947	30445	Insignia, Rank, Shoulder Strap Crown, Small	Aluminium, anodised gold and silver. St Edwards Crown with scarlet velvet backing and brass backplate – H22mm x W22mm. 2 x vertical fusion pins, 14mm apart, mounted centrally. Complete with 2 clutch fasteners.
28.	TL1042275	130-5781	22609	Insignia, Organisation, Cap Exeter University Officer Training Corps	Aluminium, anodised gold and silver. Silver castle overlaid with gold dragon, gold scroll beneath 'EXETER UNIVERSITY OTC' – H40mm x W37mm With vertical hook. mounted 4mm from top.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
29.	TL1042539	135-6864	24604	Insignia, Organisation, Shoulder Title Royal Electrical & Mechanical Engineers, All Ranks	Aluminium, anodised gold. Letters 'REME' – H10mm x W36.5mm. 2 x horizontal fusion pins, 26mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
30.	TL1042546	135-8488	20349	Insignia, Organisation, Bonnet Tayforth University Officer Training Corps	Aluminium, anodised gold and silver. Gold wreath of laurels overlaid with silver sword, silver scroll beneath 'TAY FORTH UOTC' – H75mm x W48mm 2 x horizontal lugs H6mm, 34mm apart, mounted centrally on wreath. Complete with cotter pin.
31.	TL1042547	135-8941	20371	Insignia, Organisation, Cap Royal Scots Dragoon Guards, Soldiers	Aluminium, anodised gold and silver. An Eagle with a wreath of laurels on the breast upon a plume inscribed WATERLOO super-imposed upon a pair of carbines crossed with a scroll across the butts inscribed ROYAL SCOTS DRAGOON GUARDS. The Eagle in silver remainder in gold. The Eagle faces left. – H47mm x W40mm With vertical hook, mounted centrally 9mm from top.
32.	TL1042551	135-9216	V38982	Insignia, Organisation, Shoulder Title Royal Marines Reserve	Aluminium, anodised gold. Letters 'RMR' – H12mm x W36mm 2 x horizontal lugs H5mm, 25mm apart, mounted centrally Complete with cotter pin. Supplied in pairs
33.	TL1042561	135-9875	22617	Insignia, Organisation, Shoulder Title Army Cadet Force, All Ranks	Aluminium, anodised gold. Letters 'ACF' – H12mm x W31mm 2 x horizontal fusion pins, 23mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
34.	TL1042562	135-9878	24161	Insignia, Organisation, Shoulder Title Special Air Service, All Ranks	Aluminium, anodised black. Letters 'SAS' – H10mm x W23mm 2 x horizontal fusion pins, 18mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
35.	TL1042571	136-2693	21614	Insignia, Organisation, Shoulder Title Royal Army Veterinary Corps	Aluminium, anodised gold. Letters 'RAVC' – H10.5mm x W44mm 2 x horizontal fusion pins, 35mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
36.	TL1042576	136-4746	20530	Insignia, Organisation, Cap The Queen's Own Yeomanry, Soldiers	Aluminium, anodised gold and silver. Gold fox, silver scroll beneath 'QUEEN'S OWN YEOMANRY' – H28mm x W55mm With vertical hook, mounted centrally 3mm from top.
37.	TL1042577	136-4808	20827	Insignia, Organisation, Shoulder Title Royal Army Dental Corps, All Ranks	Aluminium, anodised gold. Letters 'RADC' – H10.5mm x W42mm 2 x horizontal fusion pins, 29mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
38.	TL1042580	136-5692	23274	Insignia, Organisation, Shoulder Title The Intelligence Corps, All Ranks	Aluminium, anodised gold. Letters 'INT CORPS', arc design – H10.5mm x W59mm 2 x horizontal fusion pins, 37mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
39.	TL1042582	136-5882	20577A	Insignia, Organisation, Shoulder Title Combined Cadet Force, All Ranks	Aluminium, anodised gold. Letters 'C.C.F' – H11mm x W30mm 2 x horizontal fusion pins, 24mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
40.	TL1042589	137-0107	20698	Insignia, Rank, Wrist Strap Master At Arms, Royal Navy	Aluminium, anodised gold. St Edwards crown within a wreath of laurels – H45mm x W51mm 2 x horizontal lugs H8mm, 38mm apart, mounted centrally on wreath. Complete with cotter pin and back plate.



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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
41.	TL1042594	137-0727	20730	Insignia, Rank, Wrist Strap Warrant Officer Class 2, Queen Alexander Royal Army Nursing Corps	Aluminium, anodised gold. St Edwards crown within a wreath of laurels – H27mm x W36mm 2 x horizontal lugs H7mm, 28mm apart, mounted centrally on wreath. Complete with cotter pin and back plate.
42.	TL1042646	138-0880	21205	Insignia, Organisation, Cap City of Edinburgh University Officer Training Corps	Aluminium, anodised gold and silver. Silver St Andrews saltire overlaid with gold open book and St Edwards crown – H53mm x W50mm With vertical hook. mounted 11mm from top.
43.	TL1042647	138-0881	21206	Insignia, Organisation, Sporan City of Edinburgh University Officer Training Corps	Aluminium, anodised gold and silver. Silver St Andrews saltire overlaid with gold open book and St Edwards crown – H27mm x W25mm 2 x horizontal lugs H4mm, 12mm apart, mounted centrally on book. Complete with cotter pin.
44.	TL1042708	157-9354	19798	Insignia, Rank, Sleeve Master Gunner 1st Class, Royal Regiment of Artillery, & Conductor, Royal Logistic Corps	Aluminium, anodised gold. Royal arms within a wreath of laurels – H42mm x W42mm 2 x horizontal lugs H4mm, 21mm apart, mounted centrally. Complete with cotter pin and back plate.
45.	TL1042710	175-1537	20601	Insignia, Rank, Sleeve Quartermaster Sergeants, Colour Sergeants & Staff Sergeants	Aluminium, anodised gold. St Edwards crown – H32mm x W32mm 2 x horizontal lugs H6mm, 19mm apart, mounted centrally. Complete with cotter pin and back plate.
46.	TL1042724	189-4841	D00280	Insignia, Organisation, Cap, D (London Irish Rifles) Company, The London Regiment	Aluminium, anodised silver. Harp surmounted by a St Edwards crown – H47mm x W24mm With vertical hook. mounted 12mm from top.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
47.	TL1042740	227-3296	30410	Insignia, Rank, Shoulder Strap General Officer	Aluminium, anodised gold. Crossed sword and baton – H33mm x W44mm 4 x horizontal lugs H6mm, 28mm apart, mounted centrally. Complete with 2 cotter pins. Handed design. Supplied in pairs.
48.	TL1042744	227-6485	30432	Insignia, Rank, Shoulder Strap Bath Star, Small	Aluminium, anodised black. Star surmounted by Maltese Cross, wreath of laurels, Order of Bath motto 'TRIA JUNCTA IN UNO' with three crowns in centre – H/W 23mm point to point. 2 x horizontal fusion pins, 11mm apart, mounted centrally. Complete with 2 clutch fasteners.
49.	TL1042748	236-1785	18983	Insignia, Rank, Wrist Strap Warrant Officer Class 2, Light Infantry & Royal Irish Regt	Aluminium, anodised silver. St Edwards crown within a wreath of laurels – H44mm x W59mm 2 x horizontal lugs H7mm, 47mm apart, mounted centrally on wreath. Complete with cotter pin and back plate.
50.	TL1042829	301-7058	30103	Insignia, Rank, Shoulder Strap Thistle Star, Scots Guards	Aluminium, anodised gold. Star surmounted by garter with Order of the Thistle motto 'NEMO ME IMPUNE LACESSIT', with thistle in centre – H/W 29mm point to point. 2 x horizontal lugs H5mm, 19mm apart, mounted centrally on star. Complete with cotter pin.
51.	TL1042832	302-2262	30176	Insignia, Rank, Shoulder Strap Bath Star, Minature	Aluminium, anodised gold. Star surmounted by Maltese Cross, wreath of laurels, Order of Bath motto 'TRIA JUNCTA IN UNO' with three crowns in centre – H/W 14mm point to point. 2 x horizontal lugs H4mm, 10mm apart, mounted centrally on star. Complete with cotter pin.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
52.	TL1042860	337-9078	21442	Insignia, Rank, Wrist Strap Strap, Bugle, Drum, Pipe & Trumpet Major	Aluminium, anodised silver. Chevron 4 bar – H22mm x W24mm 2 x vertical lugs H6mm, 9mm apart, mounted centrally. Complete with cotter pin.
53.	TL1042942	396-1687	D01080	Insignia, Organisation, Collar Special Boat Service	Aluminium, anodised gold and silver. 2 gold waves overlaid by silver dagger with motto 'BY STRENGTH AND GUILLE' – H34mm x W26mm 2 x horizontal lugs H5mm, 20mm apart, mounted on moto. Complete with cotter pin. Supplied in pairs.
54.	TL1042970	409-9787	20843	Insignia, Organisation, Shoulder Title Royal Military Police, All Ranks	Aluminium, anodised gold. Letters 'RMP' – H10mm x W32mm 2 x horizontal fusion pins, 24mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
55.	TL1042971	409-9795	22874	Insignia, Organisation, Shoulder Title Royal Anglian Regiment. All Ranks	Aluminium, anodised gold. Letters 'ROYAL ANGLIAN' – H20mm x W52mm 2 x horizontal fusion pins, 29mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
56.	TL1043024	416-4222	23075	Insignia, Organisation, Cap Royal Marines, Officers	Aluminium, anodised gold and silver. Silver globe within a gold wreath of laurels – H33mm x W38mm 2 x horizontal lugs H8mm, 30mm apart, mounted centrally on wreath. Complete with cotter pin.
57.	TL1043025	416-4223	22675	Insignia, Organisation, Cap Royal Marines, Officers	Aluminium, anodised gold. St Edwards crown & lion – H19mm x W12mm Brass screw fitting 12mm long x M3 attached centrally at base of crown with 2mm long locating spike 12 mm above, complete with Ø13mm knurled nut.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
58.	TL1043111	416-5491	23010	Insignia, Organisation, Cap/Beret Royal Marines, All Ranks	Aluminium, anodised gold. St Edwards crown & lion – H19mm x W12mm Complete with 30mm long vertical pin fitting attached at centre of crown.
59.	TL1043113	416-5493	23129	Insignia, Organisation, Cap Royal Marines	Aluminium, anodised gold. Globe, within wreath of laurels, surmounted by St Edwards crown & lion – H47mm x W39mm 2 x horizontal lugs H8mm, 28mm apart, mounted centrally on wreath. Complete with cotter pin.
60.	TL1043123	416-5503	22082	Insignia, Organisation, Collar Royal Marines, All Ranks	Aluminium, anodised gold. Globe within wreath of laurels – H33mm x W39mm 2 x horizontal lugs H8mm, 30mm apart, mounted centrally on wreath. Complete with cotter pin.
61.	TL1043125	416-5508	22037	Insignia, Organisation, Shoulder Title Royal Marines	Aluminium, anodised gold. Letters 'RM' – H13mm x W23mm 2 x horizontal lugs H5mm, 18mm apart, mounted centrally. Complete with cotter pin and back plate.
62.	TL1043127	416-5518	23237	Insignia, Rank, Wrist Strap Warrant Officer, Royal Navy	Aluminium, anodised gold. Royal arms – H39mm x W40mm. 2 x horizontal lugs H5mm, 24mm apart, mounted 22mm from base. Complete with cotter pin and back plate.
63.	TL1043130	416-5522	22083	Insignia, Rank, Wrist Strap Quartermaster Sergeant, Royal Marines	Aluminium, anodised gold. St Edwards crown within a wreath of laurels – H59mm x W44mm. 2 x horizontal lugs H7mm, 49mm apart, mounted centrally. Complete with cotter pin and back plate.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
64.	TL1043153	416-5652	22373	Insignia, Organisation, Shoulder Title Sea Cadet Corps Marine Cadets	Aluminium, anodised gold. 'MARINE CADETS' around letters 'SCC' – H28mm x W39mm. 2 x horizontal lugs H6mm, 16mm apart, mounted centrally at top of letters SCC. Complete with cotter pin and back plate.
65.	TL1043228	426-3171	D00863	Insignia, Organisation, Shoulder Title Royal Welsh	Aluminium, anodised gold. Letters 'R WELSH' – H11mm x W46mm 2 x horizontal fusion pins, 37mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs
66.	TL1043238	428-7144	19279	Insignia, Organisation, Cap Royal Anglian Regiment	Aluminium, anodised gold and silver. Gold Gibraltar Castle and Key with scroll 'Royal Anglian' riveted centrally on a silver 8 pointed star – H30mm x W30mm. With vertical hook. mounted centrally 6mm from top.
67.	TL1043250	436-1944	22139	Insignia, Rank, Wrist Strap Bugle, Drum, Pipe & Trumpet Major	Aluminium, anodised gold. Chevron 4 bar – H22mm x W24mm 2 x vertical lugs H6mm, 9mm apart, mounted centrally. Complete with cotter pin.
68.	TL1043251	446-5873	30411	Insignia, Rank, Shoulder Strap General Officer	Aluminium, anodised gold. Crossed sword and baton – H22mm x W37mm. 2 x horizontal lugs H7mm, 33mm apart, mounted centrally on batton. Complete with cotter pin. Handed design. Supplied in pairs.
69.	TL1043293	492-9332	30412	Insignia, Rank, Shoulder Strap General Officer	Aluminium, anodised gold. Crossed sword and baton – H20mm x W32mm. 2 x horizontal lugs H7mm, 27mm apart, mounted centrally on batton. Complete with cotter pin. Handed design. Supplied in pairs.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
70.	TL1043415	517-5503	22399	Insignia, Organisation, Collar Royal Army Veterinary Corps, Soldiers	Aluminium, anodised gold and silver. Silver centaur within gold wreath of laurels surmounted by St Edwards crown and on scroll inscribed 'ROYAL ARMY VETERINARY CORPS' – H37mm x W27mm. 1 x vertical lug H5mm, mounted centrally on centaur. Complete with cotter pin and back plate. Handed design. Supplied in pairs.
71.	TL1043416	517-5504	18080	Insignia, Organisation, Collar 1st Battalion, Royal Anglian Regiment, Soldiers	Aluminium, anodised gold and silver. Gold Gibraltar Castle and Key with silver Britannia super-imposed. Britannia figures to be inward facing – H24mm x W25mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Handed design. Supplied in pairs.
72.	TL1043417	517-5505	18300	Insignia, Organisation, Collar 2 <sup>nd</sup> Battalion, Royal Anglian Regiment, Soldiers	Aluminium, anodised gold and silver. Silver sphinx with 'EGYPT' inscribed beneath on gold 'TALAVERA' scroll. Sphinxes to be inward facing – H30mm x W36mm. 1 x vertical lug H5mm, mounted centrally. Complete with cotter pin and back plate. Handed design. Supplied in pairs.
73.	TL1043419	517-5508	25020	Insignia, Organisation, Collar Queen Alexandra's Royal Army Nursing Corps, Soldiers	Aluminium, anodised gold and silver. Gold Cypher of HM the late Queen Alexandra combined with the Dannebrog, the whole within a wreath of laurels inscribed with the Corps motto 'SUB CRUCE CANDIDA' surmounted with a crown. On the lower portion of the wreath is a silver scroll inscribed 'Q.A.R.A.N.C' – H34mm x W20mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Handed design. Supplied in pairs.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
74.	TL1043420	517-5509	18871	Insignia, Organisation, Collar Royal Military Police, Soldiers	Aluminium, anodised gold. The EIIR cipher is charged with the Royal Crown, within a Fontenoy Laurel Wreath, with 'ROYAL MILITARY POLICE' on scroll beneath the cypher – H29mm x W32mm. 1 x vertical lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
75.	TL1043423	517-5512	30310	Insignia, Organisation, Collar Royal Army Chaplains Department Jewish Officer	Aluminium, anodised matt black. Upon a wreath of laurel and oak a Star of David. In the centre of the Star, a circle containing a quatrefoil voided. The whole ensigned with the Crown – H30m x W24mm. 2 x horizontal lugs H7mm, 20mm apart, mounted centrally on wreath. Complete with cotter pin. Supplied in pairs.
76.	TL1043427	517-5516	18930	Insignia, Organisation, Collar Royal Army Dental Corps, Soldiers	Aluminium, anodised gold and silver. Within a gold wreath of laurels a silver dragon's head and sword with gold hilt: beneath a scroll bearing the motto 'EX DENTIBUS ENSIS' ensigned with The Crown – H32mm x W25mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Handed design. Supplied in pairs.
77.	TL1043429	517-5518	19799	Insignia, Organisation, Collar Special Air Service, Soldiers	Aluminium, anodised gold and silver. Silver downward pointing Excalibur, wreathed in gold flames on scroll inscribed 'WHO DARES WINS' – H34mm x W19mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
78.	TL1043430	517-5519	19193	Insignia, Organisation, Collar Military Provost Staff Corps, Soldiers	Aluminium, anodised gold. The EIIR cipher topped with a the crown, with a scroll underneath inscribed 'MILITARY PROVOST STAFF CORPS' – H31mm x W32mm. 1 x horizontal lug H5mm, mounted centrally on royal cipher. Complete with cotter pin and back plate. Supplied in pairs.
79.	TL1043435	517-5525	18512	Insignia, Organisation, Collar Army Air Corps, Soldiers	Aluminium, anodised silver. Inward facing eagle with wings outspread – H26mm x W24mm. 1 x horizontal lug H5mm, mounted centrally on body of eagle. Complete with cotter pin and back plate. Handed design. Supplied in pairs.
80.	TL1043436	517-5526	19455	Insignia, Organisation, Collar Honourable Artillery Company, Soldiers	Aluminium, anodised gold. Grenade with seven flames and scroll to base inscribed 'H.A.C' – H40mm x W27mm. 1 x horizontal lug H7mm, mounted 22mm from base. Complete with cotter pin and back plate. Supplied in pairs.
81.	TL1043438	517-5528	19787	Insignia, Organisation, Collar Royal Horse Artillery, Soldiers	Aluminium, anodised silver. Royal cipher EIIR in garter inscribed 'HONI SOIT QUI MAL Y PENSE' surmounted by a St Edwards crown with scroll below inscribed 'ROYAL HORSE ARTILLERY' – H35mm x W23mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
82.	TL1043440	517-5530	19938	Insignia, Organisation, Collar 201 (Hertfordshire & Bedfordshire Yeomanry), 100th (Yeomanry) Regiment Royal Artillery, Soldiers	Aluminium, anodised gold. To the left a castle overlaid on an eagle in a wreath of half oak and half laurel, and to the right a hart in garter ennscribed 'YEOMANRY' surmounted by a St Edwards crown on scroll inscribed 'SOUTH AFRICA 1900 - 01' – H39mm x W24mm. 1 x horizontal lug H5mm, mounted offset 14mm from base. Complete with cotter pin and back plate. Supplied in pairs.



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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
83.	TL1043442	517-5532	18850	Insignia, Organisation, Collar Small Arms School Corps, Soldiers	Aluminium, anodised silver. A Vickers Machine Gun, thereon a pair of crossed rifles with bayonets fixed; a crown within the angle formed by the rifles above the machine gun; the whole laurel wreath; on the wreath scrolls inscribed on the left side 'SMALL' on the bottom 'ARMS' and on the right 'SCHOOL'. Vickers Machine Gun to be inward facing – H24mm x W24mm 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.
84.	TL1043444	517-5539	18217	Insignia, Organisation, Collar Royal Military Academy Sandhurst, All Ranks	Aluminium, anodised silver. Cypher EIIR in the centre with a circlet inscribed 'ROYAL MILITARY ACADEMY SANDHURST', ensigned with The Crown. Banner below inscribed 'SERVE TO LEAD' – H33mm x W24mm 2 x vertical lugs H6mm, 17mm apart, on top and bottom of circlet. Complete with cotter pin and back plate. Supplied in pairs.
85.	TL1043448	517-5543	18766	Insignia, Organisation, Collar Army Physical Training Corps, Soldiers	Aluminium, anodised silver. Silver cross swords ensigned with The Crown – H28mm xW28mm. 1 x vertical lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
86.	TL1043450	517-5546	19901	Insignia, Organisation, Collar D (London Irish Rifles) Company, The London Regiment, Soldiers	Aluminium, anodised silver. Tara harp, ensigned with The Crown – H27mm x W17mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
87.	TL1043451	517-5547	19545	Insignia, Organisation, Collar A (London Scottish) Company, The London Regiment, Soldiers	Aluminium, anodised silver. Thistle with two sprays of leaves – H29mm x W26mm 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
88.	TL1043453	517-5549	18870	Insignia, Organisation, Arm Kings Royal Hussars	Aluminium, anodised silver. 2 kukri's in saltire, the blades placed upwards and outwards – H16mm x W16mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate.
89.	TL1043459	551-5186	30427A	Insignia, Rank, Shoulder Strap Crown Small	Aluminium, anodised black. St Edwards Crown with crimson velvet backing and brass backplate – H23mm x W22mm. 2 x vertical fusion pins, 15mm apart, mounted centrally. Complete with 2 clutch fasteners.
90.	TL1043569	562-6583	30110	Insignia, Rank, Shoulder Strap St Patrick Star, Irish Guards	Aluminium, anodised gold. Star surmounted by garter with Order of St Patrick motto 'QUIS SEPARABIT - MDCCLXXXIII', with St Patrick saltire and shamrock with three crowns in centre – H/W 28mm point to point. 2 x horizontal lugs H3mm, 15mm apart, mounted centrally. Complete with and cotter pin.
91.	TL1043615	623-9853	29000	Insignia, Organisation, Shoulder Title Military Provost Guard Service, All Ranks	Aluminium, anodised gold. Letters 'MPGS' – H10mm x W48mm. 2 x horizontal fusion pins, 22mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
92.	TL1043681	724-8041	30458	Insignia, Rank, Shoulder Strap Crown Large, Royal Welsh	Aluminium, anodised gold. St Edwards Crown with crimson velvet backing and brass backplate – H29mm x W30mm. Brass screw fitting 8mm long x M3 attached centrally. Complete with M3 hexagonal nut.

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93.	TL1043683	724-8134	19649	Insignia, Organisation, Collar Queen's Gurkha Engineers, Soldiers	Aluminium, anodised gold and silver. 2 silver kukri's in saltire, the blades placed upwards and outwards. A gold grenade with 9 flames over the centre and over the pommels a gold scroll inscribed 'UBIQUE' – H30mm x W25mm. 2 x vertical lugs H6mm, 21mm apart, mounted centrally. Complete with cotter pins. Supplied in pairs.
94.	TL1043685	724-8136	18800	Insignia, Organisation, Collar Royal Engineers, Soldiers	Aluminium, anodised gold. Grenade with 9 flames over a scroll inscribed 'UBIQUE' – H33mm x W21mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
95.	TL1043688	724-8139	19281	Insignia, Organisation, Collar Parachute Regiment, Soldiers	Aluminium, anodised silver. Upon a Spread of Wings, an open Parachute surmounted by the Royal Crest – H24mm x W40mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.
96.	TL1043690	724-8141	19175	Insignia, Organisation, Collar Intelligence Corps, Soldiers	Aluminium, anodised gold. A union rose, surmounted by a crown and flanked by laurel leaves, with scroll beneath inscribed 'INTELLIGENCE CORPS' – H32mm x W25mm 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
97.	TL1043692	724-8143	19217	Insignia, Organisation, Collar Royal Tank Regiment, Soldiers	Aluminium, anodised silver. A tank within a wreath of laurels with scroll inscribed 'FEAR NAUGHT' at base and surmounted by the crown – H32mm x W26mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
98.	TL1043695	724-8146	20372	Insignia, Organisation, Collar Royal Scots Dragoon Guards, Soldiers	Aluminium, anodised gold and silver. A silver eagle on plinth inscribed 'WATERLOO' superimposed upon two gold carbines in saltier with scroll across stocks inscribed 'ROYAL SCOTS DRAGOON GUARDS' – H31mm x W26mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.
99.	TL1043696	724-8147	30469	Insignia, Organisation, Shoulder Title Scots Dragoon Guards, All Ranks	Aluminium, anodised gold. Letters 'SCOTS DG' – H11mm x W48mm. 2 x horizontal lugs H4mm, 40mm apart, mounted centrally. Complete with cotter pin. Supplied in pairs.
100.	TL1043697	724-8148	18541	Insignia, Organisation, Collar Royal Armoured Corps, Soldiers	Aluminium, anodised silver. Clenched fist wearing gauntlet with the letters 'RAC' on a billet on the cuff. Two concentric circles with arrowheads radiate from the wrist, surmounted by St Edwards crown – H36mm x W27mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pins and back plates. Supplied in pairs.
101.	TL1043698	724-8149	18657	Insignia, Organisation, Collar Queen's Dragoon Guards, Soldiers	Aluminium, anodised gold. The letters 'BAYS' encircled by a wreath of laurel surmounted by St Edwards crown – H33mm x W29mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pins and back plates. Supplied in pairs.
102.	TL1043704	724-8155	24621	Insignia, Organisation, Collar Light Dragoons, Soldiers	Aluminium, anodised gold and silver, 2 part design. Silver St Edwards crown surmounted by a lion riveted to gold Z shaped scroll – H31mm x W25mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pins and back plates. Supplied in handed pairs.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
103.	TL1043705	724-8157	D00696	Insignia, Organisation, Collar King's Royal Hussars, Soldiers	Aluminium, anodised gold and silver. Prince of Wales's feathers. Silver ostrich feathers and scroll and gold coronet – H32mm x W38mm. 2 x horizontal lugs H7mm, 12mm apart, mounted 17mm from base. Complete with cotter pin. Supplied in pairs.
104.	TL1043711	724-8164	19996	Insignia, Organisation, Collar A (Sherwood Rangers Yeomanry) Squaron, Royal Yeomanry, Soldiers	Aluminium, anodised gold. Bugle and lanyard within circlet inscribed 'THE SHERWOOD RANGERS YEOMANRY' surmounted by St Edwards crown – H31mm x W20mm. 1 x horizontal lug H5mm, mounted 17mm from base. Complete with cotter pins and back plates. Supplied in handed pairs.
105.	TL1043712	724-8165	19579	Insignia, Organisation, Collar Y (Royal Wiltshire Yeomanry) Squadron, Royal Wessex Yeomanry, Soldiers	Aluminium, anodised gold and silver. Prince of Wales's feathers. Silver ostrich feathers and scroll and gold coronet – H25mm x W23mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pins and back plates. Supplied in pairs.
106.	TL1043715	724-8168	18835	Insignia, Organisation, Collar Inns of Court & City Yeomanry, Soldiers	Aluminium, anodised gold and silver. Gold winged devil on silver spur – H30mm x W30mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pins and back plates. Supplied in handed pairs.
107.	TL1043716	724-8169	18804	Insignia, Organisation, Shoulder Title Inns of Court & City Yeomanry	Aluminium, anodised gold. Letters 'IC & CY' – H10mm x W42mm. 2 x horizontal lugs H4mm, 35mm apart, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
108.	TL1043717	724-8171	20678	Insignia, Organisation, Collar D (Northumberland Hussars) Squadron, Queen's Own Yeomanry, Soldiers	Aluminium, anodised silver. Castle within circlet inscribed 'NORTHUMBERLAND HUSSARS' over a scroll inscribed 'SOUTH AFRICA 1900-02' surmounted by St Edwards crown – H34mm x W23mm. 1 x horizontal lug H5mm, mounted centrally in circlet. Complete with cotter pin and back plate. Supplied in pairs.
109.	TL1043718	724-8172	18978A	Insignia, Organisation, Collar D (Duke of Lancaster's Own Yeomanry) Squadron, Royal Mercian & Lancastrian Yeomanry, All Ranks	Aluminium, anodised gold. Rose of Lancaster – H27mm x W27mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
110.	TL1043719	724-8175	19365	Insignia, Organisation, Collar Shropshire Yeomanry, Soldiers	Aluminium, anodised gold. Three leopards' heads within a circlet inscribed 'SHROPSHIRE YEOMANRY' surmounted by St Edwards crown – H32mm x W23mm. 1 x horizontal lug H5mm, mounted at top of circlet. Complete with cotter pin and back plate. Supplied in pairs.
111.	TL1043749	737-3329	D02110	Insignia, Rank, Shoulder Strap Crown, The Duke of Lancaster's Regiment	Aluminium, anodised gold. St Edwards Crown – H22mm x W22mm. 2 x horizontal fusion pins, 19mm apart, mounted at top of arches. Complete with 2 clutch fasteners. Supplied in pairs.
112.	TL1043750	737-3330	D02111	Insignia, Rank, Shoulder Strap Bath Star, The Duke of Lancaster's Regiment	Aluminium, anodised gold. Star surmounted by Maltese Cross, wreath of laurels, Order of Bath motto 'TRIA JUNCTA IN UNO' with three crowns in centre – H/W 26mm point to point. 2 x horizontal fusion pins, 18mm apart, mounted centrally. Complete with 2 clutch fasteners.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
113.	TL1043759	742-7327	19913	Insignia, Organisation, Collar Royal Irish Regiment, Soldiers	Aluminium, anodised silver. Castle with scroll above inscribed 'INNISKILLING' – H19mm x W22mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
114.	TL1043810	812-6406	30085	Insignia, Rank, Shoulder Strap Garter Star. Grenadier Guards, Coldstream Guards & Welsh Guards	Aluminium, anodised gold. Star surmounted by garter inscribed 'HONI SOIT QUI MAL Y PENSE' with cross of St George within – H35mm x W26mm. 2 x horizontal lugs H6mm, 18mm apart, mounted centrally. Complete with cotter pin.
115.	TL1043840	814-4374	D02192	Insignia, Organisation, Shoulder Title Queen's Own Yeomanry	Aluminium, anodised silver. Letters 'QOY' – H10mm x W30mm. 2 x horizontal fusion pins, 16mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
116.	TL1043903	869-1187	27730	Insignia, Rank, Shoulder Strap Bath Star, Small, Royal Marines	Aluminium, anodised gold. Low bake enamelled, green wreath and red moto. Star surmounted by Maltese Cross, wreath of laurels, Order of Bath moto 'TRIA JUNCTA IN UNO' with three crowns in centre – H/W 23mm point to point. 2 x horizontal fusion pins, 19mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
117.	TL1043905	869-1189	27732A	Insignia, Rank, Shoulder Strap Bath Star, Miniature, Royal Marines	Aluminium, anodised gold. Star surmounted by Maltese Cross, wreath of laurels, Order of Bath moto 'TRIA JUNCTA IN UNO' with three crowns in centre – H/W 16mm point to point. 2 x horizontal fusion pins, 10mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
118.	TL1043906	869-1190	27733	Insignia, Organisation, Collar Royal Marines, Officers	Aluminium, anodised gold and silver. Two piece design. Silver globe within gold wreath of laurels riveted to circular brass disc with black velvet – Dia 27mm 2 x horizontal lugs H5mm, 16mm apart, mounted centrally. Complete with cotter pins. Supplied in pairs.
119.	TL1043912	869-1569	28005	Insignia, Organisation, Collar Royal Marines, Officers	Aluminium, anodised gold and silver. Silver globe within gold wreath of laurels – H29mm x W35mm 2 x horizontal lugs H6mm, 27mm apart, mounted centrally on wreath. Complete with cotter pin. Supplied in pairs.
120.	TL1043949	869-3628	28371	Insignia, Rank, Shoulder Strap Crown, Royal Marines	Aluminium, anodised gold. St Edwards Crown with scarlet velvet backing and brass backplate – H22mm x W22mm. 2 x vertical fusion pins, 14mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
121.	TL1043950	869-3629	28372	Insignia, Rank, Shoulder Strap Crown, Miniature, Royal Marines	Aluminium, anodised gold. St Edwards Crown – H13mm x W14mm. 1 x fusion pins, mounted centrally 4mm from base. Complete with clutch fastener.
122.	TL1043983	871-6340	24509	Insignia, Organisation, Collar Adjutant Generals Corps, Soldiers	Aluminium, anodised gold and silver. Gold lion upon a St Edwards crown within a wreath of laurels surmounted by St Edwards crown, upon a silver scroll bearing the motto 'ANIMO ET FIDE' – H34mm x W31mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.



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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
123.	TL1043985	871-6342	18525	Insignia, Organisation, Collar Royal Electrical & Mechanical Engineers, Soldiers	Aluminium, anodised gold and silver. Silver horse with coronet of 4 fleur-de-lys around its neck, a chain attached to the back of the coronet and falling down its side to a globe on which the horse is standing on its near hind leg, mounted on a gold lightening flash surmounted by St Edwards crown – H31mm x W14mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.
124.	TL1043987	871-6344	18403A	Insignia, Organisation, Collar Royal Regiment of Fusiliers, Soldiers	Aluminium, anodised gold and silver. Gold flaming grenade with St Edwards crown at base of flames, with silver St George and Dragon within a wreath of laurels mounted on the grenade body – H32mm x W22mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.
125.	TL1043989	871-6346	19988	Insignia, Organisation, Collar Royal Army Medical Corps, Soldiers	Aluminium, anodised gold and silver. The Rod of Aesculapius in gold with a Serpent entwined in silver, within a gold wreath of laurels surmounted by a St Edwards crown. Below is a silver scroll inscribed 'IN ARDUIS FIDELIS'. – H34mm x W24mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.
126.	TL1043997	883-3367	21161	Badge, Qualification Musician & Bandsmen, Light Infantry & Royal Irish Regiment	Aluminium, anodised silver. Lyre sat on wreath of oak surmounted by St Edwards crown – H50mm x W42mm. 2 x vertical lugs H6mm, 31mm apart, mounted centrally. Complete with cotter pin and back plate.
127.	TL1043998	883-3368	23074	Badge, Qualification Bugler, Light Infantry & Royal Irish Regiment	Aluminium, anodised silver. Bugle and cord – H17mm x W20mm. 2 x vertical lugs H5mm, 10mm apart, mounted centrally. Complete with cotter pin.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
128.	TL1043999	883-3369	22032	Badge, Qualification Piper & Pipe Major, Light Infantry & Royal Irish Regiment	Aluminium, anodised silver. Bagpipes – H65mm x W33mm. 2 x vertical lugs H5mm, 35mm apart, mounted centrally. Complete with cotter pin and back plate.
129.	TL1044000	883-3370	19207	Badge, Qualification Bugle Major, Light Infantry & Royal Irish Regiment	Aluminium, anodised silver. Bugle and cord – H30mm x W33mm. 3 x horizontal lugs H5mm, pair 20mm apart mounted centrally on bugle plus one mounted on cord knot. Complete with 2 cotter pins and back plate.
130.	TL1044003	883-3373	18984	Badge, Qualification Drummer, Army	Aluminium, anodised gold. Drum – H30mm x 26mm. 2 x vertical lugs H5mm, 19mm apart, mounted centrally. Complete with cotter pin and back plate.
131.	TL1044004	883-3374	18848	Badge, Qualification Musician & Bandsmen, Army	Aluminium, anodised gold. Lyre sat on wreath of oak surmounted by St Edwards crown – H50mm x W42mm. 2 x vertical lugs H6mm, 31mm apart, mounted centrally. Complete with cotter pin and back plate.
132.	TL1044005	883-3375	22615	Badge, Qualification Musician & Bandsmen, Army	Aluminium, anodised gold. Lyre sat on wreath of oak surmounted by St Edwards crown – H44mm x W35mm. 2 x vertical lugs H6mm, 29mm apart, mounted centrally. Complete with cotter pin.
133.	TL1044006	883-3376	29260	Badge, Qualification Trumpet Major, Army	Aluminium, anodised gold. Pair of crossed trumpets – H19mm x W32mm 1 x vertical lugs H5mm, mounted centrally. Complete with cotter pin.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
134.	TL1044007	883-3377	21470	Badge, Qualification Trumpeter & Trumpet Major, Army	Aluminium, anodised gold. Pair of crossed trumpets – H31mm x W46mm 4 x horizontal lugs H5mm, 2 pairs 21mm apart vertically and 24mm apart horizontally, mounted centrally. Complete with 2 cotter pins and back plate.
135.	TL1044008	883-3378	23185	Badge, Qualification Saddle & Harness Maker, Kings Troop Royal Horse Artillery	Aluminium, anodised gold. Horse bit – H41mm x W37mm 4 x horizontal lugs H5mm, 2 pairs 15mm apart vertically and 24mm apart horizontally, mounted centrally. Complete with 2 cotter pins and back plate.
136.	TL1044009	883-3379	21318	Badge, Qualification Riding Instructor, Kings Troop Royal Horse Artillery	Aluminium, anodised gold. Spur – H44mm x W24mm. 3 x horizontal lugs H5mm, pair 21mm apart & 10mm from ends of arms, plus one mounted 6mm from end of spigot. Complete with 2 cotter pins and back plate.
137.	TL1044010	883-3380	20751	Badge, Qualification Farrier, Kings Troop Royal Horse Artillery	Aluminium, anodised gold. Horseshoe – H31mm x W29mm. 2 x horizontal lugs H3mm, 21mm apart, mounted 13mm from top. Complete with cotter pin and back plate.
138.	TL1044011	883-3381	21174	Badge, Qualification Pipers & Pipe Majors Scottish Army	Aluminium, anodised silver. Bagpipes – H65mm x W37mm. 2 x vertical lugs H6mm, 35mm apart, lower lug mounted centrally at base and upper lug mounted 5mm from edge. Complete with cotter pin and back plate.
139.	TL1044032	925-0632	30084	Insignia, Rank, Shoulder Strap Crown, Large, Foot Guards & Royal Welsh	Aluminium, anodised gold. St Edwards Crown – H25mm x W26mm. 2 x horizontal lugs H5mm, 14mm apart, mounted 8mm from base. Complete with cotter pin.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
140.	TL1044053	958-2199	20178	Insignia, Rank, Wrist Strap Warrant Officer Class 2	Aluminium, anodised gold. St Edwards crown within a wreath of laurels – H44mm x W59mm 2 x horizontal lugs H7mm, 47 mm apart, mounted centrally on wreath. Complete with cotter pin and back plate.
141.	TL1044080	961-3546	18755	Insignia, Organisation, Collar Royal Regiment of Artillery, Soldiers	Aluminium, anodised gold. Grenade with 7 flames over a scroll inscribed 'UBIQUE' – H38mm x W24mm. 1 x horizontal lug H5mm, mounted centrally. Complete with cotter pin and back plate. Supplied in pairs.
142.	TL1044082	961-3548	19483	Insignia, Organisation, Collar Royal Corps of Signals, Soldiers	Aluminium, anodised gold and silver. Mercury standing on a globe with a spray of laurel on either side and scroll over inscribed 'CERTA CITO' – H36mm x W26mm. 1 x horizontal lug H5mm, mounted on Mercury's body and pin H4mm mounted on centre of globe. Complete with cotter pin and back plate. Supplied in handed pairs.
143.	TL1044255	973-8866	24586	Badge, Qualification, Arm Bugle Majors & Buglers, The Rifles & Brigade of Gurkhas	Aluminium, anodised black. Bugle and cord – H30mm x W33mm. 3 x horizontal lugs H5mm, pair 20mm apart mounted centrally on bugle plus one mounted on cord knot. Complete with 2 cotter pins and back plate.
144.	TL1044265	973-8893	20366	Insignia, Rank, Wrist Strap Warrant Officer Class 2, The Rifles & Brigade of Gurkhas	Aluminium, anodised black. St Edwards crown – H40mm x W40mm. 2 x horizontal lugs H5mm, 24mm apart, mounted centrally. Complete with cotter pin and back plate.
145.	TL1044266	973-8894	20424	Insignia, Rank, Wrist Strap Warrant Officer Class 2	Aluminium, anodised gold. St Edwards crown – H40mm x W40mm. 2 x horizontal lugs H5mm, 22mm apart, mounted centrally. Complete with cotter pin and back plate.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
146.	TL1044267	973-8895	20517	Insignia, Rank, Wrist Strap Warrant Officer Class 2, Light Infantry & Royal Irish Regiment	Aluminium, anodised silver. St Edwards crown – H40mm x W40mm. 2 x horizontal lugs H5mm, 18mm apart, mounted centrally. Complete with cotter pin and back plate.
147.	TL1044313	973-9031	23020	Insignia, Organisation, Arm Royal Regiment of Artillery, Sergeants, Staff Sergeants & Master Gunners	Aluminium, anodised gold. Left facing artillery gun – H23mm x W52mm. 2 x horizontal lugs H7mm, 15mm apart, mounted centrally on wheel. Complete with cotter pin and back plate.
148.	TL1044314	973-9033	22247	Insignia, Organisation, Arm Royal Regiment of Artillery, Sergeants, Staff Sergeants & Master Gunners	Aluminium, anodised gold. Right facing artillery gun – H22mm x W52mm. 2 x horizontal lugs H7mm, 20mm apart, mounted centrally on wheel. Complete with cotter pin and back plate.
149.	TL1044316	973-9037	20911	Badge, Qualification Instructors In Gunnery, Warrant Officer Class 2, Royal Regiment of Artillery	Aluminium, anodised gold. Crossed guns – H34mm x W38mm 4 x horizontal lugs H5mm, 22mm apart, mounted centrally. Complete with 2 cotter pins.
150.	TL1044349	973-9221	20184	Insignia, Rank, Wrist Strap Warrant Officer Class 1	Aluminium, anodised gold. Royal arms – H39mm x W40mm. 2 x horizontal lugs H5mm, 25mm apart, mounted centrally. Complete with cotter pin and back plate.
151.	TL1044350	973-9222	20639	Insignia, Rank, Wrist Strap Warrant Officer Class 1	Aluminium, anodised silver. Royal arms – H39mm x W40mm. 2 x horizontal lugs H5mm, 25mm apart, mounted centrally. Complete with cotter pin and back plate.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
152.	TL1044366	973-9352	19361	Insignia, Organisation, Bonnet A (London Scottish) Company, The London Regiment, Soldiers	Aluminium, anodised silver. Scottish lion superimposed on St Andrew's saltire, all on a circlet bearing the motto 'STRIKE SURE' and 'S. AFRICA 1900-02' on lower portion. Across top diagonals of saltire a scroll marked 'LONDON' and across the lower diagonals a scroll marked 'SCOTTISH'. The whole enclosed by a wreath of thistles – H52mm x W57mm. 2 x horizontal lugs H5mm, 37mm apart, mounted centrally. Complete with cotter pin and back plate.
153.	TL1044368	973-9360	18768	Insignia, Organisation, Cap The Household Cavalry, Soldiers	Aluminium, anodised gold. Garter inscribed 'HONI SOIT QUI MAL Y PENSE', surmounted by St Edwards crown and EIIR cipher within – H42mm x W27mm. 2 x horizontal lugs H7mm, 20mm apart, mounted centrally on garter. Complete with cotter pin.
154.	TL1044369	973-9361	17933A	Insignia, Organisation, Cap The Life Guards, Soldiers	Aluminium, anodised gold. Garter inscribed 'THE LIFE GUARDS', surmounted by St Edwards crown and EIIR cipher within – H38mm x W26mm. 2 x horizontal lugs H11mm, 20mm apart, mounted centrally on garter. Complete with cotter pin.
155.	TL1044372	973-9383	19298	Insignia, Organisation, Cap Royal Armoured Corps, Soldiers	Aluminium, anodised silver. Clenched fist wearing gauntlet with the letters 'RAC' on a billet on the cuff. Two concentric circles with arrowheads radiate from the wrist, surmounted by St Edwards crown – H50mm x W38mm. With vertical hook, mounted centrally 10mm from top.
156.	TL1044373	973-9385	18224A	Insignia, Organisation, Cap Royal Horse Artillery, Soldiers	Aluminium, anodised gold, 2 part design. Left facing artillery gun with wheel riveted to chasis. Scroll above inscribed 'UBIQUE' and scroll below inscribed 'QUO FAS ET GLORIA DUCUNT', surmounted by St Edwards crown – H46mm x W65mm. With vertical hook, mounted centrally 10mm from top.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
157.	TL1044374	973-9387	18176	Insignia, Organisation, Cap Royal Engineers, Soldiers	Aluminium, anodised gold and silver, 2 part design. Gold garter inscribed 'HONI SOIT QUI MAL Y PENSE' with EIIR cipher within, surmounted by St Edwards crown and on scroll inscribed 'ROYAL ENGINEERS', riveted to silver wreath of laurels – H45mm x W39mm. With vertical hook, mounted centrally 12mm from top.
158.	TL1044376	973-9390	19143	Insignia, Organisation, Cap Grenadier Guards, Sergeants & Bandsmen	Aluminium, anodised gold. Grenade with seventeen flames with reversed and interlaced cipher surmounted by St Edwards crown on grenade – H43mm x W35mm. 2 x horizontal lugs H6mm, 25mm apart, mounted centrally on flames 17mm below top. Complete with cotter pin.
159.	TL1044377	973-9394	17668A	Insignia, Organisation, Cap Coldstream Guards, Soldiers	Aluminium, anodised gold. Star surmounted by garter inscribed 'HONI SOIT QUI MAL Y PENSE' with cross of St George within – H44mm x W45mm. 2 x horizontal lugs H6mm, 28mm apart, mounted centrally. Complete with cotter pin.
160.	TL1044379	973-9396	19216	Insignia, Organisation, Cap Scots Guards, Soldiers	Aluminium, anodised gold and silver. Silver star surmounted by gold garter with Order of the Thistle moto 'NEMO ME IMPUNE LACESSIT', with thistle in centre – H44mm x W41mm. 2 x horizontal lugs H10mm, 28mm apart, mounted centrally on star. Complete with cotter pin.
161.	TL1044380	973-9397	17669A	Insignia, Organisation, Cap Scots Guards, Soldiers & Drummers	Aluminium, anodised gold. Star surmounted by garter with Order of the Thistle moto 'NEMO ME IMPUNE LACESSIT', with thistle in centre – H44mm x W41mm. 2 x horizontal lugs H8mm, 28mm apart, mounted centrally on star. Complete with cotter pin.

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Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
162.	TL1044381	973-9400	17670	Insignia, Organisation, Cap Irish Guards, Soldiers	Aluminium, anodised gold. Star surmounted by garter with Order of St Patrick motto 'QUIS SEPARABIT - MDCCLXXXIII', with St Patrick saltire and shamrock with three crowns in centre – H43mm x W43mm. 2 x horizontal lugs H6mm, 28mm apart, mounted centrally. Complete with and cotter pin.
163.	TL1044383	973-9402	17671	Insignia, Organisation, Cap Welsh Guards, Soldiers	Aluminium, anodised gold. Leek – H48mm x W33mm. With vertical hook, mounted centrally 15mm from top.
164.	TL1044384	973-9424	20302	Insignia, Organisation, Cap Liverpool University, Officer Training Corps	Aluminium, anodised gold and silver. Silver Horse of Hanover on gold scroll inscribed 'KING'S – H39mm x W39mm. With vertical hook, mounted centrally 15mm from top.
165.	TL1044386	973-9468	18270	Insignia, Organisation, Cap Intelligence Corps, Soldiers	Aluminium, anodised gold. A union rose, surmounted by a crown and flanked by laurel leaves, with scroll beneath inscribed 'INTELLIGENCE CORPS' – H45mm x W33mm. With vertical hook, mounted centrally 7mm from top.
166.	TL1044387	973-9470	20894	Insignia, Organisation, Cap Military Provost Staff, Soldiers	Aluminium, anodised gold. The EIIR cipher topped with a the crown, with a scroll underneath inscribed 'MILITARY PROVOST STAFF CORPS' – H40mm x W38mm. With vertical hook, mounted centrally 6mm from top.
167.	TL1044388	973-9471	19203	Insignia, Organisation, Cap Queen Alexandra's Royal Army Nursing Corps, Soldiers	Aluminium, anodised gold and silver. Gold Cypher of HM the late Queen Alexandra combined with the Dannebrog, the whole within a wreath of laurels inscribed with the Corps motto 'SUB CRUCE CANDIDA' surmounted with a crown. On the lower portion of the wreath is a silver scroll inscribed 'Q.A.R.A.N.C' – H40mm x W25mm. With vertical hook, mounted centrally 7mm from top.



TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
168.	TL1044389	973-9472	19172	Insignia, Organisation, Cap Royal Army Dental Corps, Soldiers	Aluminium, anodised gold and silver. Within a gold wreath of laurels a silver dragon's head and sword with gold hilt: beneath a scroll bearing the motto 'EX DENTIBUS ENSIS' ensigned with The Crown. Two part design with the silver dragons head and sword blade riveted to the main badge – H47mm x W35mm. With vertical hook, mounted centrally 8mm from top.
169.	TL1044390	973-9478	20181	Insignia, Organisation, Cap Royal Army Veterinary Corps, Soldiers	Aluminium, anodised gold and silver. Silver centaur within gold wreath of laurels surmounted by St Edwards crown and on scroll inscribed 'ROYAL ARMY VETERINARY CORPS' – H45mm x W30mm. With vertical hook, mounted centrally 8mm from top.
170.	TL1044391	973-9479	19152A	Insignia, Organisation, Cap Royal Electrical & Mechanical Engineers, Soldiers	Aluminium, anodised gold and silver, 2 part design. Silver horse with coronet of 4 fleur-de-lys around its neck, a chain attached to the back of the coronet and falling down its side to a globe on which the horse is standing on its near hind leg, riveted on to a gold lightening flash surmounted by scroll inscribed 'R E M E' and St Edwards crown above – H48mm x W30mm. With vertical hook, mounted centrally 8mm from top.
171.	TL1044392	973-9480	18253	Insignia, Organisation, Cap Royal Military Police, Soldiers	Aluminium, anodised gold. The EIIR cypher is charged with the Royal Crown, within a Fontenoy Laurel Wreath, with 'ROYAL MILITARY POLICE' on scroll beneath the cypher – H43mm x W47mm. With vertical hook, mounted centrally 8mm from top.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
172.	TL1044393	973-9482	20707	Insignia, Organisation, Cap Small Arms School Corps, Soldiers	Aluminium, anodised silver. A left facing Vickers Machine Gun, thereon a pair of crossed rifles with bayonets fixed; a crown within the angle formed by the rifles above the machine gun; the whole laurel wreath; on the wreath scrolls inscribed on the left side 'SMALL' on the bottom 'ARMS' and on the right 'SCHOOL' – H39mm x W38mm. With vertical hook, mounted centrally 8mm from top.
173.	TL1044394	973-9488	18701	Insignia, Organisation, Cap Civilian Employees	Aluminium, anodised gold. St Edwards Crown – H32mm x W33mm. With vertical hook, mounted centrally 8mm from top.
174.	TL1044395	973-9489	18995	Insignia, Organisation, Cap Duke of York's Royal Military School, All Ranks	Aluminium, anodised gold and silver. Silver EIIR cipher within gold circlet inscribed 'ROYAL MILITARY SCHOOL' and St Edwards crown above – H41mm x W280mm. With vertical hook, mounted centrally 8mm from top.
175.	TL1044396	973-9496	19330	Insignia, Organisation, Cap Royal Military Academy Sandhurst, Officer Cadets	Aluminium, anodised silver. Cypher EIIR in the centre with a circlet inscribed 'ROYAL MILITARY ACADEMY SANDHURST', ensigned with The Crown. Banner below inscribed 'SERVE TO LEAD' – H48mm x W35mm. With vertical hook, mounted centrally 12mm from top.
176.	TL1044397	973-9501	19333	Insignia, Organisation, Cap Welbeck College	Aluminium, anodised gold and silver. Silver cross-moline within a gold circle with inscription 'WELBECK COLLEGE', imposed on crossed swords with gold hilts and silver blades – H39mm x W34mm. With vertical hook, mounted centrally 4mm from top of circle.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
177.	TL1044401	973-9523	19739	Insignia, Organisation, Cap Honourable Artillery Company, Officers/WO1	Aluminium, anodised gold, 2 part design. Left facing artillery gun with wheel riveted to chasis. Scroll above inscribed 'H.A.C' and scroll below inscribed 'ARMA PACIS FULCRA', surmounted by St Edwards crown – H47mm x W65mm. With vertical hook, mounted centrally 10mm from top.
178.	TL1044402	973-9564	19338	Insignia, Organisation, Cap Honourable Artillery Company, Soldiers	Aluminium, anodised silver. Fused grenade with multiple flames with 'HAC' on the grenade with entwined lettering – H58mm x W44mm. With vertical hook, mounted centrally at top of grenade.
179.	TL1044403	973-9574	19173	Insignia, Organisation, Cap Special Air Service, Soldiers	Aluminium, anodised gold and silver. Silver downward pointing Excalibur, wreathed in gold flames on scroll inscribed 'WHO DARES WINS' – H42mm x W22mm. With vertical hook, mounted centrally on crosspiece of sword.
180.	TL1044405	973-9576	22734	Insignia, Organisation, Cap Aberdeen University Officer Training Corps, All Ranks	Aluminium, anodised silver. Boar's head within circlet inscribed 'NON CONFUNDAR' – H54mm x W71mm. 2 x horizontal lugs H7mm, 57mm apart, mounted centrally. Complete with and cotter pin.
181.	TL1044406	973-9578	19948	Insignia, Organisation, Cap Birmingham University Officer Training Corps, All Ranks	Aluminium, anodised gold. Shield bearing the arms of Birmingham with scroll below inscribed 'BIRMINGHAM UNIVERSITY O.T.C' – H41mm x W42mm. With vertical hook, mounted centrally 8mm from top.
182.	TL1044407	973-9579	21326	Insignia, Organisation, Cap University of Bristol Officer Training Corps, All Ranks	Aluminium, anodised gold. Shield bearing the arms of Bristol University – H38mm x W33mm. With vertical hook, mounted centrally 4mm from top.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
183.	TL1044408	973-9580	20824	Insignia, Organisation, Cap University of Cambridge Officer Training Corps, All Ranks	Aluminium, anodised silver. Shield bearing the arms of the University of Cambridge surmounted by a St Edward crown with scroll below inscribed 'DISCENDO DVCES' – H47mm x W35mm. With vertical hook mounted centrally 13mm from top.
184.	TL1044409	973-9581	18172	Insignia, Organisation, Cap Northumbrian Universities Officer Training Corps, All Ranks	Aluminium, anodised gold. St Cuthbert's Cross – H32mm x W32mm. With vertical hook mounted centrally 2mm from top.
185.	TL1044410	973-9584	17918	Insignia, Organisation, Cap University of Leeds Officer Training Corps, All Ranks	Aluminium, anodised gold. Winged sphinx sejant facing left with scroll below inscribed 'OFFICERS TRAINING CORPS' – H47mm x W40mm. With vertical hook mounted below neck 13mm from top.
186.	TL1044411	973-9585	17660	Insignia, Organisation, Cap London University Officer Training Corps, All Ranks	Aluminium, anodised gold. The arms of London University surmounted by a St Edward crown imposed on an eight-point star with scroll below inscribed 'UNIVERSITY OF LONDON O.T.C.' - H45mm x W37mm. With vertical hook mounted below neck 8mm from top.
187.	TL1044412	973-9586	20280	Insignia, Organisation, Cap University of Manchester Officer Training Corps, Cadets	Aluminium, anodised gold. Rampant lion facing left – H40mm x W32mm. With vertical hook mounted below neck 10mm from top.
188.	TL1044413	973-9588	19575	Insignia, Organisation, Cap Oxford University Officer Training Corps, All Ranks	Aluminium, anodised silver. The arms of Oxford University within circlet inscribed 'OXFORD UNIVERSITY O.T.C.', surmounted by a St Edward crown with scroll below inscribed "MILITIA NOBIS STUDIUM" – H49mm x W42mm. With vertical hook mounted below neck 10mm from top.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
189.	TL1044414	973-9590	21286	Insignia, Organisation, Cap Queen's University Officer Training Corps, All Ranks	Aluminium, anodised gold. The arms of Queens University surmounted by a St Edward crown with scroll below inscribed `QUEEN'S` – H44mm x W36mm With vertical hook mounted below neck 10mm from top.
190.	TL1044415	973-9591	17658	Insignia, Organisation, Cap Sheffield University Officer Training Corps, All Ranks	Aluminium, anodised gold. The arms of Sheffield University with scroll below inscribed `UNIVERSITY OF SHEFFIELD O.T.C.` – H46mm x W45mm. With vertical hook mounted below neck 8mm from top.
191.	TL1044419	973-9732	20073	Insignia, Organisation, Collar North Irish Horse, Soldiers	Aluminium, anodised silver. An Irish Harp surmounted by a St Edward crown with scroll below inscribed `NORTH IRISH HORSE` – H36mm x W32mm. 1 x horizontal lug H4mm, mounted centrally at base of crown. Complete with cotter pin and back plate. Supplied in handed pairs.
192.	TL1044420	973-9782	19786	Insignia, Organisation, Cap Royal Horse Artillery, Soldiers	Aluminium, anodised silver. Royal cipher EIIR in garter inscribed `HONI SOIT QUI MAL Y PENSE` surmounted by a St Edwards crown with scroll below inscribed `ROYAL HORSE ARTILLERY` – H35mm x W23mm. With vertical hook mounted at top of garter.
193.	TL1044431	973-9941	20660	Insignia, Rank, Wrist Strap Trumpet Majors, Colour Sgts & Staff Sgts	Aluminium, anodised gold. St Edwards crown – H14mm x W14mm. 1 x vertical lug H5mm, mounted centrally. Complete with cotter pin.
194.	TL1044432	973-9942	21129	Insignia, Rank, Wrist Strap Trumpet Majors, Colour Sgts & Staff Sgts, Light Infantry & Royal Irish Regiment	Aluminium, anodised silver. St Edwards crown – H14mm x W14mm. 1 x vertical lug H5mm, mounted centrally. Complete with cotter pin.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
195.	TL1044433	973-9943	22398	Badge Qualification, Wrist Strap Drummers & Drum Majors	Aluminium, anodised gold. Drum – H17mm x W14mm. 1 x vertical lug H5mm, mounted centrally. Complete with cotter pin.
196.	TL1044436	973-9949	21351	Badge, Qualification, Wrist Strap Pipers & Pipe Majors. Scottish	Aluminium, anodised gold. Bagpipes – H15mm x W8mm. 1 x vertical lug H5mm, mounted at base. Complete with cotter pin.
197.	TL1044437	973-9950	21441	Badge, Qualification, Wrist Strap Pipers & Pipe Majors	Aluminium, anodised silver. Bagpipes – H15mm x W8mm. 1 x vertical lug H5mm, mounted at base. Complete with cotter pin.
198.	TL1044438	973-9952	18546	Insignia, Organisation, Cap Royal Monmouthshire Royal Engineers, Other Ranks	Aluminium, anodised gold and silver, 2 part design. Gold Prince of Wales's coronet over silver plumes and scroll below inscribed 'ICH DIEN'. Riveted to gold backing with St Edwards crown above, letters 'R' and 'E' either side of the plume with scroll below inscribed 'ROYAL MONMOUTHSHIRE' – H47mm x W41mm. With vertical hook mounted at base of crown.
199.	TL1044445	973-9974	17424	Brooch, Pipers Royal Regiment of Artillery (Volunteers), Pipe Majors & Pipers	Aluminium, anodised gold insignia mounted on gilding metal, bright chromium plated brooch with 3 fold over pins. Insignia – 2 part design, with left facing artillery gun with wheel riveted to chasis. Scroll above inscribed 'UBIQUE' and scroll below inscribed 'QUO FAS ET GLORIA DUCUNT', surmounted by St Edwards crown – H47mm x W65mm. Brooch – Dia 92mm domed plate with dia 19mm hole in centre. Fitted with 80mm long, 2.6mm dia horizontal brooch pin, mounted centrally across brooch.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
200.	TL1044521	974-0402	19648	Insignia, Organisation, Cap Queen's Gurkha Engineers, Soldiers	Aluminium, anodised gold and silver. 2 silver kukri's in saltire, the blades placed upwards and outwards. A gold grenade with 9 flames over the centre and over the pommels a gold scroll inscribed 'UBIQUE' – H30mm x W25mm. With vertical hook mounted at base of grenade.
201.	TL1044527	974-0419	19803	Insignia, Organisation, Cap Glasgow and Strathclyde Universities Officer Training Corps	Aluminium, anodised gold. St Andrew within elliptical scroll inscribed 'GLASGOW AND STRATHCLYDE UOTC' on St Andrew's saltire – H50mm x W32mm. With vertical hook mounted 12mm from top.
202.	TL1044549	974-0856	20779	Insignia, Organisation, Shoulder Title Royal Horse Artillery, Soldiers	Aluminium, anodised gold. Letters 'RHA' – H10mm x W27mm. 2 x horizontal fusion pins, 21mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
203.	TL1044552	974-1048	17974	Insignia, Organisation, Cap Army Air Corps, Soldiers	Aluminium, anodised silver. Left facing eagle with wings outspread within laurel wreath surmounted by St Edwards crown – H48mm x W40mm. With vertical hook mounted 10mm from top.
204.	TL1044553	974-1051	18141	Insignia, Organisation, Cap Royal Gibraltar Regiment, Soldiers	Aluminium, anodised gold and silver. Silver castle and key on shield with gold surround, surmounted by silver St Edwards crown and scroll below inscribed 'NULLI EXPUGNABILIS HOSTI' – H44mm x W34mm. With vertical hook mounted 10mm from top.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
205.	TL1044556	974-1106	17975A	Insignia, Organisation, Cap Royal Regiment of Fusiliers, All Ranks	Aluminium, anodised gold and gilding metal, bright chromium plated, 2 part design. Gold flaming grenade with St Edwards crown at base of flames, with silver St George and Dragon within a wreath of laurels securely riveted to centre of grenade – H50mm x W40mm. Plume location loop mounted at base of flames – W5mm x H2mm. 2 x horizontal lugs H11mm, 28mm apart, mounted centrally at base of flames. Complete with cotter pin.
206.	TL1044572	974-1173	22915	Insignia, Organisation, Cap Royal Corps of Signals, Soldiers	Aluminium, anodised gold and silver, 2 part design. Silver mercury standing on a globe with a gold spray of laurel on either side and scroll over inscribed 'CERTA CITO' – H36mm x W26mm. 2 x vertical lugs H5mm, mounted on Mercury's body and top of globe 18mm apart. Gold St Edwards crown – H11mm x W11mm. 1 x vertical lug H5mm, mounted centrally. Complete with cotter pin and back plate to accept both parts.
207.	TL1044582	974-1270	18402	Insignia, Organisation, Purse Queen's Own Highlanders	Aluminium, anodised silver. Thistle flower flanked by two leaves surmounted by St Edwards crown – H45mm x W34mm. 2 x vertical lugs H5mm, mounted on crown and flower 18mm apart. Complete with cotter pin.
208.	TL1044585	974-1282	23475	Insignia, Organisation, Shoulder Title Army Air Corps	Aluminium, anodised gold. Letters 'AAC' – H10mm x W29mm. 2 x horizontal fusion pins, 16mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.



TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
209.	TL1044621	974-2183	23021	Insignia, Organisation, Shoulder Title Royal Regiment of Artillery, All Ranks	Aluminium, anodised gold. Letters 'RA' – H10mm x W19mm. 2 x horizontal fusion pins, 14mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
210.	TL1044622	974-2186	22994A	Insignia, Organisation, Shoulder Title Royal Corps of Signals, All Ranks	Aluminium, anodised gold. Letters 'R.SIGNALS' – H10mm x W46mm. 2 x horizontal fusion pins, 40mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
211.	TL1044634	974-2267	19548	Insignia, Organisation, Cap Royal Regiment of Artillery, Soldiers	Aluminium, anodised gold, 2 part design. Left facing artillery gun with wheel riveted to chasis. Scroll above inscribed 'UBIQUE' and scroll below inscribed 'QUO FAS ET GLORIA DUCUNT', surmounted by St Edwards crown – H40mm x W53mm. With vertical hook mounted 10mm from top.
212.	TL1044816	977-3734	30467	Insignia, Organisation, Cap University of Southampton Officer Training Corps	Aluminium, anodised gold. University of Southampton coat of arms with scroll below inscribed 'STRENUIS ARDUA CEDUNT' – H47mm x W29mm. With vertical hook mounted 18mm from top.
213.	TL1044859	978-5357	23610	Insignia, Rank, Tie Pin Regulating Branch, Petty Officer	Aluminium anodised gold. St Edwards crown – H29mm x W29mm. 1 x fusion pins, mounted centrally. Complete with clutch fasteners.
214.	TL1044889	978-7833	24440	Insignia, Organisation, Cap University of Wales Officer Training Corps	Aluminium, anodised gold. Welsh dragon with scroll below inscribed 'UNIVERSITY OF WALES OTC' – H35mm x W42mm. With vertical hook mounted 13mm from top.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
215.	TL1044890	978-8104	24503	Badge Qualification Coxwains, Submariners, Royal Navy	Aluminium, anodised gold. 6 spoked ships wheel within wreath of laurels surmounted by St Edwards crown – H56mm x W41mm. 2 x vertical lugs H5mm, mounted on centre of crown and base of wreath 35mm apart. Complete with cotter pin.
216.	TL1044892	978-8143	27684	Insignia, Organisation, Cap Adjutant Generals Corps	Aluminium, anodised gold and silver. Gold lion upon a St Edwards crown within a wreath of laurels surmounted by St Edwards crown, upon a silver scroll bearing the motto 'ANIMO ET FIDE' – H34mm x W31mm. With vertical hook mounted 11mm from top.
217.	TL1044895	978-8512	24602	Insignia, Organisation, Shoulder Title Ministry of Defence Guard Service, All Ranks	Aluminium, anodised silver. Letters 'MOD GUARD SERVICE' – H21mm x W51mm. 2 x horizontal fusion pins, 25mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
218.	TL1044901	978-8547	24610	Insignia, Organisation, Cap Royal Dragoon Guards	Aluminium, anodised silver. Circlet inscribed 'ROYAL DRAGOON GUARDS MCMXCII' containing Enniskillen Castle with scroll below inscribed 'INNISKILLING' over the cross of St George on eight pointed star – H29mm x W29mm With vertical hook mounted 6mm from top.
219.	TL1044902	978-8548	24611A	Insignia, Organisation, Collar Royal Dragoon Guards, Soldiers	Aluminium, anodised silver. Low bake enamelled, blue circlet and scroll, red cross. Circlet inscribed 'ROYAL DRAGOON GUARDS MCMXCII' containing Enniskillen Castle with scroll below inscribed 'INNISKILLING' over the cross of St George on eight pointed star – H30mm x W30mm 1 x horizontal lug H4mm, mounted centrally. Complete with cotter pin and back plate. Supplied in handed pairs.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
220.	TL1044908	978-8561	27652	Insignia, Organisation, Cap Light Dragoons, Soldiers	Aluminium, anodised gold and silver, 2 part design. Low bake enamelled, dark blue circlet. Gold `LD` on silver backing within gold circlet inscribed `VIRET . IN . AETERNUM . MEREBIMUR . ` within gold wreath of laurels surmounted by gold St Edwards crown riveted onto a gold edged Maltese cross with silver diamond pattern infill – H45mm x W42mm. With vertical hook mounted 5mm from top of Maltese cross.
221.	TL1044909	978-8563	24622	Insignia, Organisation, Shoulder Title Light Dragoons, All Ranks	Aluminium, anodised gold. Letters `LIGHT DRAGOONS` – H19mm x W48mm. 2 x horizontal fusion pins, 20mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
222.	TL1044910	978-8721	24643	Insignia, Organisation, Shoulder Title Royal Dragoon Guards, All Ranks	Aluminium, anodised gold. Letters `R D G` – H15mm x W38mm. 2 x horizontal fusion pins, 25mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
223.	TL1044911	978-8767	24645	Insignia, Organisation, Shoulder Title Royal Irish Regiment	Aluminium anodised black finish. Letters `ROYAL IRISH`, curved – H20mm x W46mm, height of letters 11mm. 2 x horizontal fusion pins, 32mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
224.	TL1044929	978-9041	24852	Insignia, Organisation, Shoulder Title Royal Logistic Corps, Soldiers	Aluminium, anodised gold. Letters `R L C` – H11mm x W28mm. 2 x horizontal fusion pins, 18mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.

TABLE 7 – PRODUCT LISTING – NATO STOCK NUMBER, PATTERN NO, DESCRIPTION AND ADDITIONAL INFORMATION

Item No	TL Number	NATO Stock Number 8455-99-	Pattern No	Description	Additional Information
225.	TL1045002	978-9683	27494	Insignia, Organisation, Shoulder Title Queen's Royal Lancers, Soldiers	Aluminium, anodised gold. Letters 'Q R L' – H10mm x W35mm. 2 x horizontal fusion pins, 27mm apart, mounted centrally. Complete with 2 clutch fasteners. Supplied in pairs.
226.	TL1045007	991-2111	20966	Insignia, Rank, Shoulder Strap Quartermaster Sgts, Colour Sgts & Staff Sgts, Light Infantry & Royal Irish Regiment	Aluminium, anodised silver. St Edwards crown – H31mm x W32mm. 2 x vertical lugs H7mm, 18mm apart, mounted centrally. Complete with cotter pin and back plate.



**Manufacturing Specification for  
JACKET, WOMAN'S No.2 Dress Army (Separate items)  
SKIRT, WOMAN'S, No.2 Dress Army (Separate items)**

**Defence Clothing (DC)**

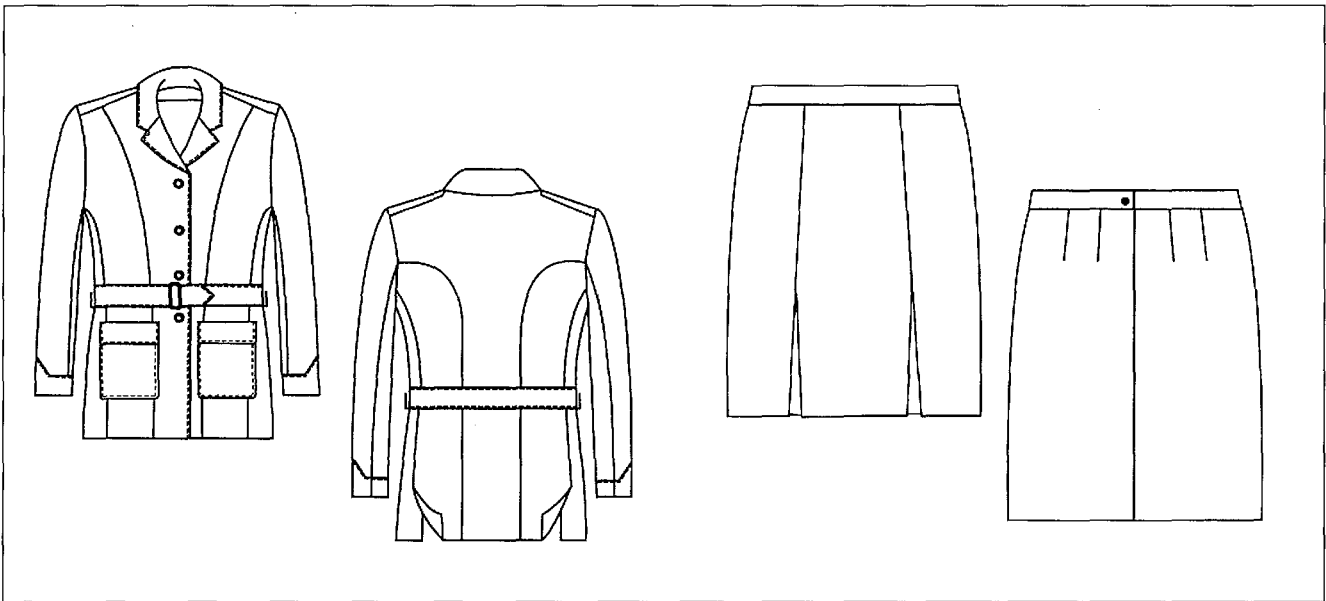
PROPERTY OF  
MINISTRY OF DEFENCE



**1. THE ITEM**

Item	Pattern No.	Electronic Pattern No.
JACKET, WOMAN'S, No.2 Dress Army	D00836A/1	D00836J
SKIRT WOMAN'S No.2 Dress Army	D00836A/2	D00836S

Use: A Jacket and Skirt issued as separate items made from Barathea, khaki material for wear as No.2 Dress by all ranks of Service women in the Army.



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

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**2. ISSUE RECORD**

Issue No.	Comments	Issue Date
12	Updated to new specification template	10 May 2022
11	Amended Issue number on title page	18 November 2016
10	Page 4: Bold text removed Pages 8 & 9: Column width extended Page 37: The word 'Uniform' changed to read 'Jacket and Skirt' Page 38: Main material NSN removed (8305-99-990-6968). Only Pattern number 8373B to be used	16 November 2016
09	Page 34: Broad arrow added to Identification labels Page 37: Related specification Table 7 titles updated to be in line with specifications and British Standards Page 41: Thread columns in Bill of materials table moved to the bottom to be in line with other specifications Reformatting and layout amended throughout specification	07 November 2016
08	Reformatted and layout amended to match order of other No.2 dress specifications Page 2 & 34: Pattern numbers updated Page 19. Additional wording added to patch pocket bindings Page 19. Added additional size to Table on page Page 28. Added additional size to Table on page Page 30 & 31: Date of manufacture added to identification label Page 31: Do not bleach care label icon updated Page 34 & 35: Related specifications checked and updated Page 35 to 37: Bill of materials checked and updated	03 May 2013

**2. ISSUE RECORD continued**

Issue No.	Comments	Issue Date
07	<p>Page 11 &amp; 36. Skirt size measurement NSN 8410-99-301-7091 amended to read 63/60/88</p> <p>Page 13. Seam types added</p> <p>Page 32. Outsize identification label amended to state what measurements required. Fibre content requirement inserted</p> <p>Page 34. Care Label updated. "Do not bleach" wash care icon amended</p> <p>Page 35. NSN 8410-99-238-9175 corrected to size 162/100/84</p> <p>Page 37. Main material pattern number added in related specification table. 's removed, ticket number and BS table number inserted in thread table</p>	17 January 2013
06	Reformatted without technical changes	09 May 2012
05	<p>Reformatted</p> <p>Laminate information added to section 3</p> <p>Page 28 Waistband depth amended to 4cm</p> <p>Requirement for Fibre Content added to Labelling</p>	09 February 2012
04	Additional NSNs added	09 July 2008
03	Fusing diagram amended, Quality statement added, wording on buttonholes changed, fusible added to skirt waistband	14 May 2008
02	Skirt garment sizing table amended	05 December 2007
	<p>Increased sizing and measurements in the jacket patch pocket, belt, inverted pleat, dart and slide fastener tables</p> <p>Terminology change, "Stock Size" now called "Stock Item" and, "Special Measure" now called "Outsize"</p>	
01	New specification derived from DC/MS/6264	29 October 2007



### 3. TECHNICAL DATA

#### 3.1 RELATED DOCUMENTS

Document	Title
BS EN ISO 3758	Textiles. Care labelling code using symbols
BS ISO 7769	Test Method for assessing the appearance of creases in fabrics after cleansing
BS EN 12590	Textiles. Industrial sewing threads made wholly or partly from synthetic fibres
BS 3870 Part 1 Part 2	Stitches and seams Classification and terminology of stitch type Classification and terminology of seam type
BS 4560	Fabrics for linings in uniform clothing
BS 4973 Part 2 Part 3 Part 4	Interlinings Non-woven fusible interlinings Woven and knitted fusible interlinings Woven sew-in interlinings
BS 5742	Specification for textile labels requiring to be washed and/or dry cleaned
BS 7141 Part 7	Narrow Fabrics Specification for woven cotton tapes and webbings
UK/SC/2124	Insignia, aluminium alloy, anodized Gold and Silver
UK/SC/4559	Slide fasteners, metallic & non-metallic chains
UK/SC/4885	Cloth, baratheia, wool, worsted
UK/SC/6723	Metal-ware – Various ceremonial items
8373B	Cloth baratheia, wool, worsted, khaki

#### 3.2 BILL OF MATERIALS

MAIN MATERIAL(S)		
Reference	Description	Notes/NATO Stock No.
UK/SC/4885 Pattern No. 8373B	MAIN MATERIAL Cloth, baratheia, wool, worsted, khaki	
BS 4560	LINING for JACKET, SKIRT and POCKET BAGS Cloth, plain weave, polyester, khaki to Table 1, Ref 1.14	Shade to match main material

3.2 BILL OF MATERIALS continued

<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Interlining	Charcoal	FOREPART, HIP POCKETS AND FLAPS Interlining, fusible, woven, knitted or non-woven type	BS 4973 Part 2 or 3
Interlining	Charcoal	CUFFS, FRONT FACING, TOP COLLAR & SHOULDER STRAPS, BELT AND STAY FOR HOOK & BAR Interlining fusible, non-woven type	BS 4973 Part 2
Interlining	Charcoal	WAISTBAND Nonwoven fusible interlinings	BS 4973 Part 2
Stay	6mm	UNDERCOLLAR Tape, woven cotton	BS 7141 Part 7 Ref CT2
Stay	Charcoal 30mm	BRIDLE, AND BUTTON AND BUTTONHOLE Tape, woven, fusible	BS 4973 Part 3
Stay	Charcoal 20mm	FRONT EDGES, BLACK NECK, ARMHOLE, PLEATS AND VENTS Tape, woven, fusible	BS 4973 Part 3
Stay	Black	WAIST HOOK Cloth plain weave linen	BS 4973 Part 4 Pattern No. 8443A Or a suitable alternative to be approved by DC
Felt	Shade to match main material	UNDER COLLAR Pre padded or pre fused felt	Or a suitable alternative to be approved by DC
Web	20mm	SECURING LINING/FACING SEAM Web, fusible	
Tape	Shade to match main material 6mm	HANGERS Tape, woven, polyester	Or a suitable alternative to be approved by DC

3.2 **BILL OF MATERIALS continued**

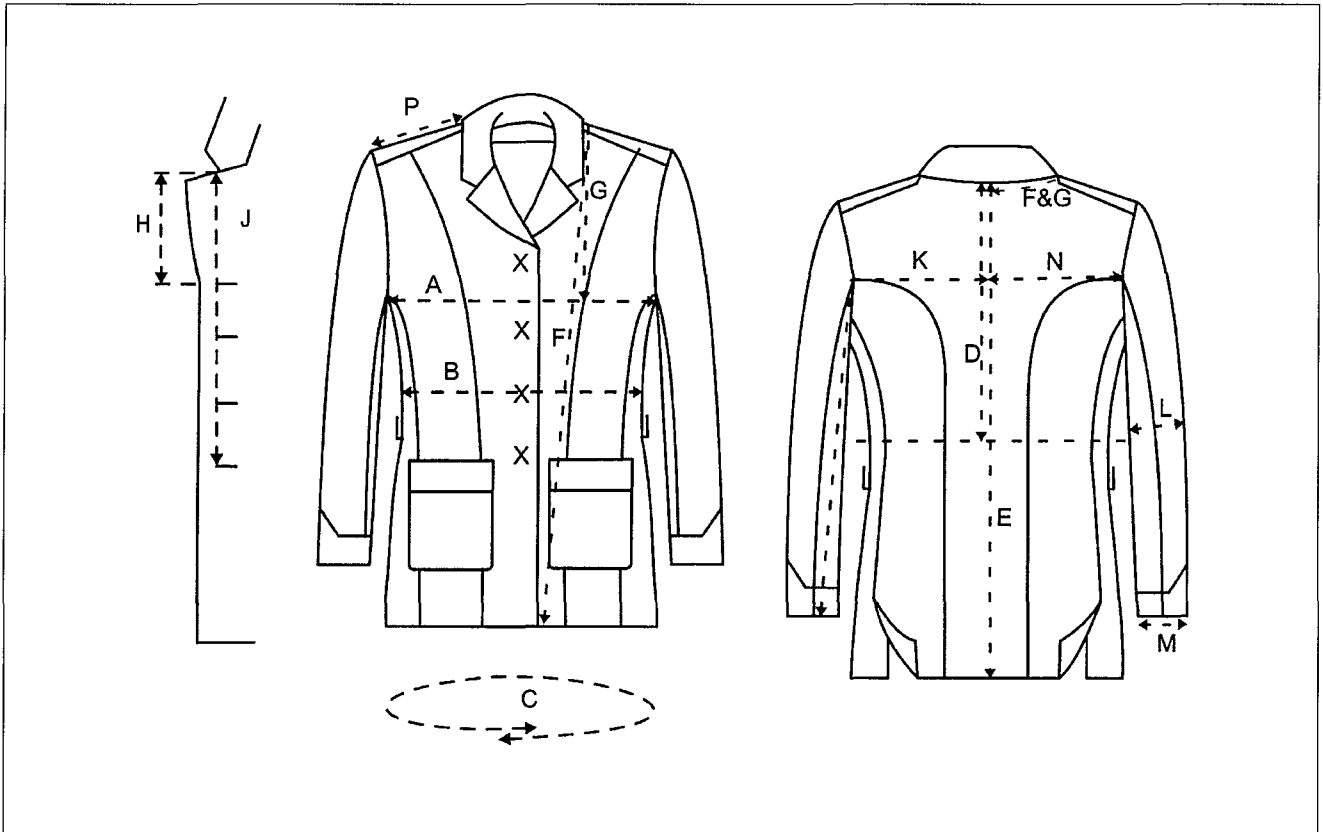
<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Pads		SHOULDER Bonded-fibre fabric layers (nylon) triacetate wadding filling	
Wadding		SLEEVEHEAD Bonded-fibre fabric base polyester wadding	
Fastener	Shade to match main material	SKIRT Fastener, slide, self concealing type, lightweight, polyester or polyamide, auto locking slider, bottom stop, 11mm wide stringer	To comply with UK/SC/4559
Button	Shade to match main material  16mm	SKIRT WAIST  Button sewing 4 hole as on Standard Pattern	
Buckle		BELT Anodised aluminium 2 prong	UK/SC/2124 Pattern No. 35/R/1286
Waist Hook	Brass	JACKET WAIST Brass self coloured finish	UK/SC/6723 Pattern No. 7220A
Permanent Crease		Resinated Bead from a 1mm nib (Supercrease® from Clantex Ltd. Has been found acceptable when applied using the appropriate formers)	BS ISO 7769 To comply with the requirements of CR-5
Identification/ care instruction label	White	Refer to section 6 for detail	BS 5742 Paragraph 3 BS EN ISO 3758
Thread	Shade to match main material	Polyamide, nylon 6.6 continuous filament	BS EN 12590 Table 7
Ticket No.	60	FOR SEWING BUTTONHOLES	Gimp

3.2 **BILL OF MATERIALS continued**

<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Thread	Shade to match main material	Polyester/cotton corespun	BS EN 12590 Table 5
Ticket No.	12	BUTTONHOLES	Gimp
Ticket No.	180	OVEREDGING MACHINE PADDING AND LASHING UP- TURN	
Ticket No.	75	ALL OTHER SEWING	

#### 4. GARMENT SIZING

All measurements in centimetres.



Outsize garments are to be made for the person whose measurements are supplied on the Outsize Form. The size chart is to be used as a guide for the allowance over the measurements supplied and measurements not shown on the form.

4. **GARMENT SIZING** continued

Size Height/Bust /Waist	Measurements of regular size Jacket													
	Around jacket fastened and laid flat			Back		Front				Sleeve			Half width of back	Length of shoulder seam
	Bust at base of armhole	Waist	At bottom edge to edge including underlaps	Length of back from collar seam to		Nape to bust prominence	Nape to front length	Length from collar step to		Length from centre back finished cuff	Width of sleeve			
				Waist	Bottom edge			Top buttonhole	Bottom buttonhole		At elbow ½ way between underarm and cuff	At cuff		
A x 2	B x 2	C x 2	D	E	F	G	H	J	K	L x 2	M x 2	N	P	
154/80/60	88	68	107	34	59.9	36	72		34	68.5	32	25	16.5	12.4
154/84/64	92	72	111	34.5	60	36.5	72.5		34.5	69	33	25	17	12.6
154/88/68	96	76	115	35	60.5	37.5	73		35	69.5	33	25	17.5	12.8
154/92/68	100	76	115	35.5	61	38	73.5	16	35.5	70	34	26	18	13
154/96/72	104	80	118	36	61.5	38.5	74		36	70.5	34	26	18.5	13.2
154/100/76	108	84	123	36.5	62	39.5	74.5		36.5	71	35	27	19	13.4
154/104/80	112	88	127	37	62.5	40	75		37	71.5	35	27	19.5	13.6
154/108/84	116	92	131	37.5	63	41	75.5		37.5	72	36	28	20	13.8
162/80/60	88	68	107	36	62.5	36.5	75		36	71	32	25	16.5	12.4
162/84/64	92	72	111	36.5	63	37	75.5		36.5	71.5	33	25	17	12.6
162/88/68	96	76	115	37	63.5	37.5	76		37	72	33	25	17.5	12.8
162/92/68	100	76	115	37.5	64	38	76.5		37.5	72.5	34	26	18	13
162/96/72	104	80	119	38	64.5	38.5	77	16.5	38	73	34	26	18.5	13.2
162/100/76	108	84	123	38.5	65	39.5	78		38.5	73.5	35	27	19	13.4
162/104/80	112	88	127	39	65.5	40	78.5		39	74	35	27	19.5	13.6
162/108/84	116	92	131	39.5	66	41	79		39.5	74.5	36	28	20	13.8
162/112/88	120	96	135	40	66.5	41.5	79.5		40	75	36	28	20.5	14
162/116/92	124	100	139	40.5	67	42	80		40.5	75.5	36	28	21	14.2
TOL +/-	1.5	1.5	1.5	1	1.5	1	1.5	0.5	0.5	1.5	1	1	0.5	0.5

4. **GARMENT SIZING** continued

Size Height/Bust /Waist	Measurements of regular size Jacket													
	Around jacket fastened and laid flat			Back		Front				Sleeve			Half width of back	Length of shoulder seam
	Bust at base of armhole	Waist	At bottom edge to edge including underlaps	Length of back from collar seam to		Nape to bust prominence	Nape to front length	Length from collar step to		Length from centre back finished cuff	Width of sleeve			
				Waist	Bottom edge			Top buttonhole	Bottom buttonhole		At elbow ½ way between underarm and cuff	At cuff		
A x 2	B x 2	C x 2	D	E	F	G	H	J	K	L x 2	M x 2	N	P	
170/84/64	92	72	111	38.5	66	36.5	78		38.5	74	33	25	17	12.6
170/88/68	96	76	115	39	66.5	37.5	79		39	74.5	33	25	17.5	12.8
170/92/68	100	76	115	39.5	67	38	79.5		39.5	75	34	26	18	13
170/96/72	104	80	119	40	67.5	38.5	80		40	75.5	34	26	18.5	13.2
170/100/76	108	84	123	40.5	68	39.5	81	17	40.5	76	35	27	19	13.4
170/104/80	112	88	127	41	68.5	40	81.5		41	76.5	35	27	19.5	13.6
170/108/84	116	92	131	41.5	69	41	82		41.5	77	36	28	20	13.8
170/112/88	120	96	135	42	69.5	41.5	82.5		42	77.5	36	28	20.5	14
170/116/96	124	100	139	42.5	70	42	83		42.5	78	36	28	21	14.2
170/120/96	128	104	143	43	70.5	42.5	83.5		43	78.5	37	29	21.5	14.4
178/88/68	96	76	115	41	69.5	37.5	82		41	77	33	25	17.5	12.8
178/92/68	100	76	115	41.5	70	38	82.5		41.5	77.5	34	26	18	13
178/96/72	104	80	119	42	70.5	38.5	83		42	78	34	26	18.5	13.2
178/100/76	108	84	123	42.5	71	39.5	84	17.5	42.5	78.5	35	27	19	13.4
178/104/80	112	88	127	43	71.5	40	84.5		43	79	35	27	19.5	13.6
178/108/84	116	92	131	43.5	72	41	85.5		43.5	79.5	36	28	20	13.6
178/112/88	120	96	135	44	72.5	42	86.5		44	80	36	28	20.5	14
178/116/92	124	100	139	44.5	73	42.5	87		44.5	80.5	37	29	21	14.2
178/120/96	128	104	143	45	73.5	43	87.5		45	81	37	29	21.5	14.4
TOL +/-	1.5	1.5	1.5	1	1.5	1	1.5	0.5	0.5	1.5	1	1	0.5	0.5

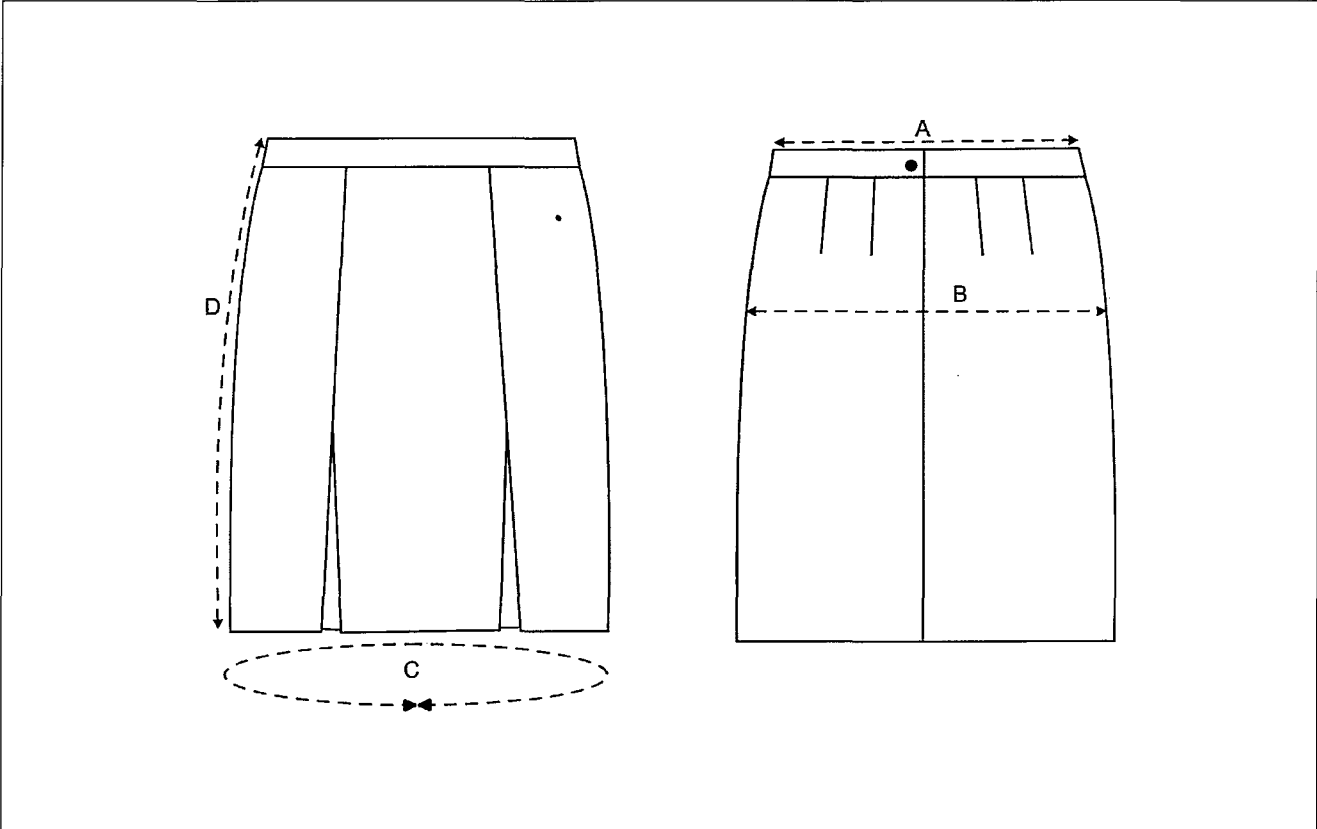
4. GARMENT SIZING continued

Size Height/Bust/ Waist	Measurements of fuller figure size Jacket													
	Around jacket			Back		Front				Sleeve			Half width of back	Length of shoulder seam
	Bust at base of armhole	Waist	At bottom edge to edge including underlaps	Length of back from collar seam to		Nape to bust prominence	Nape to front length	Length from collar step to		Length from centre back finished cuff	Width of sleeve			
				Waist	Bottom edge			Top buttonhole	Bottom buttonhole		At elbow ½ way between underarm and cuff	At cuff		
A x 2	B x 2	C x 2	D	E	F	G	H	J	K	L x 2	M x 2	N	P	
162/84/72	92	80	119	36.5	63	36.5	75		36.5	71.5	33	25	17	12.6
162/88/76	96	84	123	37	63.5	37.5	76		37	72	33	25	17.5	12.8
162/92/76	100	84	123	37.5	64	38	76.5		37.5	72.5	34	26	18	13
162/96/80	104	88	127	38	64.5	38.5	77		38	73	34	26	18.5	13.2
162/100/84	108	92	131	38.5	65	39.5	78	16.5	38.5	73.5	35	27	19	13.4
162/104/88	112	96	135	39	65.5	40	78.5		39	74	35	27	19.5	13.6
162/108/92	116	100	139	39.5	66	41	79		39.5	74.5	36	28	18	13.8
162/112/96	120	104	143	40	66.5	41.5	79.5		40	75	36	28	18.5	14
162/116/100	124	108	147	40.5	67	42	80		40.5	75.5	37	29	19	14.2
170/84/72	92	80	119	38.5	66	36.5	78		38.5	74	33	25	17	12.6
170/88/76	96	84	123	39	66.5	37.5	79		39	74.5	33	25	17.5	12.8
170/92/76	100	84	123	39.5	67	38	79.5		39.5	75	34	26	18	13
170/96/80	104	88	127	40	67.5	38.5	80		40	75.5	34	26	18.5	13.2
170/100/84	108	92	131	40.5	68	39.5	81	17	40.5	76	35	27	19	13.4
170/104/88	112	96	135	41	68.5	40	81.5		41	76.5	35	27	19.5	13.6
170/108/92	116	100	139	41.5	69	41	82		41.5	77	36	28	20	13.8
170/112/96	120	104	142	42	69.5	41.5	82.5		42	77.5	36	28	20.5	14
170/116/100	124	108	146	42.5	70	42	83		42.5	78	36	29	21	14.2
170/120/104	128	112	150	43	70.5	42.5	83.5		43	78.5	37	29	21.5	14.4
TOL +/-	1.5	1.5	1.5	1	1.5	1	1.5	0.5	0.5	1.5	1	1	0.5	0.5



4. **GARMENT SIZING continued**

All measurements in centimetres.



Outsize garments are to be made for the person whose measurements are supplied on the Outsize Form. The size chart is to be used as a guide for the allowance over the measurements supplied and measurements not shown on the form.

4. **GARMENT SIZING** continued

Size Length/Waist/Hips	Measurements of regular size Skirt			
	Fastened and laid flat		Around skirt with finished hem and pleats open	Length of skirt at side seam from top of band hemmed
	Around Waist	Around hips at bottom of slide fastener		
	A x 2	B x 2	C	D
63/60/88	62	84	148	63
63/64/92	66	98	152	
63/68/96	70	102	156	
63/72/100	74	106	160	
63/76/104	78	110	164	
63/80/108	82	114	168	
63/84/112	86	118	172	
67/60/88	62	84	148	67
67/64/92	66	98	125	
67/68/96	70	102	156	
67/72/100	74	106	160	
67/76/104	78	110	164	
67/80/108	82	114	168	
67/84/112	86	118	172	
67/88/116	90	122	176	
67/92/120	94	126	180	
71/64/92	66	98	152	71
71/68/96	70	102	156	
71/72/100	74	106	160	
71/76/104	78	110	164	
71/80/108	82	114	168	
71/84/112	86	118	172	
71/88/116	90	122	176	
71/92/120	94	126	180	
71/96/124	98	130	184	
75/64/92	66	98	152	75
75/68/96	70	102	156	
75/72/100	74	106	160	
75/76/104	78	110	164	
75/80/108	82	114	168	
75/84/112	86	118	172	
75/88/116	90	122	176	
75/92/120	94	126	180	
75/96/124	98	130	184	
Tolerance +/-	1.5	1.5	1.5	1.5

4. **GARMENT SIZING** continued

Size Length/Waist/Hips	Measurements of fuller figure size Skirt			
	Fastened and laid flat		Around skirt with finished hem and pleats open	Length of skirt at side seam from top of band hemmed
	Around Waist	Around hips at bottom of slide fastener		
	<b>A x 2</b>	<b>B x 2</b>	<b>C</b>	<b>D</b>
67/72/104	74	109	160	67
67/76/108	78	113	164	
67/80/112	82	117	168	
67/84/116	86	121	172	
67/88/120	90	125	176	
67/92/124	94	129	180	
67/96/128	98	133	184	
67/100/132	102	137	188	
71/72/104	74	109	160	71
71/76/108	78	113	164	
71/80/112	82	117	168	
71/84/116	86	121	172	
71/88/120	90	125	176	
71/92/124	94	129	180	
71/96/128	98	133	184	
71/100/132	102	137	188	
71/104/136	106	141	192	
Tolerance +/-	1.5	1.5	1.5	1.5

## 5. CONSTRUCTION

### FUSING DIAGRAM

COLOUR	PRODUCT	DESCRIPTION
	20mm woven tape	Front edges, back neck, armhole and vents
	Non-woven	Pocket flaps, pocket bags, front facing, top collar, shoulder straps and cuffs
	Woven, knitted or non-woven	Forepart
	Plain weave cotton	
	30mm woven tape	Bridle button/buttonholes
	Cotton and Hair	

The fusible interlining must be suitable for use with the garment fabric and fused in accordance with the manufacturers recommendations.

The resulting laminate shall be free from blisters and there shall not be strike through of adhesive on either the face or back.

The garment must be able to be laundered throughout its life in accordance with the care label, without any visible signs of delamination, puckering, loss of appearance and handle or excessive shrinkage.

**5. CONSTRUCTION continued**

QUALITY
<ul style="list-style-type: none"><li>• The garments are to be made to a high quality standard using sound tailoring production techniques to give a neat, smooth superior finish.</li><li>• Uniformity in appearance is essential. There should not be any noticeable variation between production garments and the Standard Pattern.</li><li>• It is essential that:<ul style="list-style-type: none"><li>• Body and sleeve linings are not tight.</li><li>• Garment parts are correctly aligned and the run of seams is regular and neatly under and top pressed.</li><li>• Front edges are thinly constructed, well pressed, regular in shape and free from distortion and that collar does not gape when fastened.</li><li>• Paired features (e.g. left and right collar end, cuffs, pockets etc.) must be balanced and should not be at the extremes of the tolerance, ensuring symmetry.</li><li>• Sleeves are correctly pitched, the sleeve-head fullness is correctly distributed, and the run is regular and well pressed.</li><li>• Shoulder seams are not distorted and wadding is securely and correctly inserted.</li></ul></li></ul>


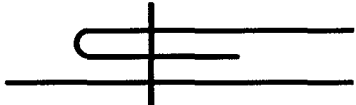
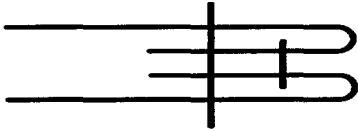
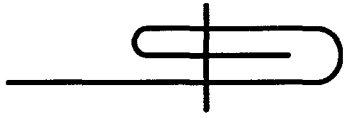
DESIGN- JACKET
<ul style="list-style-type: none"><li>• Single breasted to button four</li><li>• Step collar</li><li>• Patrol back with side vents</li><li>• Side body</li><li>• Shoulder straps</li><li>• Two piece set in sleeve</li><li>• Rifle cuff</li><li>• One inside ticket pocket (right front)</li><li>• Fully lined</li><li>• Patch hip pocket with flap</li><li>• Belt</li><li>• Retractable waist hook at side seam</li></ul>

**5. CONSTRUCTION continued**

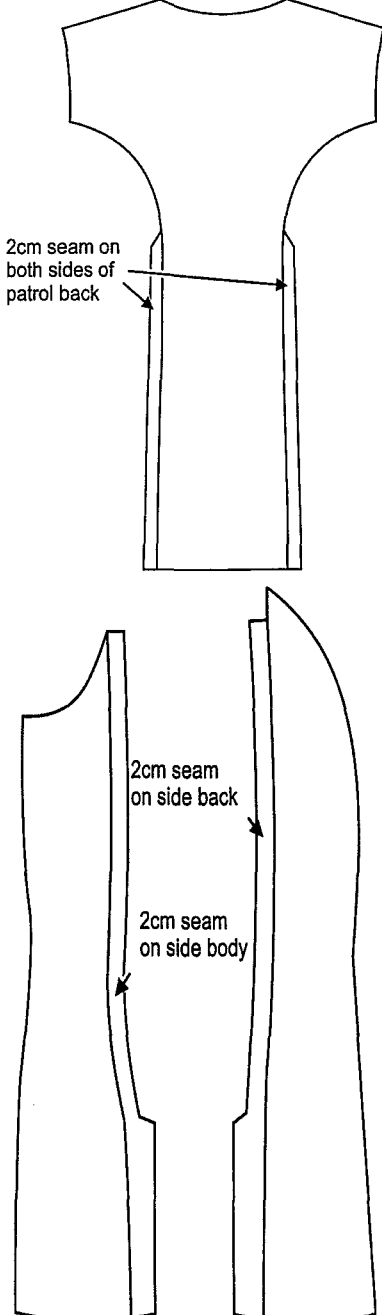
DESIGN- SKIRT
<ul style="list-style-type: none"> <li>• 5 piece panel skirt</li> <li>• Waistband with buttonhole fastening</li> <li>• Two inverted pleats at front</li> <li>• Permanent crease treatment in front pleats</li> <li>• Slide fastener at centre back</li> <li>• <math>\frac{3}{4}</math> Lined</li> </ul>

SEAMS AND STITCHING to BS 3870
<ul style="list-style-type: none"> <li>• Seam type 1.01.01 unless otherwise stated</li> <li>• Jacket and skirt upturn stitch type 103 with 4-7 stitches per 2cm</li> <li>• All other seams and topstitching stitch type 301</li> <li>• Seams to be pressed open with the exception of the armhole seam</li> <li>• 8-10 stitches per 2cm</li> <li>• All raw edges stitch type 502, 503, 504 or 505</li> <li>• Buttonholes to be cut before worked type 22 stitches per 2cm to be bar tack finished</li> </ul>

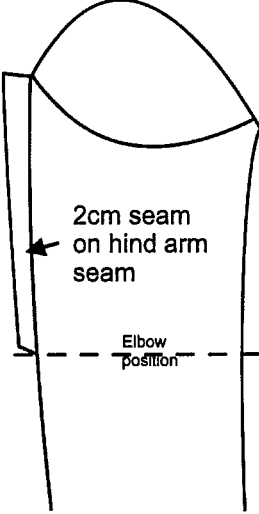
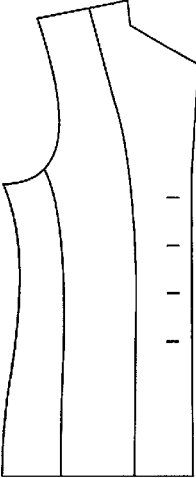
The following seam types are referenced in this specification:

	1.01.01		5.31.01
	1.06.02		6.03.01

5. **CONSTRUCTION continued**

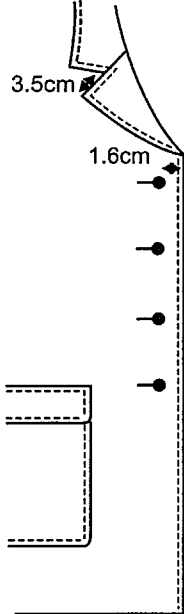
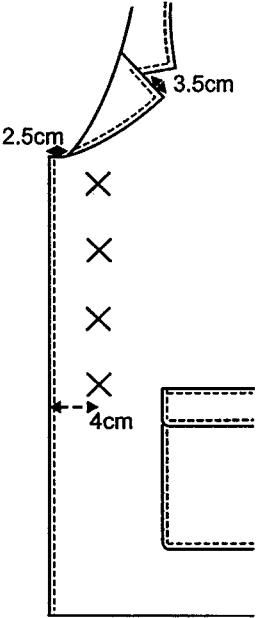
PART	DETAIL	SEAM REF
<p>5.1 INLAYS</p>  <p>2cm seam on both sides of patrol back</p> <p>2cm seam on side back</p> <p>2cm seam on side body</p>	<ul style="list-style-type: none"> <li>• Patrol back, 2cm seam from chest point to bottom of panel</li> <li>• Corresponding inlays are to be allowed on linings</li>   <li>• 2cm seam on back and side body seams</li> <li>• Corresponding inlays are to be allowed on linings</li> </ul>	

5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.1 INLAYS continued</p>  <p>2cm seam on hind arm seam</p> <p>Elbow position</p>	<ul style="list-style-type: none"> <li>• 2cm seam on hindarm from armhole to elbow point</li> <li>• Corresponding inlays are to be allowed on linings</li> </ul>	
<p>5.2 FOREPART</p> 	<ul style="list-style-type: none"> <li>• Cut with panelled fronts and side body</li> <li>• Front and side panels to have a fusible interlining</li> <li>• Cut to clear the sewing lines</li> <li>• Front edges, base of armhole button and buttonholes to be stayed with fusible tape</li> <li>• A bridle at the break line to be fused to the front interlining</li> <li>• Secured with three rows of machine padding stitches</li> <li>• Front edge seams to be pressed open before edge basting</li> </ul>	1.06.02



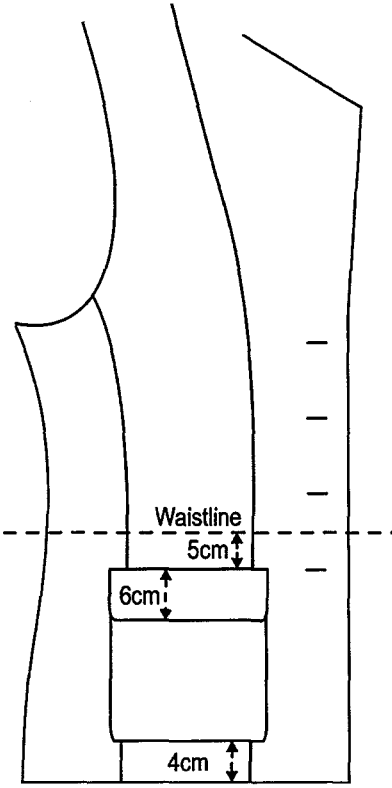
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.2 FOREPART continued</p>  	<p><u>Right forepart as worn</u></p> <ul style="list-style-type: none"> <li>• Four buttonholes 2.5cm effective cut length</li> <li>• The eyes 1.6cm from the edge</li> <li>• Position of top buttonhole see size chart</li> <li>• Fourth buttonhole positioned in line with top of hip pocket flap</li> <li>• Front to be edge stitched</li> <li>• Lapel step 3.5cm wide</li> </ul> <p><u>Left forepart as worn</u></p> <ul style="list-style-type: none"> <li>• Button stand to be 2.5cm</li> <li>• Position for four insignia buttons are to be marked with white thread</li> <li>• Positioned 4cm from the front edge</li> <li>• In register with the buttonholes on right forepart</li> </ul>	

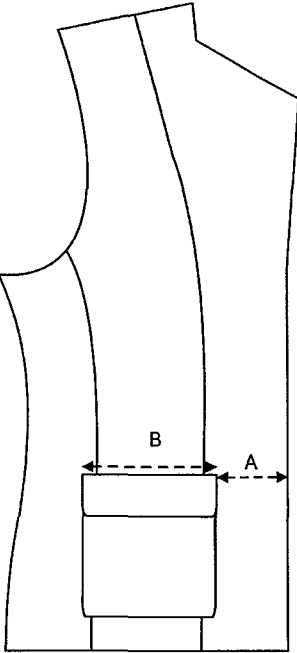
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.3 WAIST HOOK</p>	<p><u>Opening</u></p> <ul style="list-style-type: none"> <li>• A reinforced gap in stitching, to accommodate the retractable waist hook</li> <li>• Gap of 0.5cm is to be allowed in each side seam</li> <li>• Each side of the gap is to be securely back tacked</li> <li>• Positioned 1cm above the hip pocket flap</li> <li>• A two ply woven strip of linen is to be placed over the hook to form a pocket</li> <li>• The hook is to be stitched through the two layers of the pocket at the hook edge. As per diagram opposite</li> <li>• The pocket is then to be stitched around the outer edge after the hook insertion, prior to attachment to the side seam</li> <li>• The woven strip is to be attached to this side seams of the garment to correspond with the opening in the side seam of the jacket</li> <li>• Correctly tacked off 1cm above the top of the hook, to prevent the hook from moving</li> <li>• As shown on the diagram opposite</li> <li>• An opening is to be made in the side seam lining 7cm long</li> <li>• In alignment with the waist hook pocket</li> <li>• In the lining inlay</li> <li>• The opening is to be edge stitched</li> <li>• The inside is to be raw edge</li> </ul>	

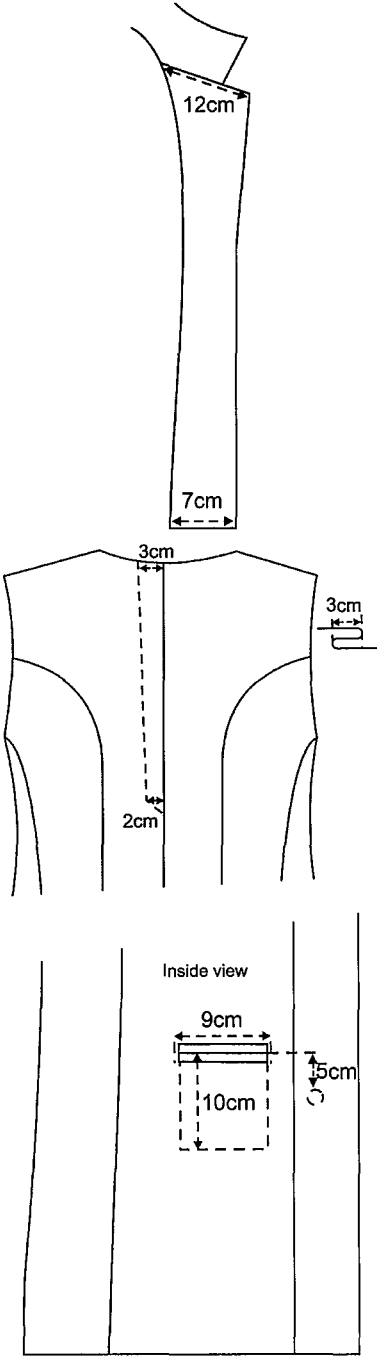
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.4 POCKETS AND FLAPS</p> 	<ul style="list-style-type: none"> <li>• Pocket flaps and patches are to be fused and sewn, using sewing jigs, on to each front</li> <li>• Top stitching 0.6cm from the top edge</li> <li>• Flap to be lined</li> <li>• Flap 6cm deep and to be edge stitched</li> <li>• Top edge of flap parallel with and 5cm below the waistline</li> <li>• The top of the flap is to be stayed with fusible tape, extending from the side seam to the front of the pocket</li> <li>• Top edge of patch to be bound 0.6cm wide with lining to extend 4cm into pocket</li> <li>• Top edge of the patch positioned 2cm below the top edge of the flap</li> <li>• Top corners to be securely tacked</li> <li>• Patch is to be edge stitched into position</li> <li>• Bottom edge of patch to be 4cm from the bottom of the jacket</li> </ul>	<p>5.31.01</p>

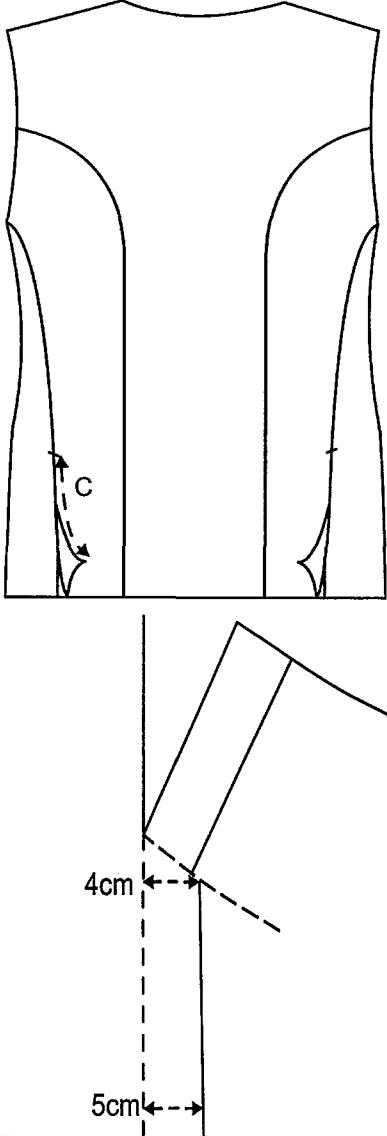
5. **CONSTRUCTION continued**

PART	DETAIL			SEAM REF
<p>5.4 POCKETS AND FLAPS continued</p> 	<ul style="list-style-type: none"> <li>Flap position from front of pocket to edge of jacket A and width of pocket flap B:</li> </ul>			
	Bust Size	A (cm)	B (cm)	
	80	7	15	
	80	7.5	15.5	
	84	8	16	
	88	8.5	16.5	
	92	9	17	
	96	9.5	17.5	
	100	10	18	
	104	10.5	18.5	
	108	11	19	
	112	11.5	19.5	
	116	12	20	
	120	12.5	20.5	

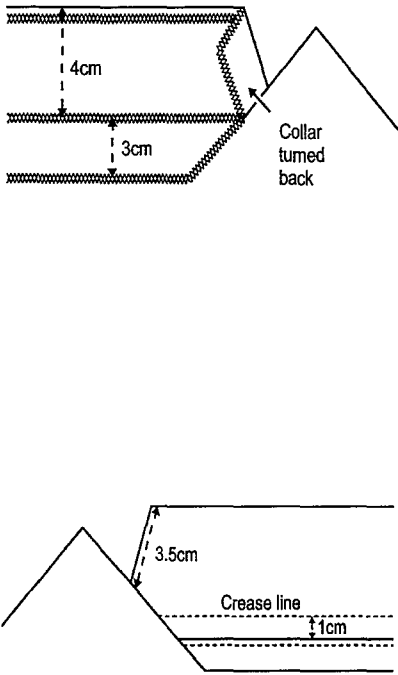
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.5 FRONT FACING AND BODY LINING</p> 	<ul style="list-style-type: none"> <li>• Facing to be interlined</li> <li>• Cut to clear sewing line at the gorge and lapel</li> <li>• Facing 12cm wide at the top</li> <li>• 7cm wide at the bottom</li> <li>• Lining cut to correspond with the side body and back</li> <li>• Facing lining seam secured to the front interlining using fusible web</li>   <li>• Lining to have a 3cm deep pleat in the centre back neck to 2cm wide at the waist</li>   <p><u>Left forepart as worn</u></p> <ul style="list-style-type: none"> <li>• Jetted inside ticket pocket</li> <li>• Positioned 5cm above the bottom button</li> <li>• Pocket opening 9cm</li> <li>• Effective pocket depth 10cm</li> <li>• Pocket ends to be securely tacked</li> </ul> </ul>	

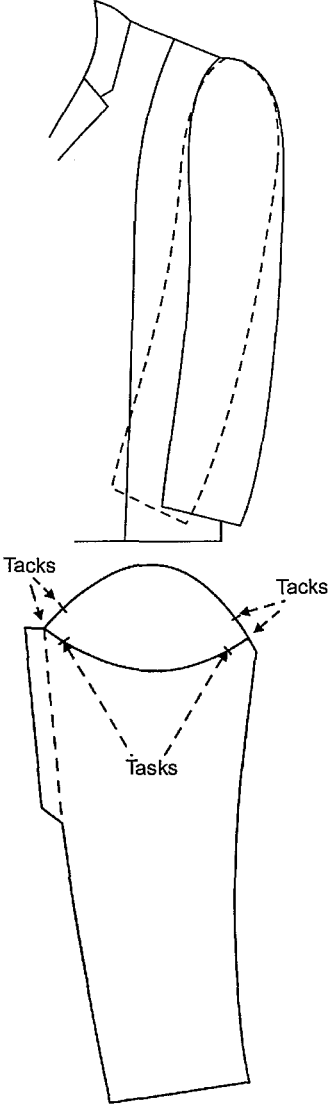
5. **CONSTRUCTION continued**

PART	DETAIL		SEAM REF										
<p>5.6 BACK</p> 	<ul style="list-style-type: none"> <li>• Cut with a patrol back</li> <li>• A vent worked in each side seam, length: <table border="1" data-bbox="560 533 1230 795"> <thead> <tr> <th>Height</th> <th>C (cm)</th> </tr> </thead> <tbody> <tr> <td>154</td> <td>14</td> </tr> <tr> <td>162</td> <td>15</td> </tr> <tr> <td>170</td> <td>16</td> </tr> <tr> <td>178</td> <td>17</td> </tr> </tbody> </table> </li> </ul> <ul style="list-style-type: none"> <li>• Under lap to be 4cm at the top edge</li> <li>• 5cm at the bottom edge</li> <li>• The tack is not to show on the outside of the garment</li> <li>• Top and under lap vent to be stayed with the fusible</li> <li>• Back armhole and neck to be stayed with fusible tape</li> </ul>		Height	C (cm)	154	14	162	15	170	16	178	17	
Height	C (cm)												
154	14												
162	15												
170	16												
178	17												

5. **CONSTRUCTION continued**

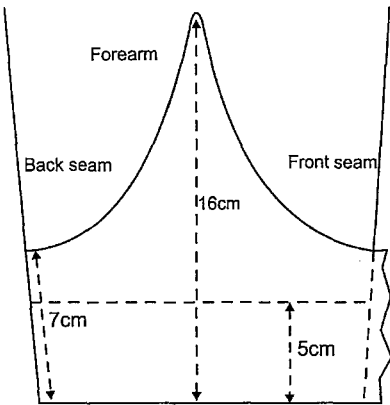
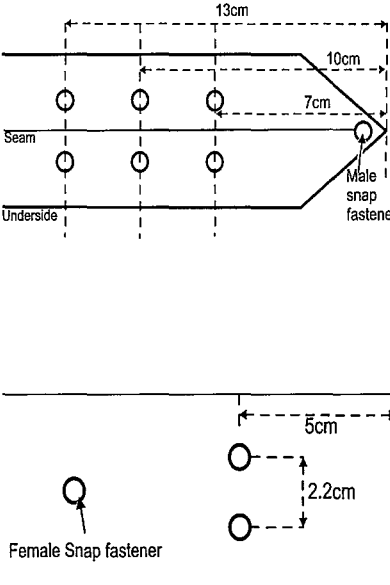
PART	DETAIL	SEAM REF
<p>5.7 COLLAR</p> 	<ul style="list-style-type: none"> <li>• The top and undercollar to be press cut with a square gorge</li> <li>• Under collar felt to be cut with a separate stand and fall</li> <li>• Crease edge stayed with tape</li> <li>• 4cm fall, 3cm stand measured from the crease line</li> <li>• Top collar to be cut with a separate stand and fall collar</li> <li>• Seam to be pressed open</li> <li>• Fall of top collar is interlined with a fusible</li> <li>• Interlining cut clear of sewing lines and crease edge</li> <li>• Collar turned back at step</li> <li>• Stand seam to be 1cm below crease line</li> <li>• Width of collar at step 3.5cm</li> <li>• Row of stitching sewn through the collar at stand and fall seam</li> <li>• Collar and lapel seam to be in line with lapel step</li> <li>• Collar to be edge stitched</li> </ul>	

5. **CONSTRUCTION continued**

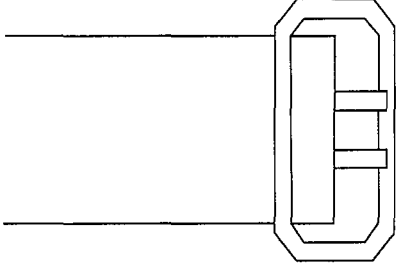
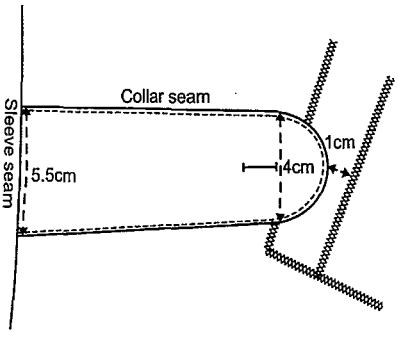
PART	DETAIL	SEAM REF
<p>5.8 SLEEVES</p>  <p>The drawing consists of two parts. The top part shows a side view of a sleeve with a solid line representing the correct pitch and a dotted line representing an incorrect pitch. The bottom part shows a top-down view of the sleevehead with six points labeled 'Tacks' where the sleevehead lining is secured to the armhole.</p>	<ul style="list-style-type: none"> <li>• It is essential the sleeves are correctly pitched for the erect stature required for uniform clothing</li> <li>• Solid line showing correctly pitched</li> <li>• Dotted line incorrectly pitched</li>   <li>• Sleevehead fullness is to be distributed and fixed using a programmed CAM controlled machine</li> <li>• Shoulder pads to be secured to the shoulder</li> <li>• A sleevehead wadding is to extend from the forearm seam to the hindarm seam</li> <li>• Sleevehead lining is to be machine sewn and securely tacked to the armhole at six points</li> <li>• At the forearm and hindarm seam</li> <li>• 4cm above and below forearm and hindarm seam</li> <li>• The sleeve is to be cut to the correct length</li> </ul>	



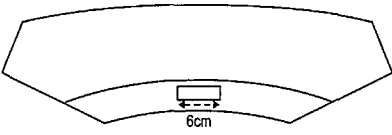
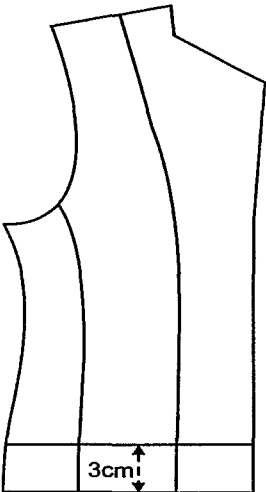
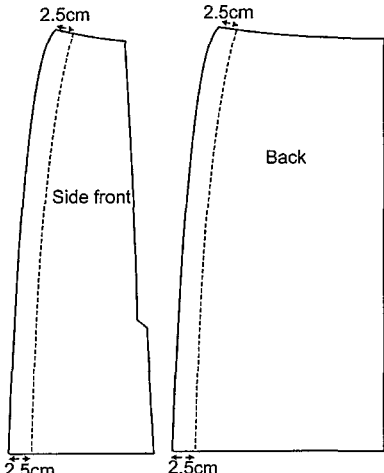
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.9 RIFLE CUFF</p> 	<ul style="list-style-type: none"> <li>• A rifle cuff is to be laid over the sleeve end and joined at the hind arm seam</li> <li>• To be edge stitched</li> <li>• Point of the rifle cuff to be in alignment with shoulder seam and edge stitched into place</li> <li>• 16cm deep at the point</li> <li>• 7cm deep at the hindarm seam, finished length</li> <li>• Rifle cuff up turn of 5cm to have fusible interlining</li> </ul>	
<p>5.10 BELT</p> 	<ul style="list-style-type: none"> <li>• Single ply main fabric folded and seamed to finish 5cm wide</li> <li>• To be edge stitched</li> <li>• Top side to have a fusible interlining</li> </ul> <p><u>Pointed end</u></p> <ul style="list-style-type: none"> <li>• Three pairs of eyelet holes to be worked centrally from the pointed end</li> <li>• Positioned 7cm, 10cm and 13cm</li> <li>• Spaced 2.2cm apart</li> <li>• Male portion of snap fastener sewn to underside of the pointed end</li> </ul> <p><u>Square end</u></p> <ul style="list-style-type: none"> <li>• Pair of eyelets worked centrally 5cm from end</li> <li>• Spaced 2.2cm apart</li> <li>• Female portion of snap fastener sewn centrally on the outside of the belt</li> <li>• In register with the male portion, when the belt is fastened on the centre pair of eyelets</li> </ul>	

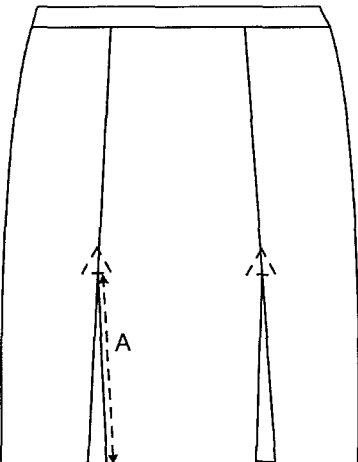
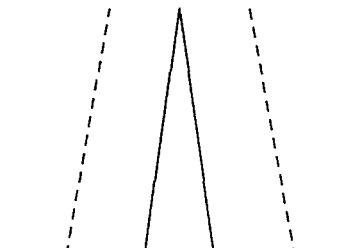
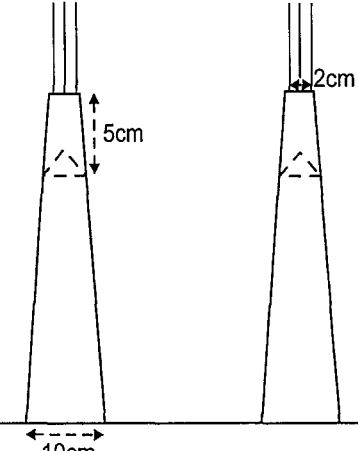
**5. CONSTRUCTION continued**

PART	DETAIL	SEAM REF																												
<p>5.10 BELT continued</p> 	<ul style="list-style-type: none"> <li>• A buckle to be fitted with a 5cm turn back overlapped and securely stitched down</li> <li>• Belt length from pointed end to buckle position to be 10cm longer than the garment waist measurement of the garment</li> <li>• Length of belt from centre of buckle to the middle eyelet holes:</li> </ul> <table border="1" data-bbox="566 728 1225 1086"> <thead> <tr> <th>Waist</th> <th>cm</th> <th>Waist</th> <th>cm</th> </tr> </thead> <tbody> <tr> <td>64</td> <td>72</td> <td>88</td> <td>96</td> </tr> <tr> <td>68</td> <td>76</td> <td>92</td> <td>100</td> </tr> <tr> <td>72</td> <td>80</td> <td>96</td> <td>104</td> </tr> <tr> <td>76</td> <td>84</td> <td>100</td> <td>108</td> </tr> <tr> <td>80</td> <td>88</td> <td>104</td> <td>112</td> </tr> <tr> <td>84</td> <td>92</td> <td></td> <td></td> </tr> </tbody> </table>	Waist	cm	Waist	cm	64	72	88	96	68	76	92	100	72	80	96	104	76	84	100	108	80	88	104	112	84	92			
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76	84	100	108																											
80	88	104	112																											
84	92																													
<p>5.11 SHOULDER STRAPS</p> 	<ul style="list-style-type: none"> <li>• Two ply main fabric with rounded end</li> <li>• 5.5cm wide at the sleeve seam</li> <li>• 4cm wide at the buttonhole</li> <li>• Top ply to have fusible interlining</li> <li>• Buttonhole 2.2cm effective cut length</li> <li>• Positioned centrally</li> <li>• The eye 4cm from the rounded free end</li> <li>• Button position on shoulder marked with white thread</li> <li>• In register with the buttonhole</li> <li>• Positioned centrally over the shoulder seam</li> <li>• Strap sewn in the sleeve seam</li> <li>• Free end of strap 1cm from collar stand seam</li> </ul>																													

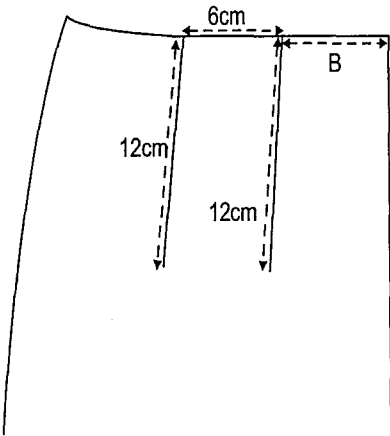
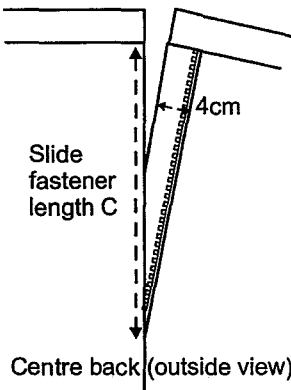
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.12 HANGER</p> 	<ul style="list-style-type: none"> <li>• Strap to be edge stitched</li> <li>• Sewn at centre back neck centrally above the back lining through the top and under collar</li> <li>• Effective length 6cm</li> </ul>	1.06.02
<p>5.13 UP-TURN</p> 	<ul style="list-style-type: none"> <li>• 3cm up-turn</li> <li>• Hem stitching not to show on outside of the garment</li> </ul>	6.02.02
<p>5.14 SEAM ALLOWANCE</p> 	<ul style="list-style-type: none"> <li>• Side seam to be 2.5cm</li> <li>• Corresponding seams to be allowed on the linings</li> </ul>	

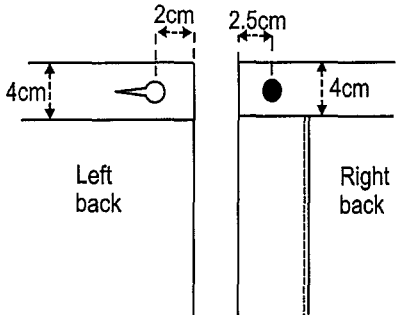
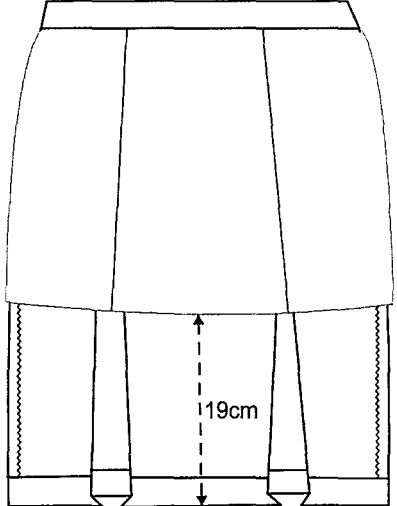
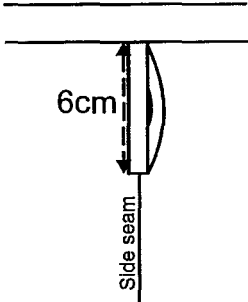
5. **CONSTRUCTION continued**

PART	DETAIL		SEAM REF										
<p>5.15 INVERTED PLEATS</p> 	<ul style="list-style-type: none"> <li>• Pleats at the bottom of each front panel</li> <li>• Pleats are to be permanently creased, a bead of resin is to be positioned correctly into the fold of the pleat</li> <li>• Backed by a single ply of main fabric</li> <li>• Pleat length:</li> </ul>												
	<table border="1"> <thead> <tr> <th>Skirt length</th> <th>A (cm)</th> </tr> </thead> <tbody> <tr> <td>63</td> <td>25</td> </tr> <tr> <td>67</td> <td>27</td> </tr> <tr> <td>71</td> <td>27</td> </tr> <tr> <td>75</td> <td>28</td> </tr> </tbody> </table>	Skirt length	A (cm)	63	25	67	27	71	27	75	28		
Skirt length	A (cm)												
63	25												
67	27												
71	27												
75	28												
	<ul style="list-style-type: none"> <li>• Effective pleat width 2cm at top</li> <li>• 10cm at the hem</li> <li>• An inlay of 5cm on top of pleat back</li> <li>• Top of the pleats to be securely tacked with 2cm wide triangular top stitching</li> <li>• When pressed the pleat is to lie closed along the full length</li> </ul>												

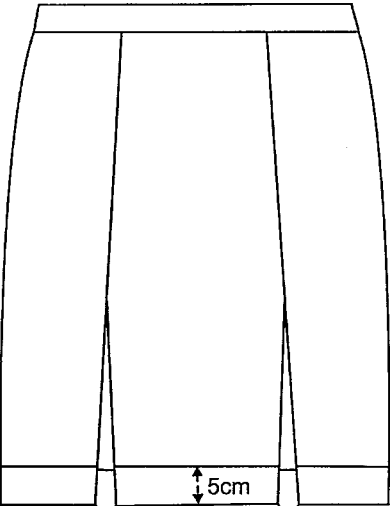
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF																												
<p>5.16 DARTS</p> 	<ul style="list-style-type: none"> <li>Two 2cm darts to be worked in each back panel</li> <li>Length 12cm</li> <li>1<sup>st</sup> positioned from centre back B, 2<sup>nd</sup> positioned 6cm further towards side seam</li> </ul> <table border="1" data-bbox="560 651 1225 1055"> <thead> <tr> <th>Waist Size</th> <th>B (cm)</th> <th>Waist size</th> <th>B (cm)</th> </tr> </thead> <tbody> <tr> <td>60</td> <td>4.0</td> <td>84</td> <td>7</td> </tr> <tr> <td>64</td> <td>4.5</td> <td>88</td> <td>7.5</td> </tr> <tr> <td>68</td> <td>5</td> <td>92</td> <td>8</td> </tr> <tr> <td>72</td> <td>5.5</td> <td>96</td> <td>8.5</td> </tr> <tr> <td>76</td> <td>6</td> <td>100</td> <td>9</td> </tr> <tr> <td>80</td> <td>6.5</td> <td>104</td> <td>9.5</td> </tr> </tbody> </table>	Waist Size	B (cm)	Waist size	B (cm)	60	4.0	84	7	64	4.5	88	7.5	68	5	92	8	72	5.5	96	8.5	76	6	100	9	80	6.5	104	9.5	
Waist Size	B (cm)	Waist size	B (cm)																											
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80	6.5	104	9.5																											
<p>5.17 SLIDE FASTENER</p> 	<ul style="list-style-type: none"> <li>Slide fastener sewn into the back seam</li> <li>Facing 4cm wide sewn to the right back as worn</li> <li>The bottom of the placket to be securely tacked</li> <li>Length:</li> </ul> <table border="1" data-bbox="560 1391 1225 1648"> <thead> <tr> <th>Skirt length</th> <th>C (cm)</th> </tr> </thead> <tbody> <tr> <td>63</td> <td>17</td> </tr> <tr> <td>67</td> <td>17</td> </tr> <tr> <td>71</td> <td>20</td> </tr> <tr> <td>75</td> <td>20</td> </tr> </tbody> </table>	Skirt length	C (cm)	63	17	67	17	71	20	75	20																			
Skirt length	C (cm)																													
63	17																													
67	17																													
71	20																													
75	20																													

5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.18 WAISTBAND</p> 	<ul style="list-style-type: none"> <li>• One piece interlined waistband fused with interlining</li> <li>• Waistband depth 4cm</li> <li>• Waistband square end</li> <li>• Buttonhole positioned centrally and 2cm from the end (left back as worn)</li> <li>• Button positioned centrally and 2.5cm from end (right back as worn)</li> </ul>	
<p>5.19 LINING</p> 	<ul style="list-style-type: none"> <li>• The lining is a five panel construction</li> <li>• To be sewn in with the waistband seam</li> <li>• Bottom edge left loose</li> <li>• Upturn 2cm overedge stitched and stitched down</li> <li>• Finished 19cm above the finished length of the skirt</li> </ul>	
<p>5.20 HANGER LOOPS</p> 	<ul style="list-style-type: none"> <li>• A loop effective length 6cm</li> <li>• Sewn in with the waistband</li> <li>• At each side seam</li> </ul>	


5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.21 HEM</p>  <p>The drawing shows a front view of a skirt with a hem. A vertical line indicates the center of the skirt. At the bottom, a horizontal line represents the hem edge. A double-headed vertical arrow below this line is labeled '5cm', indicating the height of the hem upturn.</p>	<ul style="list-style-type: none"><li>• Bottom overedge stitched</li><li>• 5cm upturn</li><li>• Hem stitching not to show on outside of the garment</li></ul>	<p>6.02.02</p>

## 6. LABELLING REQUIREMENTS






Labels	Position
Identification and care labels (can be combined to produce one label)	<p><b>JACKET:</b> Attached to the left facing below the bottom button</p> <p><b>SKIRT:</b> Attached on the inside of the placket facing, or folded and sewn in with the waist seam adjacent to the placket.</p>

### Identification Label

JACKET, WOMAN'S, No.2 Dress, Army*	
8410-99-238-9157*	
Height/Bust/Waist*	
Contract No.	
Name:	
No:	
Date of Manufacture: MM/YYYY	
<i>(Fibre content to be added here)</i>	

\*Amend as appropriate for end item

### Care Label

	DO NOT WASH
	DO NOT BLEACH
	DO NOT TUMBLE DRY
	DO NOT IRON
	Dry Clean Only

### Manufacturer Information

The contractor's name, logo or trademark should not appear on any labels, garment bags or packaging.



**7. TL NUMBER, NATO STOCK NUMBER AND SIZE**

TL Number	NATO Stock Number	Size
Jacket - Regular		
TL1036473	8410-99-301-7083	154/80/60
TL1036374	8410-99-238-9140	154/84/64
TL1036375	8410-99-238-9141	154/88/68
TL1036376	8410-99-238-9142	154/92/68
TL1036377	8410-99-238-9143	154/96/72
TL1036378	8410-99-238-9144	154/100/76
TL1036379	8410-99-238-9145	154/104/80
TL1036474	8410-99-301-7084	154/108/84
TL1036475	8410-99-301-7085	162/80/60
TL1036380	8410-99-238-9146	162/84/64
TL1036381	8410-99-238-9147	162/88/68
TL1036382	8410-99-238-9148	162/92/68
TL1036383	8410-99-238-9149	162/96/72
TL1036384	8410-99-238-9150	162/100/76
TL1036385	8410-99-238-9151	162/104/80
TL1036386	8410-99-238-9152	162/108/84
TL1036387	8410-99-238-9153	162/112/88
TL1036476	8410-99-301-7086	162/116/92
TL1036388	8410-99-238-9154	170/84/64
TL1036389	8410-99-238-9155	170/88/68
TL1036390	8410-99-238-9156	170/92/68
TL1036391	8410-99-238-9157	170/96/72
TL1036392	8410-99-238-9158	170/100/76
TL1036393	8410-99-238-9159	170/104/80
TL1036394	8410-99-238-9160	170/108/84
TL1036395	8410-99-238-9161	170/112/88
TL1036396	8410-99-238-9162	170/116/92
TL1036477	8410-99-301-7087	170/120/96

**7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued**

TL Number	NATO Stock Number	Size
Jacket - Regular		
TL1036397	8410-99-238-9163	178/88/68
TL1036398	8410-99-238-9164	178/92/68
TL1036399	8410-99-238-9165	178/96/72
TL1036400	8410-99-238-9166	178/100/76
TL1036401	8410-99-238-9167	178/104/80
TL1036402	8410-99-238-9168	178/108/84
TL1036403	8410-99-238-9169	178/112/88
TL1036404	8410-99-238-9170	178/116/92
TL1036478	8410-99-301-7088	178/120/96
Jacket – Fuller Figure		
TL1036405	8410-99-238-9171	162/84/72
TL1036406	8410-99-238-9172	162/88/76
TL1036407	8410-99-238-9173	162/92/76
TL1036408	8410-99-238-9174	162/96/80
TL1036409	8410-99-238-9175	162/100/84
TL1036410	8410-99-238-9176	162/104/88
TL1036411	8410-99-238-9177	162/108/92
TL1036412	8410-99-238-9178	162/112/96
TL1036479	8410-99-301-7089	162/116/100
TL1036413	8410-99-238-9179	170/84/72
TL1036414	8410-99-238-9180	170/88/76
TL1036415	8410-99-238-9181	170/92/76
TL1036416	8410-99-238-9182	170/96/80
TL1036417	8410-99-238-9183	170/100/84
TL1036418	8410-99-238-9184	170/104/88
TL1036419	8410-99-238-9185	170/108/92
TL1036420	8410-99-238-9186	170/112/96
TL1036421	8410-99-238-9187	170/116/100
TL1036480	8410-99-301-7090	170/120/104
TL1036422	8410-99-238-9188	Outsize

7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued

TL Number	NATO Stock Number	Size
Skirt - Regular		
TL1036481	8410-99-301-7091	63/60/88
TL1036423	8410-99-238-9189	63/64/92
TL1036424	8410-99-238-9190	63/68/96
TL1036425	8410-99-238-9191	63/72/100
TL1036426	8410-99-238-9192	63/76/104
TL1036427	8410-99-238-9193	63/80/108
TL1036428	8410-99-238-9194	63/84/112
TL1036483	8410-99-301-7093	67/60/88
TL1036429	8410-99-238-9195	67/64/92
TL1036430	8410-99-238-9196	67/68/96
TL1036431	8410-99-238-9197	67/72/100
TL1036432	8410-99-238-9198	67/76/104
TL1036433	8410-99-238-9199	67/80/108
TL1036434	8410-99-238-9200	67/84/112
TL1036435	8410-99-238-9201	67/88/116
TL1036484	8410-99-301-7094	67/92/120
TL1036436	8410-99-238-9202	71/64/92
TL1036437	8410-99-238-9203	71/68/96
TL1036438	8410-99-238-9204	71/72/100
TL1036439	8410-99-238-9205	71/76/104
TL1036440	8410-99-238-9206	71/80/108
TL1036441	8410-99-238-9207	71/84/112
TL1036442	8410-99-238-9208	71/88/116
TL1036485	8410-99-301-7095	71/92/120
TL1036486	8410-99-301-7096	71/96/124

**7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued**

TL Number	NATO Stock Number	Size
Skirt - Regular		
TL1036443	8410-99-238-9209	75/64/92
TL1036444	8410-99-238-9210	75/68/96
TL1036445	8410-99-238-9211	75/72/100
TL1036446	8410-99-238-9212	75/76/104
TL1036447	8410-99-238-9213	75/80/108
TL1036448	8410-99-238-9214	75/84/112
TL1036449	8410-99-238-9215	75/88/116
TL1036487	8410-99-301-7097	75/92/120
TL1036488	8410-99-301-7098	75/96/124
Skirt – Fuller Figure		
TL1036450	8410-99-238-9216	67/72/104
TL1036451	8410-99-238-9217	67/76/108
TL1036452	8410-99-238-9218	67/80/112
TL1036453	8410-99-238-9219	67/84/116
TL1036454	8410-99-238-9220	67/88/120
TL1036455	8410-99-238-9221	67/92/124
TL1036489	8410-99-301-7099	67/96/128
TL1036490	8410-99-301-7100	67/100/132
TL1036456	8410-99-238-9222	71/72/104
TL1036457	8410-99-238-9223	71/76/108
TL1036458	8410-99-238-9224	71/80/112
TL1036459	8410-99-238-9225	71/84/116
TL1036460	8410-99-238-9226	71/88/120
TL1036461	8410-99-238-9227	71/92/124
TL1036462	8410-99-238-9228	71/96/128
TL1036482	8410-99-301-7092	71/100/132
TL1036491	8410-99-301-7101	71/104/136
TL1036463	8410-99-238-9229	Outsize



**Manufacturing Specification for  
JACKET, MAN'S, No.2 Dress, Army, All Ranks (Jacket only)  
TROUSERS, MAN'S, No.2 Dress, Army, All Ranks  
(Trousers only)**

**Defence Clothing (DC)**

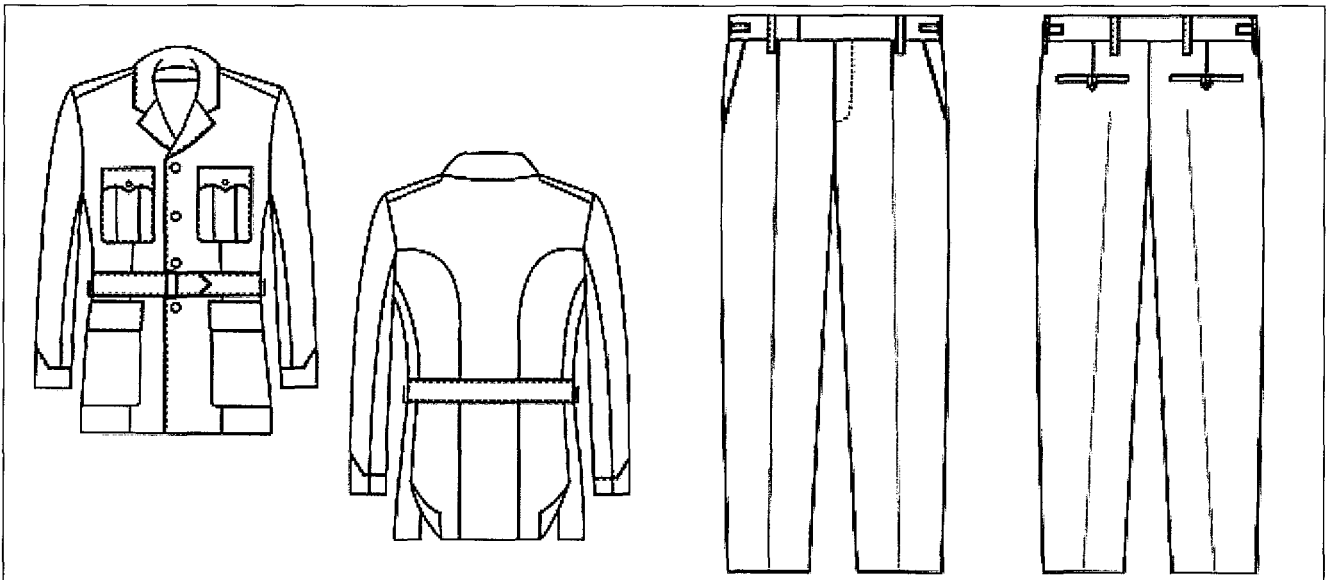
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**1. THE ITEM**

Item	Pattern No.	Electronic Pattern No.
JACKET, MAN'S, No 2 Dress, Army	D00833A/1 TG	D00833J
TROUSERS, MAN'S, No 2 Dress, Army	D00833A/2 TG	D00833T

Use: Jacket and Trousers supplied as separate items of No.2 Dress for Male Army Officers and Soldiers. Jackets only supplied to regiments who traditionally wear regimental coloured trousers. Provided in 99 sizes and an outsize.



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

**IPR STATEMENT**

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## 2. ISSUE RECORD

Issue No.	Comments	Issue Date
11	Updated to new specification template	11 May 2022
10	Size chart amended for uniform jacket, to fall in line with Gerber pattern measurements.- sleeve length grading for regular and stout column J  Page 48: Related specification Table 7 titles updated to be in line with specifications and British Standards  Page 43: Broad arrow added onto identification labels  Reformatting and layout amended throughout specification	03 November 2016
09	Reformatted and layout amended to match order of other No.2 dress specifications  Pattern numbers updated  Reference to uniform deleted from scope  Additional wording added to patch pocket bindings  Changed breast pocket width on last 2 sizes to 17cm  No grade on internal pockets  Changed side seam finished depths on pages 13 and 14  Changed pleat position A and dart position B on page 32  Graded side pockets on trousers C on page 33  Deleted table for hip pocket position on page 34 now positioned centrally around dart. Hip pocket no longer graded  Date of manufacture added to identification label  Bill of materials checked and updated  Page 47. Pattern No. 8190K changed to 8190U  Related specifications checked and updated	30 April 2013
08	NSN's corrected on pages 2, 45 and 46: 8405-99-213-2400 to 2402 replaced with 8405-99-958-1277 to 1279  Page 48. The term "Gimp" removed from the Bill of Materials	16 January 2013
07	Page 42, NSN table – NSN's 8405-99-501-1811 and 501-1812 sizes corrected from 176 to 182  Do not bleach care label icon updated  Main material pattern number added to Related Documents table	01 August 2012

2. **ISSUE RECORD continued**

Issue No.	Comments	Issue Date
06	Reformatted Laminate information added to section 3 BS EN 25077 replaced by BS EN ISO 5077 DEF STAN 83-65 replaced by UK/SC/6577 Requirement for Fibre Content added to labelling	07 February 2012
05	Additional sizes added to Jacket and Trousers and to manufacturing tables Sleeves shortened; back width increased	11 December 2008
04	Additional NSNs for Trousers	09 July 2008
03	Fusing Diagram amended Quality statement added Wording on buttonholes changed Thigh measurement changed Diagram added to show pleat in back lining	14 May 2008
02	Table information for Pleats & Darts and Hip Pockets has been amended Terminology change, 'Stock Size', now called 'Stock Item' and 'Special Measure', now called 'Outsize'	04 December 2007
01	Derived from DC/MS/6263 for Jacket and Trousers issued as separate items	07 November 2007



### 3. TECHNICAL DATA

#### 3.1 RELATED DOCUMENTS

Document	Title
BS EN ISO 3758	Textiles. Care labelling code using symbols
BS ISO 7769	Textiles. Test method for assessing the appearance of creases in fabrics after cleansing
BS EN 12590	Textiles. Industrial sewing threads made wholly or partly from synthetic fibres
BS 3870	Stitches and seams
Part 1	Classification and terminology of stitch type
Part 2	Classification and terminology of seam type
BS 4560	Fabrics for linings in uniform clothing
BS 4973	Interlinings
Part 2	Non-woven fusible interlinings
Part 3	Woven and knitted fusible interlinings
Part 4	Woven sew-in interlining
BS 5742	Textile labels requiring to be washed and/or dry cleaned
BS 7141	Narrow fabrics
Part 7	Specification for woven cotton tapes and webbings
UK/SC/2124	Insignia, Aluminium Alloy, Anodized Gold and Silver
UK/SC/4559	Slide fasteners, metallic and non-metallic chains
UK/SC/4885	Cloth, barathea, wool, worsted
UK/SC/6577	Cloth, Twill, Polyester and Cotton, FS
UK/SC/6723	Metal-ware. Various Ceremonial Items
8373B	Cloth, Barathea, Wool, Worsted, Khaki

### 3.2 BILL OF MATERIALS

<b>MAIN MATERIAL(S)</b>		
Reference	Description	Notes/NATO Stock No.
UK/SC/4885 Pattern No. 8373B	MAIN MATERIAL Cloth baratheia, wool, worsted khaki	
BS 4560  Table 1 Ref 1.14	LINING FOR BODY OF JACKET, SLEEVES FLAP, BINDING TOP EDGE OF POCKETS  Cloth, plain weave, polyester, khaki. Shade to match main material	
UK/SC/6577  Pattern No. 8190U to guide	TROUSER POCKETS, FORK STAYS, CRUTCH LINING, FLY LINING, BINDING SEAT SEAM AND POCKET BAGS  Cloth, twill, polyester and cotton, colour to match main material, FS	Or a suitable alternative to be approved by DC

<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Interlining	Charcoal	FOREPART, HIP POCKETS & FLAPS  Interlining fusible, woven, knitted or non-woven type	BS 4973 Part 3 or 2
Interlining	Charcoal	BELT, POCKET FLAPS, FRONT FACING, TOP COLLAR, TROUSER FLY, CUFFS AND STAY FOR HOOK AND BAR, SHOULDER STRAPS AND WAISTBAND EXTENSION  Interlining fusible, non-woven type	BS 4973 Part 2
Stay	Charcoal  30mm	BRIDLE, POCKET, FRONT BUTTON AND BUTTONHOLE STAYS, TROUSER SIDE STAYS AND HIP POCKET  Tape, woven fusible	BS 4973 Part 3
Stay	Charcoal  20mm	FRONT EDGES, BACK NECK, SCYE AND VENTS  Tape, woven, fusible	BS 4973 Part 3
Stay	10mm wide	UNDER COLLAR  Tape woven cotton	BS 7141 Part 7 Ref No CT2

3.2 BILL OF MATERIALS continued

COMPONENTS			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Stay	Black	WAIST HOOK Cloth plain weave linen	BS4973 Part 4 Pattern No. 8443A 8305-99-942-7523 Or a suitable alternative to be approved by DC
Felt	Shade to match main material	UNDERCOLLAR Pre-padded or pre-fused felt	Or a suitable alternative to be approved by DC
Web	20mm	SECURING LINING/FACING SEAM Web, fusible	
Reinforcement		SHOULDER/CHEST Cloth, interlining, cotton and hair	BS 4973 Part Pattern No. 8343A Ref WS5 8305-99-942-7003 Or a suitable alternative to be approved by DC
Reinforcement	Black 2.5cm wide finished items to weigh at least 5.5g/m <sup>2</sup>	WAISTBAND Interlining plain weave continuous filament polyester warp, 100 Tex mono filament nylon weft, acrylic melamine resin finish with at least 34 ends per width and 10 picks per cm. Edged sealed with PVC heat set into a concave shape	Or a suitable alternative to be approved by DC
Reinforcement	Shade to match material 25mm	TROUSER BOTTOM Webbing nylon	Or a suitable alternative to be approved by DC
Tape	6mm wide Shade to match main material	HANGER Tape woven polyester	Or a suitable alternative to be approved by DC

3.2 BILL OF MATERIALS continued

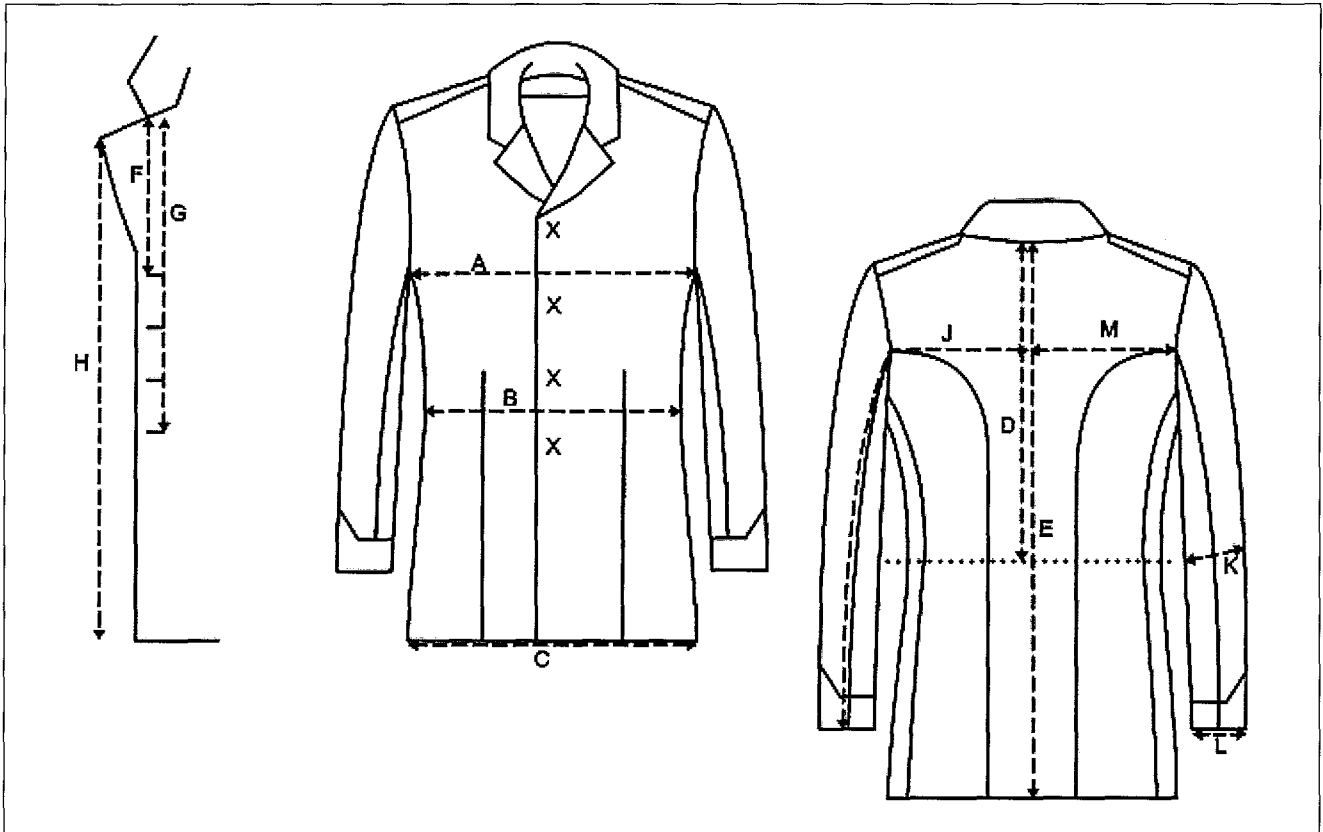
<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Pads		SHOULDER Bonded-fibre fabric layers (nylon) triacetate wadding filling	
Wadding		SLEEVEHEAD Bonded-fibre fabric base, polyester wadding	
Fastener	Shade to match main material  11mm wide stringer	FLY  Fastener slide lightweight polyester or polyamide, spiral chain, closed end, auto locking slider, and bottom stop	To comply with UK/SC/4559
Fastener	Nickel plated	WAIST Hook and bar, steel	
Snap fasteners	Brass black enamelled	BREAST POCKETS Sewn on type as on standard pattern	Or a suitable alternative to be approved by DC
Buckle		BELT Anodised aluminium 2 prong	UK/SC/2124 Pattern No.35/R/1286 8315-99-973-0644
Buckle	Nickel plated 20mm	TROUSER WAIST ADJUSTMENT Buckles, slide, steel as on standard pattern	
Waist Hook	Brass	JACKET WAIST Brass, self-coloured finish	UK/SC/6723 Pattern No.7220A 8315-99-973-0743

3.2 BILL OF MATERIALS continued

<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Permanent Crease		Resinated Bead from a 1mm nib (Supercrease® from Clantex Ltd has been found acceptable when applied using the appropriate formers)	BS ISO 7769 To comply with the requirements of CR-5
Tape	Shade to match main material  6mm wide	HANGER  Tape, woven, polyester	Or a suitable alternative to be approved by DC
Button	Shade to match main material  16mm	INSIDE BREAST POCKET  Button sewing 4 hole as on standard pattern	
Identification/ care instruction label	White	Refer to section 6 for detail	BS 5742 Paragraph 3 BS EN ISO 3758
Thread	Shade to match main material	FOR SEWING BUTTONHOLES	BS EN 12590 Table 7
Ticket No.	60	Polyamide, nylon 6.6 continuous filament	Gimp
Thread	Shade to match main material	Polyester and cotton continuous filament polyester core, cotton sheath	BS EN 12590 Table 5
Ticket No.	12	BUTTONHOLES	Gimp
Ticket No.	50	SEWING BUTTONS	
Ticket No.	180	OVEREDGING AND LASHING UPTURN	
Ticket No.	75	ALL OTHER SEWING	

#### 4. GARMENT SIZING

All measurements in centimetres.



Outsize garments are to be made for the person whose measurements are supplied on the Outsize Form. The size chart is to be used as a guide for the allowance over the measurements supplied and measurements not shown on the form.

4. GARMENT SIZING

Size Height/Chest/Waist	Jacket – Measurements of Regular size garment											
	Around Jacket		Back		Front from collar step to			Sleeve			Half width of back	
	Fastened and laid flat		At bottom edge including underlap	From collar seam to waist	Full length	Top buttonhole	Bottom buttonhole	Bottom of jacket	Length from centre of back to cuff	Width at		
	Chest	Waist								Elbow ½ way between cuff and underarm	Cuff	
	Ax2	Bx2	Cx2	D	E	F	G	H	J	Kx2	Lx2	M
164/80/68	90	74	122	38	71	15	37	67	77.5	36	28	17.5
164/84/72	94	78	126	38.5	71.5		37.5	67.5	78	37	29	18
164/88/76	98	82	130	39	72		38	68	78.5	37	29	18.5
164/92/76	102	82	134	39.5	72.5		38.5	68.5	79	38	30	19
164/96/80	106	86	138	40	73		39	69	79.5	38	30	19.5
164/100/84	110	90	142	40.5	73.5		39.5	69.5	80	39	31	20
164/104/88	114	94	146	41	74		40	70	80.5	39	31	20.5
164/108/92	118	98	150	41.5	74.5		40.5	70.5	81	40	32	21
170/84/72	94	78	126	40	74	15.5	39	70	80.5	37	29	18
170/88/76	98	82	130	40.5	74.5		39.5	70.5	81	37	29	18.5
170/92/76	102	82	134	41	75		40	71	81.5	38	30	19
170/96/80	106	86	138	41.5	75.5		40.5	71.5	82	38	30	19.5
170/100/84	110	90	142	42	76		41	72	82.5	39	31	20
170/104/88	114	94	146	42.5	76.5		41.5	72.5	83	39	31	20.5
170/108/92	118	98	150	43	77		42	73	83.5	40	32	21
170/112/96	122	102	154	43.5	77.5		42.5	73.5	84	40	32	21.5
170/116/100	126	106	158	44	78		43	74	84.5	41	32	22
170/120/104	130	110	162	44.5	78.5		43.5	74.5	85	41	33	22.5

**4. GARMENT SIZING continued**

Size Height/Chest/Waist	Jacket – Measurements of Regular size garment											
	Around Jacket			Back		Front from collar step to			Sleeve			Half width of back
	Fastened and laid flat		At bottom edge including underlap	From collar seam to waist	Full length	Top buttonhole	Bottom buttonhole	Bottom of jacket	Length from centre of back to cuff	Width at		
	Chest	Waist								Elbow ½ way between cuff and underarm	Cuff	
	Ax2	Bx2	Cx2	D	E	F	G	H	J	Kx2	Lx2	
176/84/72	94	78	126	41.5	76.5		40.5	72.5	83	37	29	
176/88/76	98	82	130	42	77		41	73	83.5	37	29	18.5
176/92/76	102	82	134	42.5	77.5		41.5	73.5	84	38	30	19
176/96/80	106	86	138	43	78		42	74	84.5	38	30	19.5
176/100/84	110	90	142	43.5	78.5		42.5	74.5	85	39	31	20
176/104/88	114	94	146	44	79	16	43	75	85.5	39	31	20.5
176/108/92	118	98	150	44.5	79.5		43.5	75.5	86	40	32	21
176/112/96	122	102	154	45	80		44	76	86.5	40	32	21.5
176/116/100	126	106	158	45.5	80.5		44.5	76.5	87	41	33	22
176/120/104	130	110	162	46	81		45	77	87.5	41	33	22.5
176/124/108	134	114	166	46.5	81.5		45.5	77.5	88	42	34	23
182/88/76	98	82	130	43.5	79.5		42.5	75.5	86	37	29	18.5
182/92/76	102	82	134	44	80		43	76	86.5	38	30	19
182/96/80	106	86	138	44.5	80.5		43.5	76.5	87	38	30	19.5
182/100/84	110	90	142	45	81		44	77	87.5	39	31	20
182/104/88	114	94	146	45.5	81.5	16.5	44.5	77.5	88	39	31	20.5
182/108/92	118	98	150	46	82		45	78	88.5	40	32	21
182/112/96	122	102	154	46.5	82.5		45.5	78.5	89	40	32	21.5
182/116/100	126	106	158	47	83		46	79	89.5	41	32	22
182/120/104	130	110	162	47.5	83.5		46.5	79.5	90	41	33	22.5
182/124/108	134	114	166	48	84		47	80	90.5	42	34	23



4. GARMENT SIZING continued

Size Height/Chest/Waist	Jacket – Measurements of Regular size garment											
	Around Jacket		Back		Front from collar step to			Sleeve			Half width of back	
	Fastened and laid flat		At bottom edge including underlap	From collar seam to waist	Full length	Top buttonhole	Bottom buttonhole	Bottom of jacket	Length from centre of back to cuff	Width at		
	Chest	Waist								Elbow ½ way between cuff and underarm	Cuff	
	Ax2	Bx2	Cx2	D	E	F	G	H	J	Kx2	Lx2	M
188/92/76	102	82	134	45.5	82.5	17	44.5	78.5	89	38	30	19
188/96/80	106	86	138	46	83		45	79	89.5	38	30	19.5
188/100/84	110	90	142	46.5	83.5		45.5	79.5	90	39	31	20
188/104/88	114	94	146	47	84		46	80	90.5	39	31	20.5
188/108/92	118	98	150	47.5	84.5		46.5	80.5	91	40	32	21
188/112/96	122	102	154	48	85		47	81	91.5	40	32	21.5
188/116/100	126	106	158	48.5	85.5		47.5	81.5	92	41	33	22
188/120/104	130	110	162	49	86	48	82	92.5	41	33	22.5	
194/96/80	106	86	138	47.5	85.5	17.5	46.5	81.5	92	38	30	19.5
194/100/84	110	90	142	48	86		47	82	92.5	39	31	20
194/104/88	114	94	146	48.5	86.5		47.5	82.5	93	39	31	20.5
194/108/92	118	98	150	49	87		48	83	93.5	40	32	21
194/112/96	122	102	154	49.5	87.5		48.5	83.5	94	40	32	21.5
194/116/100	126	106	158	50	88		49	84	94.5	41	33	22
194/120/104	130	110	162	50.5	88.5		49.5	84.5	95	41	33	22.5

4. **GARMENT SIZING continued**

Size Height/Chest/Waist	Jacket – Measurements of Regular size garment											
	Around Jacket		Back		Front from collar step to			Sleeve		Half width of back		
	Fastened and laid flat		At bottom edge including underlap	From collar seam to waist	Full length	Top buttonhole	Bottom buttonhole	Bottom of jacket	Length from centre of back to cuff		Width at	
	Chest	Waist								Elbow ½ way between cuff and underarm	Cuff	
	Ax2	Bx2	Cx2	D	E	F	G	H	J	Kx2	Lx2	M
200/96/80	106	86	138	49	88		48	84	94.5	38	30	19.5
200/100/84	110	90	142	49.5	88.5		48.5	84.5	95	39	31	20
200/104/88	114	94	146	50	89		49	85	95.5	39	31	20.5
200/108/92	118	98	150	50.5	89.5	18	49.5	85.5	96	40	32	21
200/112/96	122	102	154	51	90		50	86	96.5	40	32	21.5
200/116/100	126	106	158	51.5	90.5		50.5	86.5	97	41	33	22
200/120/104	130	110	162	52	91		51	87	97.5	41	33	22.5
Tolerance +/-	1.5	1.5	1.5	1	1.5	0.5	0.5	1.5	1	1.5	1	1
Jacket – Measurements of Stout size garment												
170/96/88	106	94	146	41.5	75.5		40.5	71.5	82	38	30	19.5
170/100/92	110	98	150	42	76		41	72	82.5	39	31	20
170/104/96	114	102	154	42.5	76.5		41.5	72.5	83	39	31	20.5
170/108/100	118	106	158	43	77	15.5	42	73	83.5	40	32	21
170/112/104	122	110	162	43.5	77.5		42.5	73.5	84	40	32	21.5
170/116/108	126	114	166	44	78		43	74	84.5	41	33	22

4. **GARMENT SIZING continued**

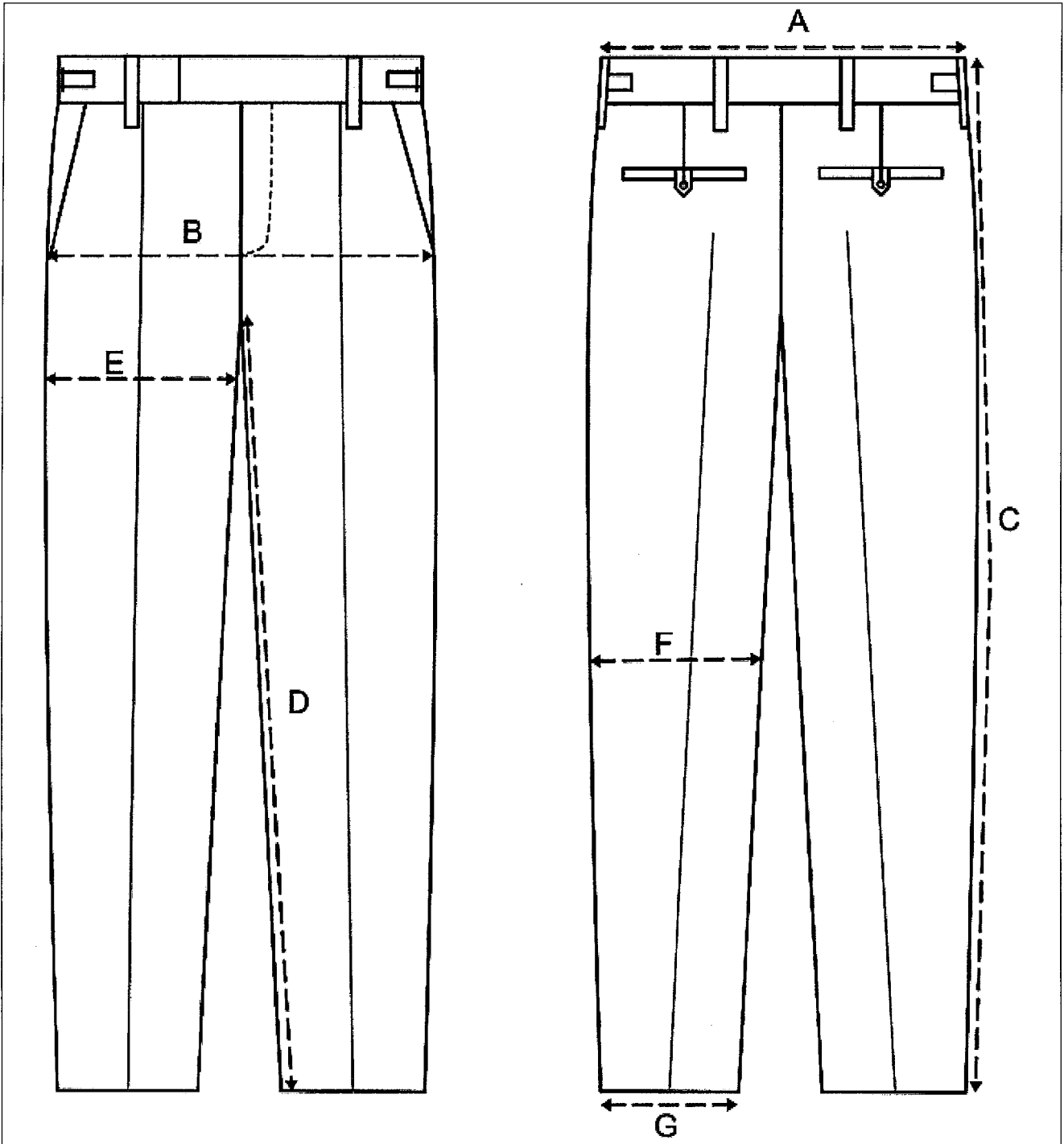
Size Height/Chest/Waist	Jacket – Measurements of Stout size garment											
	Around Jacket		Back		Front from collar step to			Sleeve			Half width of back	
	Fastened and laid flat		At bottom edge including underlap	From collar seam to waist	Full length	Top buttonhole	Bottom buttonhole	Bottom of jacket	Length from centre of back to cuff	Width at		
	Chest	Waist								Elbow ½ way between cuff and underarm	Cuff	
	Ax2	Bx2	Cx2	D	E	F	G	H	J	Kx2	Lx2	M
176/96/88	106	94	146	43	78	16	42	74	84.5	38	30	19.5
176/100/92	110	98	150	43.5	78.5		42.5	74.5	85	39	31	20
176/104/96	114	102	154	44	79		43	75	85.5	39	31	20.5
176/108/100	118	106	158	44.5	79.5		43.5	75.5	86	40	32	21
176/112/104	122	110	162	45	80		44	76	86.5	40	32	21.5
176/116/108	126	114	166	45.5	80.5		44.5	76.5	87	41	33	22
182/96/88	106	94	146	44.5	80.5	16.5	43.5	76.5	87	38	30	19.5
182/100/92	110	98	150	45	81		44	77	87.5	39	31	20
182/104/96	114	102	154	45.5	81.5		44.5	77.5	88	39	31	20.5
182/108/100	118	106	158	46	82		45	78	88.5	40	32	21
182/112/104	122	110	162	46.5	82.5		45.5	78.5	89	40	32	21.5
182/116/108	126	114	166	47	83		46	79	89.5	41	33	22
182/120/112	130	118	170	47.5	83.5		46.5	79.5	90	41	33	22.5

4. **GARMENT SIZING continued**

Size Height/Chest/Waist	Jacket – Measurements of Stout size garment											
	Around Jacket		Back		Front from collar step to			Sleeve			Half width of back	
	Fastened and laid flat		At bottom edge including underlap	From collar seam to waist	Full length	Top buttonhole	Bottom buttonhole	Bottom of jacket	Length from centre of back to cuff	Width at		
	Chest	Waist								Elbow ½ way between cuff and underarm	Cuff	
	Ax2	Bx2	Cx2	D	E	F	G	H	J	Kx2	Lx2	M
188/96/88	106	94	146	46	83		45	79	89.5	38	30	19.5
188/100/92	110	98	150	46.5	83.5		45.5	79.5	90	39	31	20
188/104/96	114	102	154	47	84		46	80	90.5	39	31	20.5
188/108/100	118	106	158	47.5	84.5	17	46.5	80.5	91	40	32	21
188/112/104	122	110	162	48	85		47	81	91.5	40	32	21.5
188/116/108	126	114	166	48.5	85.5		47.5	81.5	92	41	33	22
188/120/112	130	118	170	49	86		48	82	92.5	41	33	22.5
194/100/92	110	98	150	48	86		47	82	92.5	39	31	20
194/104/96	114	102	154	48.5	86.5		47.5	82.5	93	39	31	20.5
194/108/100	118	106	158	49	87	17.5	48	83	93.5	40	32	21
194/112/104	122	110	162	49.5	87.5		48.5	83.5	94	40	32	21.5
194/116/108	126	114	166	50	88		49	84	94.5	41	33	22
194/120/112	130	118	170	50.5	88.5		49.5	84.5	95	41	33	22.5
200/100/92	110	98	150	49.5	87.5		48.5	84.5	95	39	31	20
200/104/96	114	102	154	50	88		49	85	95.5	39	31	20.5
200/108/100	118	106	158	50.5	88.5	18	49.5	85.5	96	40	32	21
200/112/104	122	110	162	51	89		50	86	96.5	40	32	21.5
200/116/108	126	114	166	51.5	89.5		50.5	86.5	97	41	33	22
200/120/112	130	118	170	52	90		51	87	97.5	41	33	22.5
Tolerance +/-	1.5	1.5	1.5	1	1	0.5	0.5	1.5	1	1.5	1	1

#### 4. GARMENT SIZING continued

All measurements in centimetres.



Outsize garments are to be made for the person whose measurements are supplied on the Outsize Form. The size chart is to be used as a guide for the allowance over the measurements supplied and measurements not shown on the form.

4. **GARMENT SIZING** continued

Size Leg/Waist/Seat	Trousers – Measurements of Regular size garments						
	Length of				Around		
	Waist	Seat at base of fly	Side seam finished	Leg seam finished	Thigh 5cm below fork	Knee ½ between + 5cm upwards	Bottom
	Ax2	Bx2	C	D	Ex2	Fx2	Gx2
72/68/84	68	97	101	72	61	51	46
72/72/88	72	101			63	51	46
72/76/92	76	105			65	52	46
72/80/96	80	109			67	53	46
72/84/100	84	113			69	53	46
72/88/104	88	117			71	54	47
72/92/108	92	121			73	54	47
76/72/88	72	101	106	76	63	51	46
76/76/92	76	105			65	52	46
76/80/96	80	109			67	53	46
76/84/100	84	113			69	53	46
76/88/104	88	117			71	54	47
76/92/108	92	121			73	54	47
76/96/112	96	125			75	55	47
76/100/116	100	129			77	55	47
76/104/120	104	133			79	56	48
76/108/124	108	137			81	57	48
80/72/88	72	101	110	80	63	51	46
80/76/92	76	105			65	52	46
80/80/96	80	109			67	53	46
80/84/100	84	113			69	53	46
80/88/104	88	117			71	54	47
80/92/108	92	121			73	54	47
80/96/112	96	125			75	55	47
80/100/116	100	129			77	55	47
80/104/120	104	133			79	56	48
80/108/124	108	137			81	57	48

**4. GARMENT SIZING continued**

Size Leg/Waist/Seat	Trousers – Measurements of Regular size garments						
	Length of				Around		
	Waist	Seat at base of fly	Side seam finished	Leg seam finished	Thigh 5cm below fork	Knee ½ between + 5cm upwards	Bottom
	<b>Ax2</b>	<b>Bx2</b>	<b>C</b>	<b>D</b>	<b>Ex2</b>	<b>Fx2</b>	<b>Gx2</b>
84/76/92	76	105	116	84	65	52	46
84/80/96	80	109			67	53	46
84/84/100	84	113			69	53	46
84/88/104	88	117			71	54	47
84/92/108	92	121			73	54	47
84/96/112	96	125			75	55	47
84/100/116	100	129			77	55	47
84/104/120	104	133			79	56	48
84/108/124	108	137			81	57	48
84/112/128	112	141			81	57	48
88/76/92	76	105	121	88	65	52	46
88/80/96	80	109			67	53	46
88/84/100	84	113			69	53	47
88/88/104	88	117			71	54	47
88/92/108	92	121			73	54	47
88/96/112	96	125			75	55	47
88/100/116	100	129			77	55	47
88/104/120	104	133			79	56	48
88/108/124	108	137			81	57	48
88/112/128	112	141			81	57	48
92/80/96	80	109	126	92	67	53	46
92/84/100	84	113			69	53	47
92/88/104	88	117			71	54	47
92/92/108	92	121			73	54	47
92/96/112	96	125			75	55	47
92/100/116	100	129			77	55	47
92/104/120	104	133			79	56	47
92/108/124	108	137			81	57	48
92/112/128	116	141			81	58	48

4. **GARMENT SIZING** continued

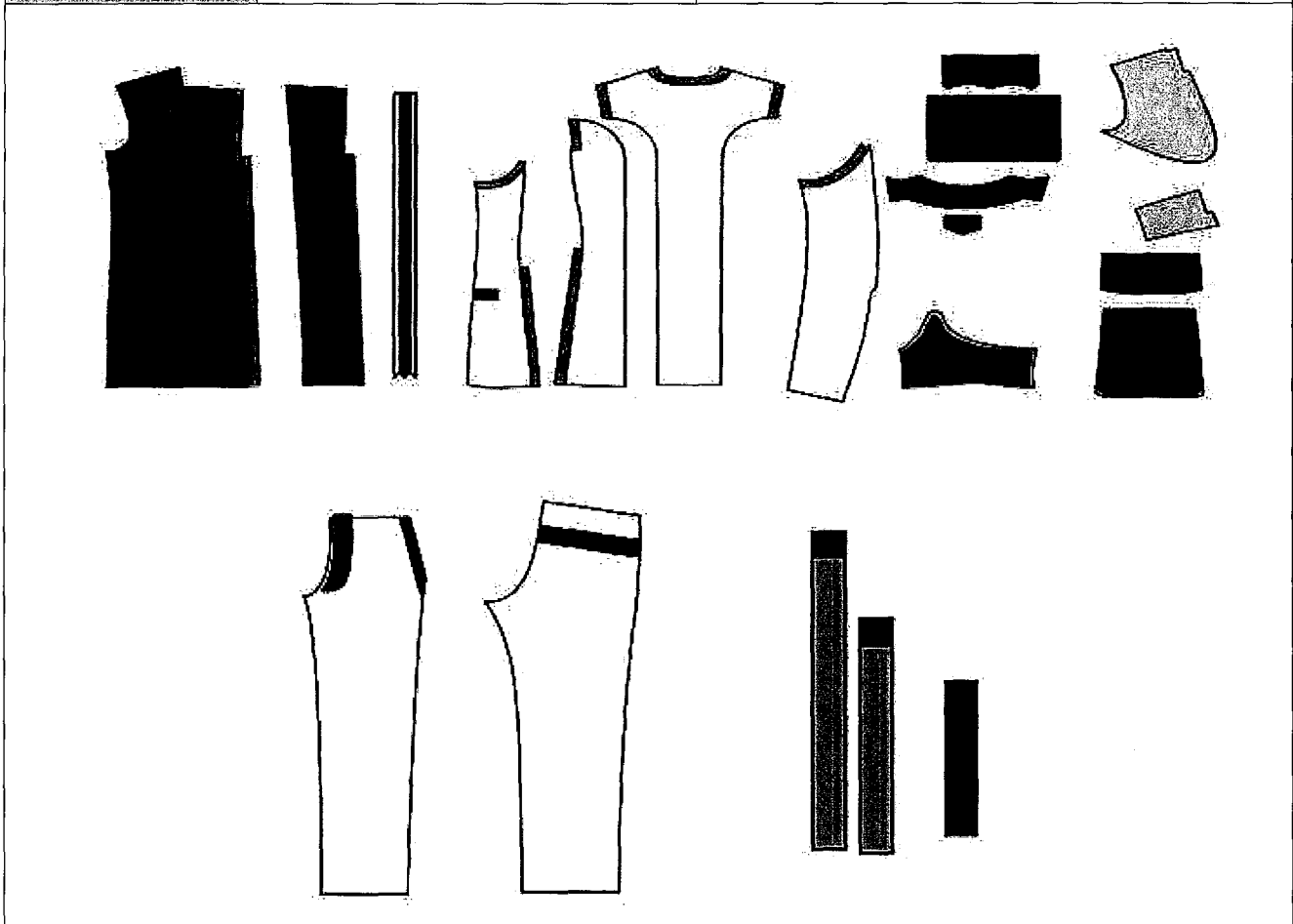
Size Leg/Waist/Seat	Trousers – Measurements of Regular size garments						
	Length of				Around		
	Waist	Seat at base of fly	Side seam finished	Leg seam finished	Thigh 5cm below fork	Knee ½ between + 5cm upwards	Bottom
	<b>Ax2</b>	<b>Bx2</b>	<b>C</b>	<b>D</b>	<b>Ex2</b>	<b>Fx2</b>	<b>Gx2</b>
96/80/96	80	109	131	96	67	53	46
96/84/100	84	113			69	53	47
96/88/104	88	117			71	54	47
96/92/108	92	121			73	54	47
96/96/112	96	125			75	55	47
96/100/116	100	129			77	55	47
96/104/120	104	133			79	56	47
96/108/124	108	137			81	57	48
96/112/128	116	141			81	58	48
Tolerance	+2 -0	+2 -0	+1 -0	+1 -1	+1 -0	+1 -0	+1 -0



## 5. CONSTRUCTION

### FUSING DIAGRAM

COLOUR	PRODUCT	DESCRIPTION
	20mm woven tape	Front edge, back neck, armhole & vents
	Non-woven	Pocket flaps, pocket bags front facing, top collar and cuffs, fly, hook & bar
	Woven, knitted or non-woven	Forepart
	Plain weave cotton	Waistband
	30mm woven tape	Bridle button/buttonhole, side pocket, hip pocket stay and pocket jettings
	Canvas	Chest and shoulder



The fusible interlining must be suitable for use with the garment fabric and fused in accordance with the manufacturers recommendations.

The resulting laminate shall be free from blisters and there shall not be strike through of adhesive on either the face or back.

The garment must be able to be laundered throughout its life in accordance with the care label, without any visible signs of delamination, puckering, loss of appearance and handle or excessive shrinkage.

## 5. CONSTRUCTION continued

QUALITY
<ul style="list-style-type: none"><li>• The garments are to be made to a high quality standard using sound tailoring production techniques to give a neat, smooth superior finish.</li><li>• Uniformity in appearance is essential. There should not be any noticeable variation between production garments and the Standard Pattern.</li><li>• It is essential that:<ul style="list-style-type: none"><li>• Body and sleeve linings are not tight.</li><li>• Garment parts are correctly aligned and the run of seams is regular and neatly under and top pressed.</li><li>• Front edges are thinly constructed, well pressed, regular in shape and free from distortion and that collar does not gape when fastened.</li><li>• Paired features (e.g. left and right collar end, cuffs, pockets etc.) must be balanced and should not be at the extremes of the tolerance, ensuring symmetry.</li><li>• Sleeves are correctly pitched, the sleeve-head fullness is correctly distributed, and the run is regular and well pressed.</li><li>• Shoulder seams are not distorted and wadding is securely and correctly inserted.</li><li>• When issued as a uniform each jacket and trouser are to be matched so there is no visible shade difference</li></ul></li></ul>

DESIGN - JACKET
<ul style="list-style-type: none"><li>• Single breasted to button four</li><li>• Step collar</li><li>• Side body</li><li>• Waist dart</li><li>• Pleated breast pocket with 3 pointed flap with buttonhole</li><li>• Patch hip pocket with straight flap</li><li>• 2 inside breast pockets</li><li>• 1 inside ticket pocket</li><li>• Patrol back and vents</li><li>• Two-piece set-in sleeve with rifle cuff</li><li>• Shoulder straps</li><li>• Fully lined</li><li>• Belt</li><li>• Retractable waist hook at side seam</li></ul>

**5. CONSTRUCTION continued****DESIGN - TROUSERS**

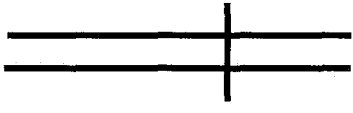

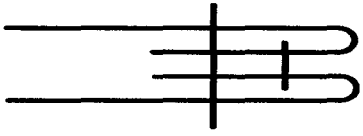

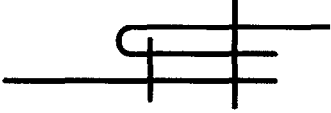

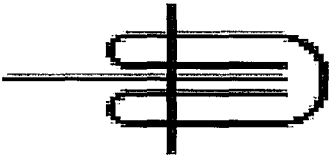
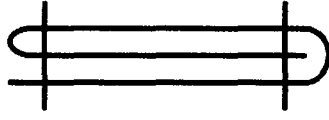
- Fly front with slide fastener closure
- Extended waistband
- Slanted side pockets
- Uncut dart in underside
- Pleat in topside
- Permanent crease treatment in front crease
- Two hip pockets
- Straps and Chapes
- Six belt loops
- Bottoms to be finished hemmed

**SEAMS AND STITCHING to BS 3870**

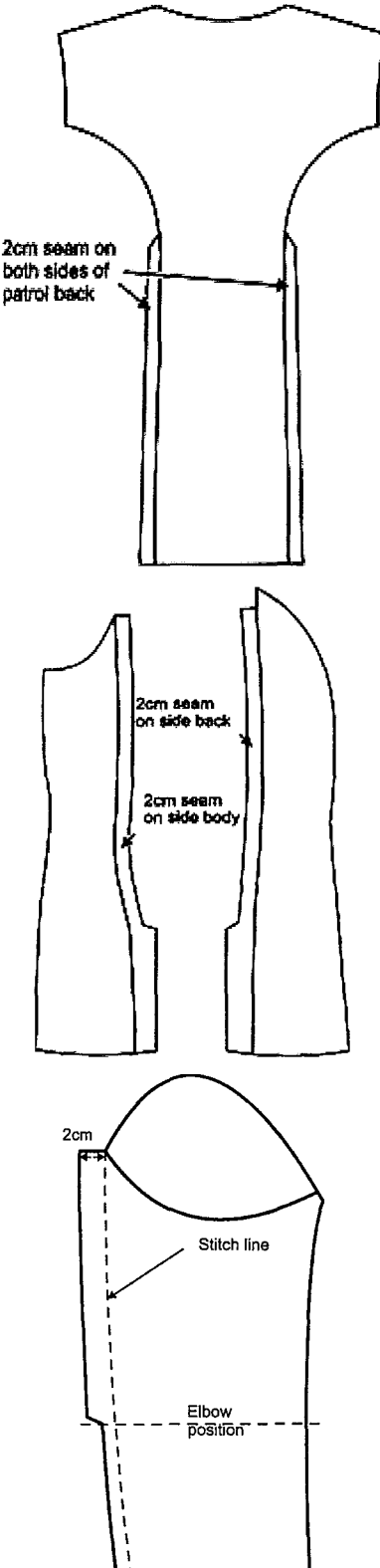
- Seam type 1.01.01 unless otherwise stated
- Jacket and trouser up-turn, stitch type 103 with 4-7 stitches per 2cm
- Trouser seat, leg and side seams are to be sewn using stitch type 301 or 401
- Two rows required on the seat seam with stitch type 301
- All other seam and top stitching 301
- 8-10 stitches per 2cm for all operations
- All rows edges stitch type 502, 503, 504, 505
- Button holes to be cut before worked type
- 22 stitches per 2cm to be bar tacked
- Button securely sewn with 16 stitches through each hole
- Trouser are to be pressed with front and back crease positioned correctly

5. **CONSTRUCTION continued**

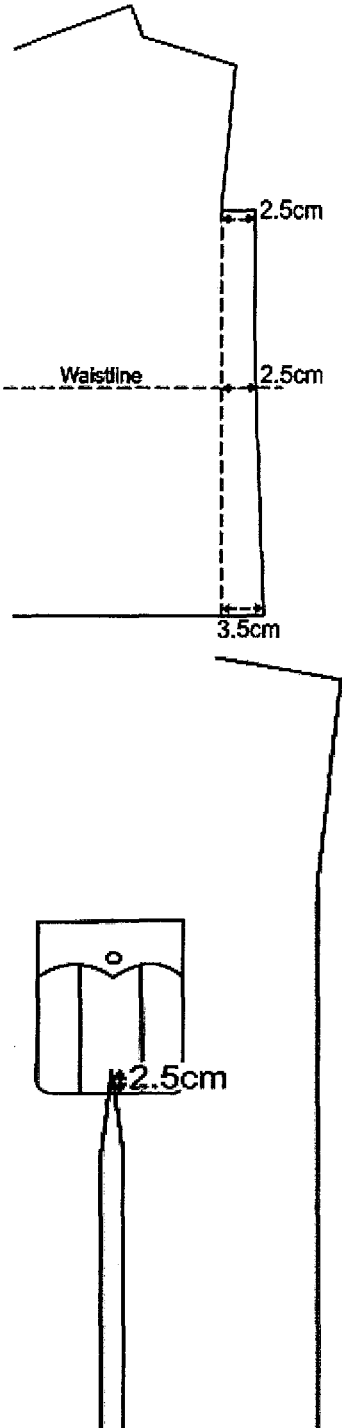
The following seam types are referenced in this specification:

	1.01.01		3.14.01
	1.06.02		5.31.01
	2.02.03		6.02.01
	3.05.03		8.03.07

5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.1 INLAYS</p>  <p>2cm seam on both sides of patrol back</p> <p>2cm seam on side back</p> <p>2cm seam on side body</p> <p>2cm</p> <p>Stitch line</p> <p>Elbow position</p>	<ul style="list-style-type: none"> <li>• Patrol back, 2cm seam from chest point to bottom of panel</li> <li>• Corresponding inlays are to be allowed on linings</li> </ul> <ul style="list-style-type: none"> <li>• 2cm seam on back and side body seams</li> <li>• Corresponding inlays are to be allowed on linings</li> </ul> <ul style="list-style-type: none"> <li>• 2cm seam on hindarm from armhole to elbow point</li> <li>• Corresponding inlays are to be allowed on linings</li> </ul>	

5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.2 FRONT</p> 	<p><u>Right front as worn</u></p> <ul style="list-style-type: none"> <li>• Button stand extension 2.5cm wide at top of front edge to waist line</li> <li>• Widening to 3.5cm at bottom edge</li> </ul> <ul style="list-style-type: none"> <li>• Cut through dart in each front</li> <li>• To finish above the bottom of the breast pocket, through to the bottom of the jacket</li> <li>• To be cut and pressed open</li> <li>• The fronts to have a fusible interlining</li> <li>• Cut full width at the shoulder, level at base of armhole</li> <li>• Shoulders have an additional reinforcement of cotton and hair canvas</li> <li>• Reinforcement to be sewn in with the bridle and sleevehead stitching</li> <li>• Front edges, base of armhole, buttons and buttonholes to be stayed with fusible tape</li> <li>• A bridle at breakline is to be fused to the front interlining secured by 3 rows of padding stitches</li> <li>• Front edge seams to be pressed open before edge basting</li> </ul>	

5. CONSTRUCTION continued

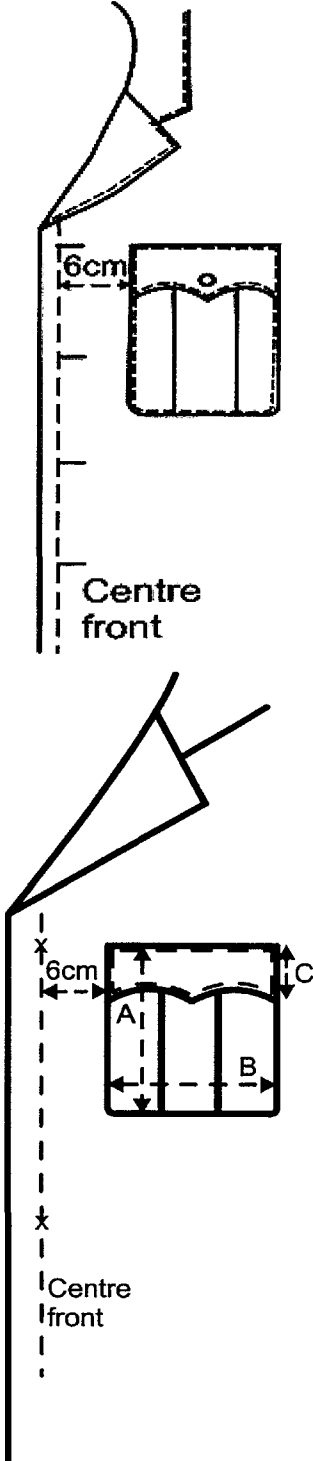
PART	DETAIL	SEAM REF
<p>5.2 FRONT continued</p>	<p><u>Left front as worn</u></p> <ul style="list-style-type: none"> <li>• Four buttonholes 2.5cm effective cut length</li> <li>• Position of top buttonhole, see size chart</li> <li>• The fourth hole positioned in line with the top of the hip pocket flap</li> <li>• The remaining holes positioned equidistantly between</li> <li>• The eyes 1.6cm from the front edges</li> </ul> <p><u>Right front as worn</u></p> <ul style="list-style-type: none"> <li>• Front edges to be edge stitched</li> <li>• Lapel step 3.5cm</li> <li>• The position of the four insignia buttons marked with white thread</li> <li>• Positioned 4cm from the front edge</li> </ul>	<p>1.06.02</p>

5. CONSTRUCTION continued

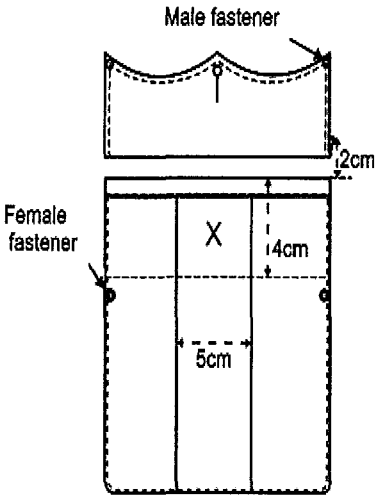
PART	DETAIL	SEAM REF
<p>5.3 WAIST HOOK</p> <p>0.5cm</p> <p>2cm</p> <p>11cm</p> <p>5cm</p> <p>Side seam</p> <p>5.5cm</p> <p>Lining side seam</p> <p>7cm</p>	<ul style="list-style-type: none"> <li>• A reinforced gap in stitching to accommodate the retractable waist hook</li> <li>• Gap of 0.5cm is to be allowed in each side seam</li> <li>• Positioned 2cm above the hip pocket flap</li> <li>• Machining either side of the gap to be securely back tacked</li> <li>• A two ply woven strip of linen is to be placed over the hook to form a pocket</li> <li>• The hook is to be stitched through the two layers of the pocket at the hook edge</li> <li>• The pocket is then to be stitched around the outer edge after the hook insertion, prior to attachment to the side seam</li> <li>• The woven strip is to be attached to the side seams of the garment to correspond with the opening in the side seam of the jacket</li> <li>• Correctly tacked off 1cm above the top of the hook to prevent the hook from moving</li> <li>• An opening to be made in the side seam lining 7cm long</li> <li>• In alignment with the waist hook pocket</li> <li>• In the lining inlay</li> <li>• The opening is to be edge stitched</li> <li>• The inside is to be raw edge</li> </ul>	



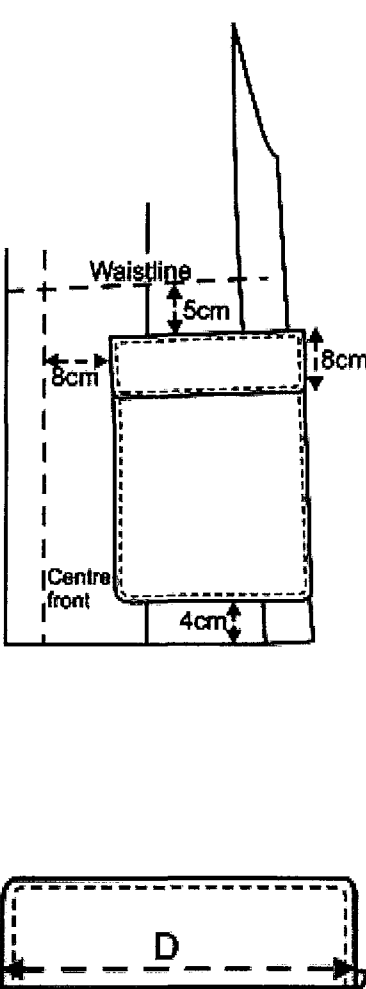
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF																																																				
<p>5.4 POCKET AND FLAPS</p> 	<ul style="list-style-type: none"> <li>• Pocket flaps and patches are to be fused and sewn, using sewing jigs, on to each front</li> <li>• Top stitching 0.6cm from the top edge</li> </ul> <p><u>Breast pocket and flap</u></p> <ul style="list-style-type: none"> <li>• Three pointed flap to have fusible interlining and lined</li> <li>• To be edge stitched</li> <li>• Top edge of flap positioned in line with top button/buttonhole</li> <li>• Front edge of pocket positioned parallel to centre front</li> <li>• Breast pocket position 6cm from centre front line (except for size 80, 5cm from centre front line)</li> <li>• Breast pocket dimensions (cm):</li> </ul> <table border="1" data-bbox="563 1137 1225 1883"> <thead> <tr> <th>Chest size</th> <th>Depth from top of flap A</th> <th>Width of pocket B</th> <th>Depth of flap at point C</th> </tr> </thead> <tbody> <tr><td>80</td><td>14</td><td>12</td><td>5</td></tr> <tr><td>84</td><td>14</td><td>12</td><td>5</td></tr> <tr><td>88</td><td>15</td><td>13</td><td>5.5</td></tr> <tr><td>92</td><td>15</td><td>13</td><td>5.5</td></tr> <tr><td>96</td><td>16</td><td>14</td><td>6</td></tr> <tr><td>100</td><td>16</td><td>14</td><td>6</td></tr> <tr><td>104</td><td>17</td><td>15</td><td>6</td></tr> <tr><td>108</td><td>17</td><td>15</td><td>6</td></tr> <tr><td>112</td><td>18</td><td>16</td><td>6.5</td></tr> <tr><td>116</td><td>18</td><td>16</td><td>6.5</td></tr> <tr><td>120</td><td>19</td><td>17</td><td>6.5</td></tr> <tr><td>124</td><td>19</td><td>17</td><td>6.5</td></tr> </tbody> </table>	Chest size	Depth from top of flap A	Width of pocket B	Depth of flap at point C	80	14	12	5	84	14	12	5	88	15	13	5.5	92	15	13	5.5	96	16	14	6	100	16	14	6	104	17	15	6	108	17	15	6	112	18	16	6.5	116	18	16	6.5	120	19	17	6.5	124	19	17	6.5	
Chest size	Depth from top of flap A	Width of pocket B	Depth of flap at point C																																																			
80	14	12	5																																																			
84	14	12	5																																																			
88	15	13	5.5																																																			
92	15	13	5.5																																																			
96	16	14	6																																																			
100	16	14	6																																																			
104	17	15	6																																																			
108	17	15	6																																																			
112	18	16	6.5																																																			
116	18	16	6.5																																																			
120	19	17	6.5																																																			
124	19	17	6.5																																																			

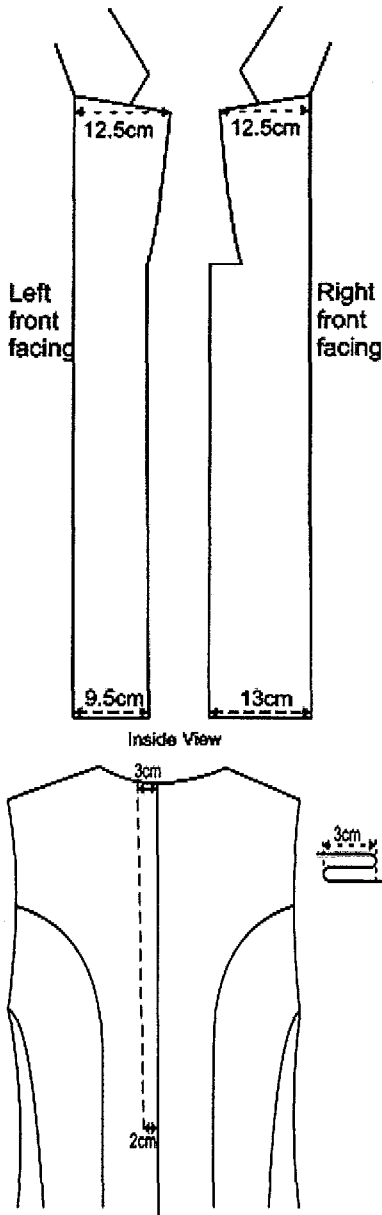
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.4 POCKET AND FLAPS continued</p> 	<ul style="list-style-type: none"> <li>• Buttonhole 2.2cm effective cut length</li> <li>• Positioned centrally in the flap</li> <li>• The eye 1.6cm from the point</li> <li>• Male portion of a snap fastener sewn to the underside of each point of flap</li> <li>• Patch has a sewn out centre pleat 5cm wide</li> <li>• Top edge is bound 0.6cm wide</li> <li>• Inner edge forms a 4cm stay for button</li> <li>• Patch edge stitched to the front</li> <li>• The top edge of patch positioned 2cm below top edge of the flap</li> <li>• Top corners to be securely tacked</li> <li>• Female portion of snap fastener to be securely sewn to each side of patch</li> <li>• In register with the male portions</li> <li>• Position of button to be correctly aligned and marked with white thread</li> <li>• In register with the buttonhole at the flap</li> </ul>	<p>3.14.01</p> <p>5.31.01</p>

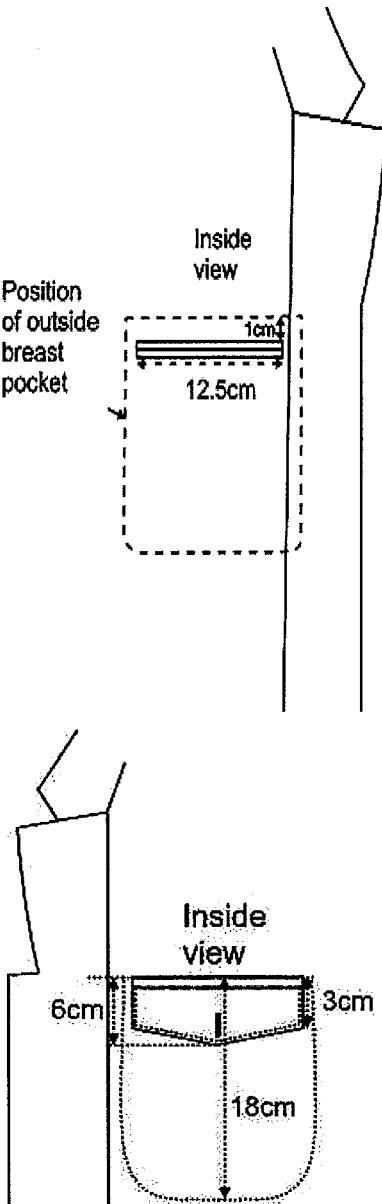
5. CONSTRUCTION continued

PART	DETAIL		SEAM REF										
<p>5.4 POCKET AND FLAPS continued</p> 	<p><u>Hip pocket and flap</u></p> <ul style="list-style-type: none"> <li>• Flap to be lined and have fusible interlining</li> <li>• Flap 8cm deep and to be edge stitched</li> <li>• Flap position 8cm from centre front</li> <li>• Top edge parallel with and 5cm below the waistline</li> <li>• The top of the flap to be stayed with fusible tape extending from the side seam</li> <li>• The top edge of the patch positioned 2.5cm below top edge of the flap and parallel with the centre front line</li> <li>• Top edge of patch to be bound 0.6cm wide with lining to extend 4cm into pocket</li> <li>• Top corners to be securely tacked</li> <li>• Patch is to be edge stitched into position</li> <li>• Bottom edge of pocket to finish 4cm from the bottom edge of jacket</li> <li>• Flap of pocket is to be parallel with the top pocket and the hem</li> <li>• Width of flap pocket:</li> </ul> <table border="1" data-bbox="555 1384 1228 1646"> <thead> <tr> <th>Chest size</th> <th>D (cm)</th> </tr> </thead> <tbody> <tr> <td>80 and 84</td> <td>18</td> </tr> <tr> <td>88 and 92</td> <td>19</td> </tr> <tr> <td>96 and 100</td> <td>20</td> </tr> <tr> <td>104 and 124</td> <td>21</td> </tr> </tbody> </table>		Chest size	D (cm)	80 and 84	18	88 and 92	19	96 and 100	20	104 and 124	21	
Chest size	D (cm)												
80 and 84	18												
88 and 92	19												
96 and 100	20												
104 and 124	21												

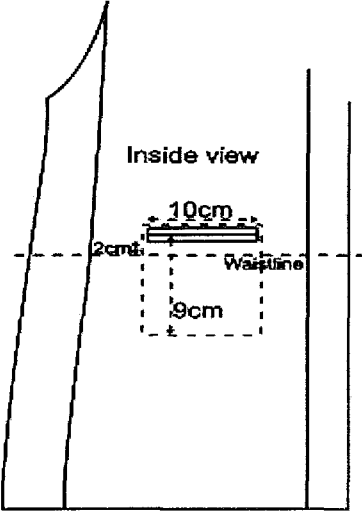
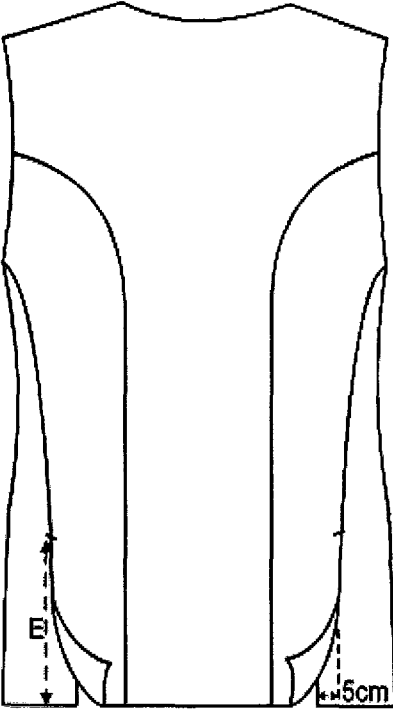
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.5 FRONT FACING AND BODY LINING</p> 	<ul style="list-style-type: none"> <li>• Facing to be interlined from the gorge to the top buttonhole</li> <li>• Cut to clear sewing line at the gorge and lapel</li> <li>• Right facing 12.5cm wide at the top</li> <li>• 13cm wide at the bottom</li> <li>• Left facing 12.5cm wide at the top</li> <li>• 9.5cm wide at the bottom</li>   <li>• Lining to be cut to correspond with the front side body and back</li> <li>• 1cm pleat formed at the hem</li> <li>• Lining to have a 3cm deep pleat in the centre back neck</li> <li>• Tapering to 2cm wide at the waist</li> </ul>	

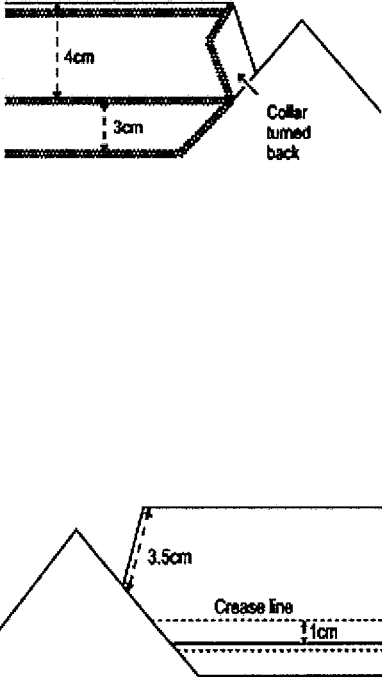
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.5 FRONT FACING AND BODY LINING continued</p> 	<p><u>Left side as worn</u></p> <ul style="list-style-type: none"> <li>• The facing/lining seam to be secured to the front interlining</li> <li>• Using fusible web</li> <li>• Jetted inside breast pocket in each front lining</li> <li>• Positioned 1cm below the top edge of the outside breast pocket</li> <li>• Pocket opening 12.5cm for all sizes</li> <li>• Effective pocket depth 18cm</li> <li>• Pocket ends to be securely tacked on outside of pockets</li> </ul> <p><u>Right side as worn</u></p> <ul style="list-style-type: none"> <li>• Pocket opening 12.5cm for all sizes</li> <li>• Single pointed flap of two thicknesses to have fusible interlining</li> <li>• To be edge stitched</li> <li>• 6cm deep at the point</li> <li>• 3cm at the sides</li> <li>• 1.7cm long buttonhole central in the flap</li> <li>• The eye 1.6cm from the point</li> <li>• Button sewn to the lining in register with the buttonhole</li> </ul>	

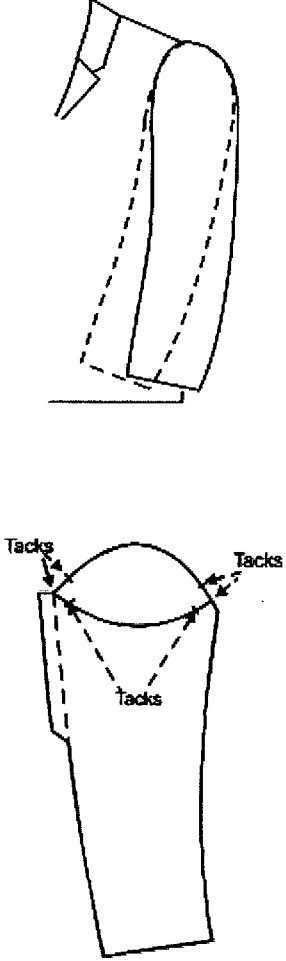
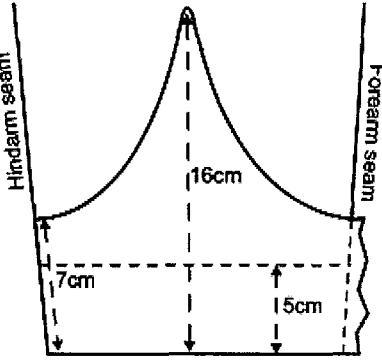
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF																
<p>5.5 FRONT FACING AND BODY LINING continued</p> 	<p><u>Ticket pocket left side as worn</u></p> <ul style="list-style-type: none"> <li>• Jetted inside ticket pocket</li> <li>• Positioned 2cm above the waistline and centrally in front lining</li> <li>• Pocket opening 10cm</li> <li>• Effective pocket depth 9cm</li> <li>• Pocket ends to be securely tacked</li> </ul>																	
<p>5.6 BACK</p> 	<ul style="list-style-type: none"> <li>• Cut with a patrol back</li> <li>• A vent worked in each side seam:</li> </ul> <table border="1" data-bbox="560 1173 1230 1599"> <thead> <tr> <th>Height</th> <th>E (cm)</th> </tr> </thead> <tbody> <tr> <td>164</td> <td>17.5</td> </tr> <tr> <td>170</td> <td>18.5</td> </tr> <tr> <td>176</td> <td>19.5</td> </tr> <tr> <td>182</td> <td>20.5</td> </tr> <tr> <td>188</td> <td>21.5</td> </tr> <tr> <td>194</td> <td>22.5</td> </tr> <tr> <td>200</td> <td>23.5</td> </tr> </tbody> </table> <ul style="list-style-type: none"> <li>• The tack is not to show on the outside of the garment</li> <li>• Top and underlap of vent to be stayed with fusible tape</li> <li>• Back armhole and neck to be stayed with fusible tape</li> </ul>	Height	E (cm)	164	17.5	170	18.5	176	19.5	182	20.5	188	21.5	194	22.5	200	23.5	
Height	E (cm)																	
164	17.5																	
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5. CONSTRUCTION continued

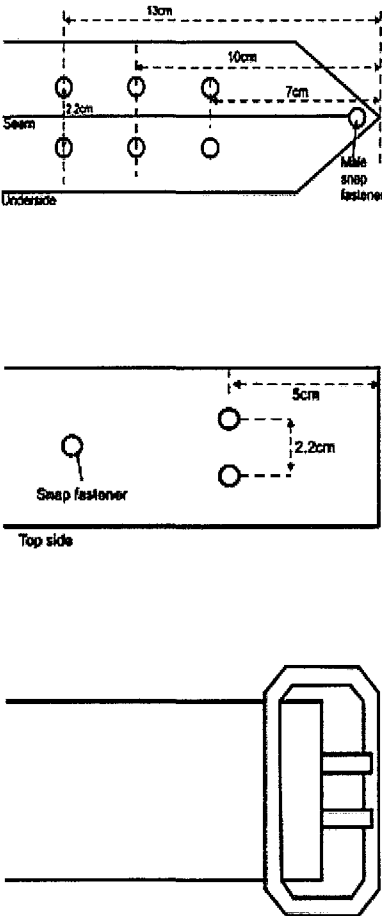
PART	DETAIL	SEAM REF
<p>5.7 COLLAR</p> 	<ul style="list-style-type: none"> <li>• The top and undercollar to be press cut with a square gorge</li> <li>• Undercollar felt to be cut with a separate stand and fall</li> <li>• Crease edge stayed with tape</li> <li>• 4cm fall, 3cm stand measured from the crease line</li> <li>• Top collar to be cut with a separate stand and fall</li> <li>• Fall of top collar is interlined with a fusible</li> <li>• Interlining cut clear of sewing lines and crease edge</li> <li>• Collar turned back at step</li> <li>• Stand seam to be 1cm below crease line</li> <li>• Width of collar at step 3.5cm</li> <li>• Top collar stand/fall seam to be pressed open</li> <li>• Row of stitching sewn through the collar at stand and fall seam</li> <li>• Collar and lapel seam to be in line with lapel step</li> <li>• Collar to be edge stitched</li> </ul>	

5. CONSTRUCTION continued

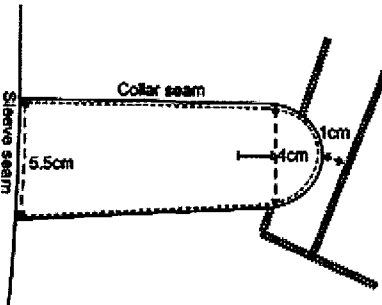
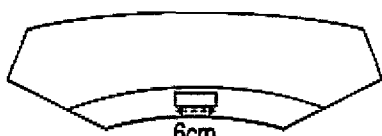
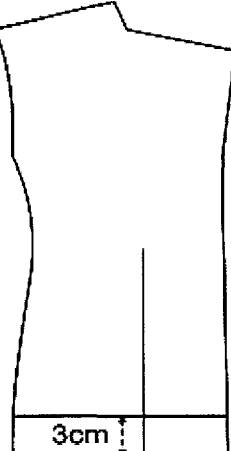
PART	DETAIL	SEAM REF
<p>5.8 SLEEVES</p> 	<ul style="list-style-type: none"> <li>• It is essential the sleeves are correctly pitched for the erect stature required for uniform clothing</li> <li>• Solid line showing correctly pitched</li> <li>• Dotted line incorrectly pitched</li> <li>• Sleevehead fullness is to be correctly distributed and fixed using a programmed CAM controlled machine</li> <li>• Shoulder pads secured to shoulder/chest reinforcement</li> <li>• Sleevehead wadding to extend from the forearm seam to the hindarm seam</li> <li>• Sleevehead lining to be machine sewn and securely tacked to the armhole at six points</li> <li>• At the forearm and hindarm seam</li> <li>• 4cm above and below forearm and hindarm seam</li> <li>• Alternatively the lining can be attached the underarm seam</li> <li>• The sleeve is to be cut to the correct length</li> </ul>	
<p>5.9 RIFLE CUFF</p> 	<ul style="list-style-type: none"> <li>• A rifle cuff is to be laid over the sleeve end and joined at the hindarm seam</li> <li>• To be edge stitched</li> <li>• Point of the rifle cuff to be in alignment with shoulder seam and edge stitched into place</li> <li>• 16cm deep at the centre of the forearm finished length</li> <li>• 7cm deep at the hindarm seam</li> <li>• Cuff upturn 5cm to have fusible interlining</li> </ul>	6.02.01



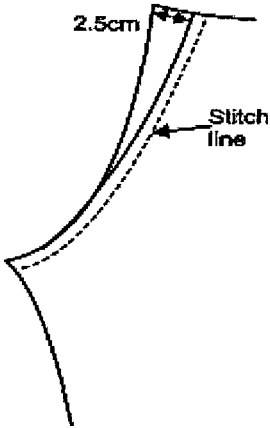
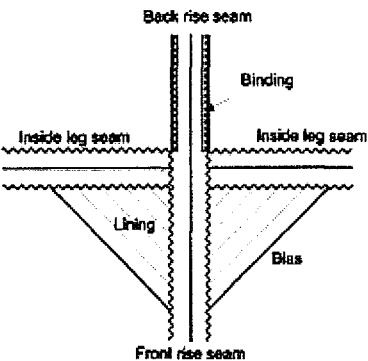
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF																												
<p>5.10 BELT</p> 	<ul style="list-style-type: none"> <li>Single ply main fabric folded and seamed to finish 5cm wide</li> <li>To be edge stitched</li> <li>Belt to have a fusible interlining</li> </ul> <p><u>Pointed end</u></p> <ul style="list-style-type: none"> <li>Three pairs of eyelet holes to be worked centrally from the pointed end</li> <li>Positioned 7cm, 10cm and 13cm</li> <li>Spaced 2.2cm apart</li> <li>Male portion of snap fastener sewn to underside at point</li> </ul> <p><u>Square end</u></p> <ul style="list-style-type: none"> <li>Pair of eyelets worked centrally 5cm from end</li> <li>Spaced 2.2cm apart</li> <li>Female portion of snap fastener sewn centrally on the outside</li> <li>In register with the male portion when the belt is fastened on the centre pair of eyelets</li> <li>A buckle is to be fitted with a 5cm turn back overlapped and securely stitched down</li> <li>Belt length from pointed end to buckle position to be 10cm over the waist measurement of the garment</li> <li>Length of belt from centre of buckle to the middle eyelet holes (cm):</li> </ul> <table border="1" data-bbox="555 1601 1225 1960"> <thead> <tr> <th>Waist</th> <th>Length</th> <th>Waist</th> <th>Length</th> </tr> </thead> <tbody> <tr> <td>68</td> <td>74</td> <td>92</td> <td>98</td> </tr> <tr> <td>72</td> <td>78</td> <td>96</td> <td>102</td> </tr> <tr> <td>76</td> <td>82</td> <td>100</td> <td>106</td> </tr> <tr> <td>80</td> <td>86</td> <td>104</td> <td>110</td> </tr> <tr> <td>84</td> <td>90</td> <td>108</td> <td>114</td> </tr> <tr> <td>88</td> <td>94</td> <td>112</td> <td>118</td> </tr> </tbody> </table>	Waist	Length	Waist	Length	68	74	92	98	72	78	96	102	76	82	100	106	80	86	104	110	84	90	108	114	88	94	112	118	
Waist	Length	Waist	Length																											
68	74	92	98																											
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76	82	100	106																											
80	86	104	110																											
84	90	108	114																											
88	94	112	118																											

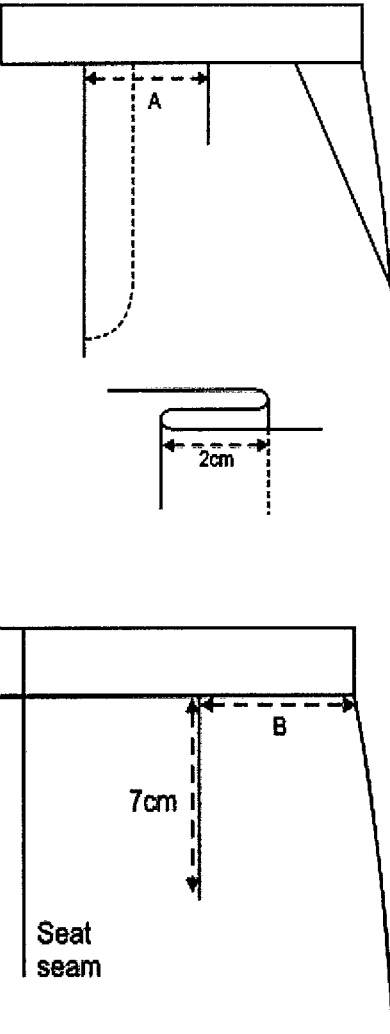
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.11 SHOULDER STRAPS</p> 	<ul style="list-style-type: none"> <li>• Two ply main fabric with rounded end</li> <li>• Top ply to have fusible interlining</li> <li>• Strap width 5.5cm at the sleeve seam</li> <li>• 4cm wide at buttonhole</li> <li>• Strap to be edge stitched</li> <li>• Buttonhole 2.2cm effective cut length</li> <li>• Positioned centrally</li> <li>• The eye 4cm from the rounded free end</li> <li>• Button position on shoulder marked with white thread</li> <li>• In register with the buttonhole</li> <li>• Strap sewn in the sleeve seam</li> <li>• Positioned centrally over the shoulder seam</li> <li>• End of strap to finish 1cm from collar/stand seam</li> </ul>	
<p>5.12 HANGER</p> 	<ul style="list-style-type: none"> <li>• Sewn at centre back neck centrally above the back lining through the top and undercollar</li> <li>• Effective length 6cm</li> </ul>	
<p>5.13 JACKET UP-TURN</p> 	<ul style="list-style-type: none"> <li>• 3cm up-turn</li> <li>• Hem to be attached without any visible sign showing on right side of garment</li> </ul>	6.02.01

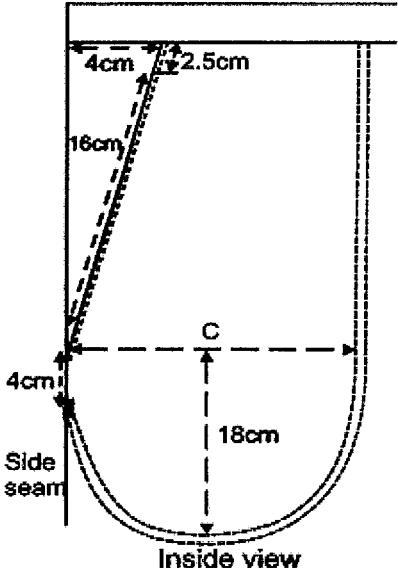
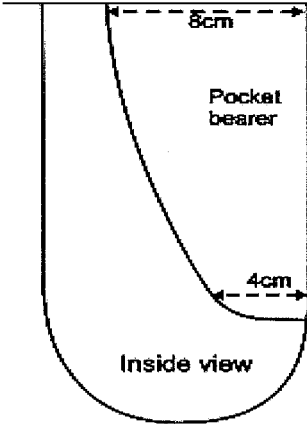
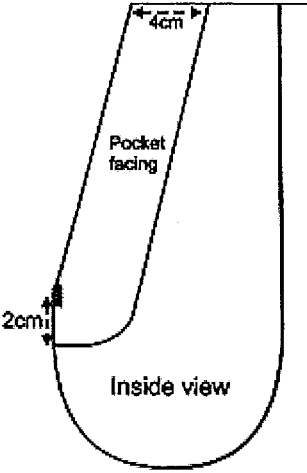
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.14 INLAYS</p>  <p>The diagram shows a close-up of a crotch inlay. A dashed line indicates the 'Stitch line'. A solid line shows the inlay's edge, which is labeled '2.5cm' at the top. The inlay is shown as a curved piece that fits into the crotch area of a pair of pants.</p>	<ul style="list-style-type: none"> <li>• 2.5cm wide at seam seam to nothing approximately 5cm from the fork</li> <li>• Corresponding inlay on waistband interlining and lining</li> </ul>	
<p>5.15 FORK STAY</p>  <p>The diagram shows a cross-section of the fork stay area. It includes labels for 'Back rise seam' at the top, 'Binding' on the right side, 'Inside leg seam' on both sides, 'Lining' in the center, 'Bias' on the left side, and 'Front rise seam' at the bottom. The fork stay is shown as a vertical strip of fabric that is folded and sewn into the crotch area.</p>	<ul style="list-style-type: none"> <li>• Fork stay of folded lining sewn in with leg and fork seams</li> <li>• Folded edge on bias</li> </ul>	

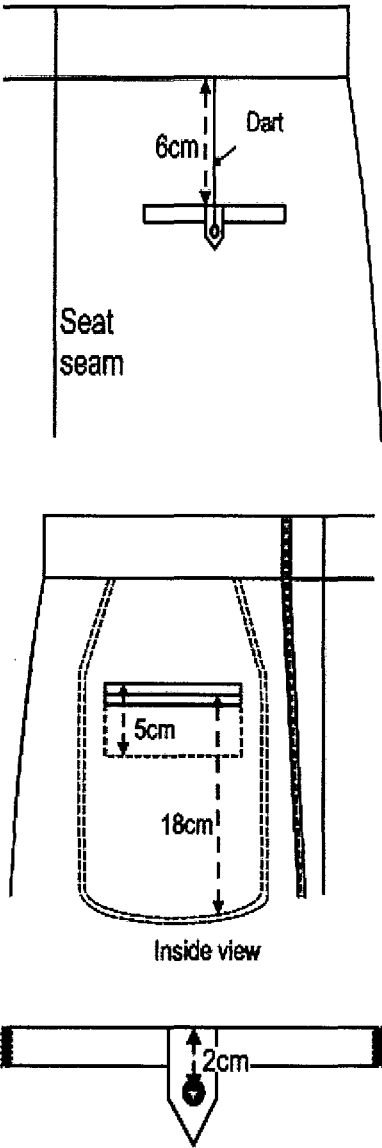
5. **CONSTRUCTION continued**

PART	DETAIL			SEAM REF
<p>5.16 PLEATS AND DARTS</p> 	<ul style="list-style-type: none"> <li>• 2cm deep pleat</li> <li>• The pleat forms the start of the permanent crease extending to the bottom hem</li> <li>• Pleats are to be permanently creased, a bead of resin is to be positioned correctly into the fold of the pleat</li> <li>• 1cm uncut dart on the back waist</li> <li>• Length 7cm</li> <li>• Pleat position from front edge A and Dart position from side seam B:</li> </ul>			
	Waist size	A (cm)	B (cm)	
	68	5.5	9	
	72	6	9	
	76	6.5	9	
	80	7	9	
	84	7.5	9.5	
	88	8	10	
	92	8.5	10	
	96	9	10.5	
	100	9.5	11	
	104	10	11.5	
	108	10.5	12	
	112	11	12.5	

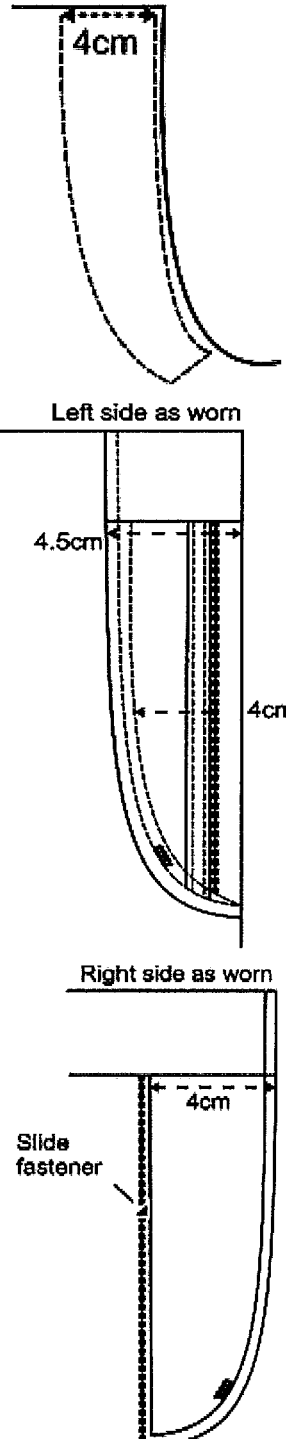
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF										
<p>5.17 SIDE POCKETS</p> 	<ul style="list-style-type: none"> <li>• 4cm from side seam</li> <li>• 16cm opening stayed with fusible tape</li> <li>• Tacked at each end</li> <li>• Top tack 2.5cm below waistband seam</li> <li>• Opening is 0.6cm topstitched</li> <li>• Pocket edges to be bound</li> <li>• With the top bag sewn into the waistband</li> <li>• The bag is tacked to the side seam 4cm below the bottom opening tack</li> <li>• Or the pocket bag can be created on the fold of the fabric</li> <li>• Pocket bag width:</li> </ul>	<p>1.06.02 3.05.03</p>										
	<table border="1"> <thead> <tr> <th data-bbox="555 1014 890 1066">Waist size</th> <th data-bbox="890 1014 1230 1066">C (cm)</th> </tr> </thead> <tbody> <tr> <td data-bbox="555 1066 890 1120">68</td> <td data-bbox="890 1066 1230 1120">17</td> </tr> <tr> <td data-bbox="555 1120 890 1173">72</td> <td data-bbox="890 1120 1230 1173">18.5</td> </tr> <tr> <td data-bbox="555 1173 890 1227">76</td> <td data-bbox="890 1173 1230 1227">19.5</td> </tr> <tr> <td data-bbox="555 1227 890 1279">80 and above</td> <td data-bbox="890 1227 1230 1279">20.5</td> </tr> </tbody> </table>	Waist size	C (cm)	68	17	72	18.5	76	19.5	80 and above	20.5	
Waist size	C (cm)											
68	17											
72	18.5											
76	19.5											
80 and above	20.5											
	<ul style="list-style-type: none"> <li>• Pocket bearer is 8cm wide at the top tack</li> <li>• 4cm wide at the bottom tack</li> <li>• Bearer sewn in with the waistband seam</li> <li>• Inner edges of bearer to be sewn or overedged and stitched down</li> </ul>	<p>5.31.01</p>										
	<ul style="list-style-type: none"> <li>• Pocket facing is 4cm wide at the waist seam tapering 2cm below the bottom tack</li> <li>• Facing sewn in waistband seam</li> <li>• Finishes 2cm below bottom tack</li> <li>• Inner edges of facing to be sewn</li> <li>• Or overedged and stitched down</li> </ul>	<p>5.31.01</p>										

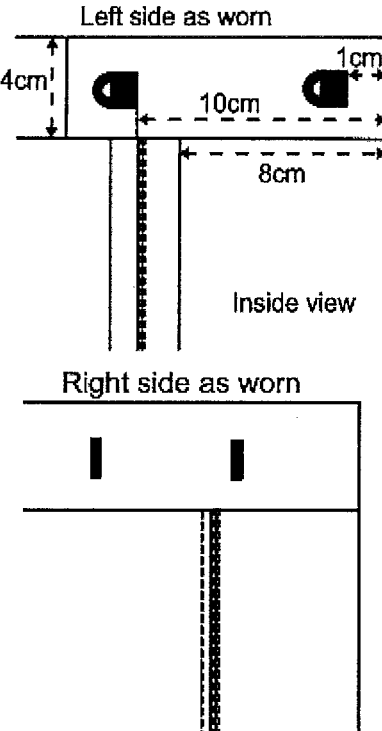
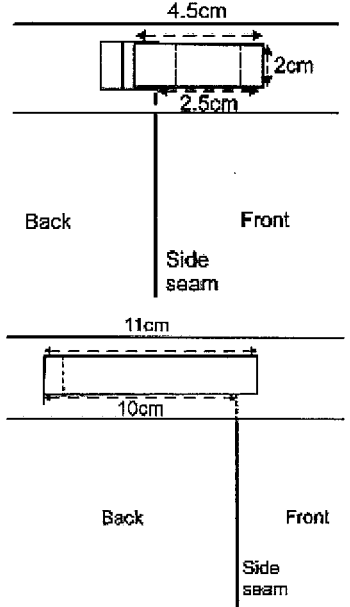
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.18 HIP POCKET</p>  <p>6cm</p> <p>Dart</p> <p>Seat seam</p> <p>5cm</p> <p>18cm</p> <p>Inside view</p> <p>2cm</p>	<ul style="list-style-type: none"> <li>• Fitted to both sides</li> <li>• Single or double jetted hip pocket</li> <li>• Positioned 6cm down and parallel to the waistband seam</li> <li>• Stayed with fusible tape extending from side seam to seat seam</li> <li>• Positioned centrally around the dart</li> <li>• Length of pocket opening 15cm for waist size 76cm and above, 14cm for waist size 72cm and below</li> <li>• Tacked at each end</li> <li>• Pocket bearer is 5cm deep</li> <li>• Inner edge of bearer to be sewn</li> <li>• Can be overedge stitched and sewn through the pocket bag</li> <li>• Pocket edges bound with the top sewn in the waist seam</li> <li>• Effective depth of pocket 18cm</li> <li>• Button sewn centrally 2cm below top edge of jetting</li> <li>• A loop sewn centrally in the top of the pocket opening</li> <li>• Effective length to fasten button</li> </ul>	<p>5.31.01</p> <p>3.05.03</p>

5. CONSTRUCTION continued

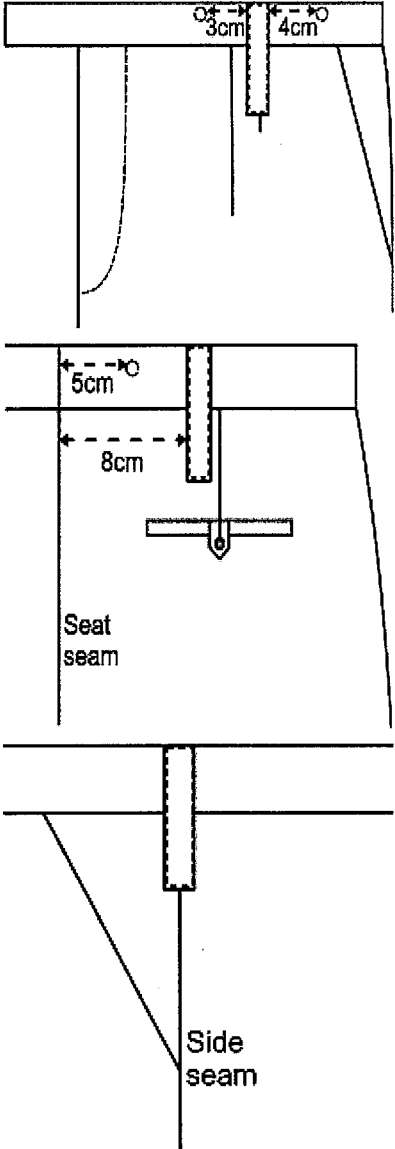
PART	DETAIL	SEAM REF
<p>5.19 FLY</p>  <p>The drawing consists of three parts:         <ul style="list-style-type: none"> <li><b>Top View:</b> Shows a curved fly piece with a width of 4cm at the top.</li> <li><b>Left side as worn:</b> Shows the fly facing (4.5cm wide) and stitching (4cm from the front edge) tapering at the base.</li> <li><b>Right side as worn:</b> Shows a lined slide fastener guard (4cm wide) and stitching (4cm from the front edge) tapering at the base.</li> </ul> </p>	<p><u>Left side as worn</u></p> <ul style="list-style-type: none"> <li>• Fusible interlining from waist line to fork, tack stitched in with the fly stitching</li> <li>• Cut to clear the front edge sewing line</li> </ul> <p><u>Left side as worn</u></p> <ul style="list-style-type: none"> <li>• Fly facing 4.5cm wide, tapering at the base and extending above the waist stitching</li> <li>• Slide fastener to be attached with two rows of stitching</li> <li>• Positioned with the bottom stop immediately above the fly tack position</li> <li>• Top of fastener sewn in waist seam</li> <li>• The fly stitching 4cm from the front edge tapering at the base</li> <li>• Stitching to be regular and unbroken with no distortion</li> </ul> <p><u>Right side as worn</u></p> <ul style="list-style-type: none"> <li>• A lined slide fastener guard 4cm wide tapering at the base</li> <li>• Fly guard and facing to be stitched together level with fly tack</li> </ul>	<p>2.02.03</p>

5. **CONSTRUCTION continued**

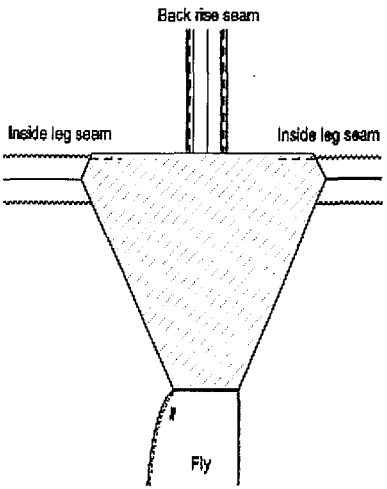
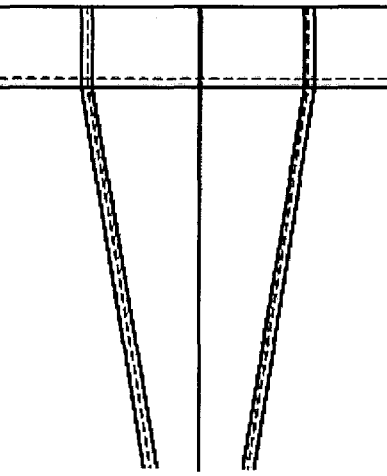
PART	DETAIL	SEAM REF
<p>5.20 WAISTBAND</p>  <p>Left side as worn</p> <p>Right side as worn</p> <p>Inside view</p>	<ul style="list-style-type: none"> <li>• Fusible interlining in top and underside of the extension</li> <li>• To reinforce the hooks</li> <li>• Waistband depth 4cm</li> <li>• Interlined with basic cotton and concave reinforcement, lined with nylon</li> <li>• The concave side of the reinforcement is sewn to the interlining</li> <li>• Left end extension is 8cm</li> <li>• Double hook fastening fitted centrally on the extension</li> <li>• Positioned 1cm and 10cm from the end</li> <li>• Two bars attached on the right side waist band in register with the hooks</li> </ul>	
<p>5.21 STRAPS AND CHAPES</p>  <p>Back Front Side seam</p> <p>Back Front Side seam</p>	<ul style="list-style-type: none"> <li>• Two plies main fabric</li> <li>• 2cm wide</li> <li>• Finished with a square end</li> <li>• Edge stitched</li> <li>• Folded chape 4.5cm long</li> <li>• Sewn centrally on the waistband</li> <li>• Positioned 2.5cm in front of the side seam</li> <li>• A buckle sewn in the folded free end</li> <li>• Immediately behind the buckle</li> <li>• Strap 11cm long</li> <li>• Sewn centrally on the waistband</li> <li>• Positioned 10cm behind the side seam</li> </ul>	<p>1.06.02</p> <p>5.31.05</p> <p>5.31.05</p>



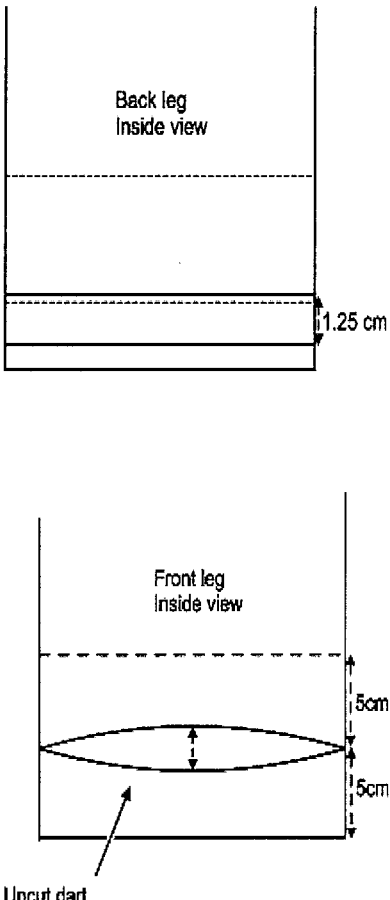
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.22 BELT LOOPS AND BRACE BUTTONS</p> 	<ul style="list-style-type: none"> <li>• Belt loops effective length 9cm and width 2cm</li> <li>• Front belt loop positioned centrally on the front panel</li> <li>• Brace buttons positioned on inside of waistband as on diagram</li> <li>• Back belt loop positioned 8cm from the centre back</li> <li>• Brace buttons positioned on inside of the waistband 5cm from the centre back</li> <li>• Side belt loop to be positioned over the side seam</li> </ul>	<p>8.03.07</p>

5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.23 CRUTCH LINING</p> 	<ul style="list-style-type: none"> <li>• Double ply triangular shape long enough to avoid distortion</li> <li>• Stitched to the bottom of the fly guard lining and tacked to the inside leg seams</li> </ul>	
<p>5.24 SEAT SEAM</p> 	<ul style="list-style-type: none"> <li>• Seat seam is bound and pressed open</li> <li>• Secured to the waistband lining with tacks each side</li> </ul>	<p>3.05.03</p>


5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.25 BOTTOMS</p> 	<ul style="list-style-type: none"> <li>• A length of nylon webbing 2.5cm wide</li> <li>• Folded down the centre to form a strip 1.25cm wide</li> <li>• Folded edge of webbing positioned 0.2cm from the bottom of the upturn</li> <li>• Sewn on the underside of each leg into the side seams</li> <li>• Top edge of the strip edge stitched through the upturn</li> <li>• Stitches not to show on the outside of the garment</li> <li>• The ends to be caught in with the seams</li> <li>• Care should be taken to ensure the extra thickness does not create a point liable to cause extra wear</li> <li>• 5cm upturn</li> <li>• An uncut dart is formed to hollow the bottom of the leg over the instep</li> <li>• Dart to be 1cm on the double at the crease and tapering to nothing at the side and leg seams</li> <li>• Dart is not to show on the outside when the bottoms are finished</li> </ul>	<p>6.02.01</p>

## 6. LABELLING REQUIREMENTS






Labels	Position
Identification and care labels (can be combined to produce one label)	Jacket: Attached inside the left inside breast pocket  Trousers: Attached to top of right pocket bag or folded and in the right waistband seam

### Identification Label

JACKET, MAN'S, No.2 Dress, Army, All Ranks 8405-99-9581164* Height/Chest/Waist* Contract No. Name: No: Date of Manufacture: MM/YYYY <i>(Fibre content to be added here)</i>	
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\*Amend as appropriate for end item

### Care Label

	DO NOT WASH
	DO NOT BLEACH
	DO NOT TUMBLE DRY
	DO NOT IRON
	Dry clean only

### Manufacturer Information

The contractor's name, logo or trademark should not appear on any labels, garment bags or packaging.

**7. TL NUMBER, NATO STOCK NUMBER AND SIZE**

TL Number	NATO Stock Number	Size
JACKET - REGULAR		
TL1034519	8405-99-958-1154	164/80/68
TL1034520	8405-99-958-1155	164/84/72
TL1034521	8405-99-958-1156	164/88/76
TL1034522	8405-99-958-1157	164/92/76
TL1034523	8405-99-958-1158	164/96/80
TL1034524	8405-99-958-1159	164/100/84
TL1034525	8405-99-958-1160	164/104/88
TL1034526	8405-99-958-1161	164/108/92
TL1034527	8405-99-958-1162	170/84/72
TL1034528	8405-99-958-1163	170/88/76
TL1034529	8405-99-958-1164	170/92/76
TL1034530	8405-99-958-1165	170/96/80
TL1034531	8405-99-958-1166	170/100/84
TL1034532	8405-99-958-1167	170/104/88
TL1034533	8405-99-958-1168	170/108/92
TL1034534	8405-99-958-1169	170/112/96
TL1034535	8405-99-958-1170	170/116/100
TL1033341	8405-99-501-1808	170/120/104
TL1034536	8405-99-958-1171	176/84/72
TL1034537	8405-99-958-1172	176/88/76
TL1034538	8405-99-958-1173	176/92/76
TL1034539	8405-99-958-1174	176/96/80
TL1034540	8405-99-958-1175	176/100/84
TL1034541	8405-99-958-1176	176/104/88
TL1034542	8405-99-958-1177	176/108/92
TL1034543	8405-99-958-1178	176/112/96
TL1034544	8405-99-958-1179	176/116/100
TL1033342	8405-99-501-1809	176/120/104
TL1033343	8405-99-501-1810	176/124/108

**7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued**

TL Number	NATO Stock Number	Size
JACKET - REGULAR		
TL1034545	8405-99-958-1180	182/88/76
TL1034546	8405-99-958-1181	182/92/76
TL1034547	8405-99-958-1182	182/96/80
TL1034548	8405-99-958-1183	182/100/84
TL1034549	8405-99-958-1184	182/104/88
TL1034550	8405-99-958-1185	182/108/92
TL1034551	8405-99-958-1186	182/112/96
TL1034552	8405-99-958-1187	182/116/100
TL1033344	8405-99-501-1811	182/120/104
TL1033345	8405-99-501-1812	182/124/108
TL1034553	8405-99-958-1188	188/92/76
TL1034554	8405-99-958-1189	188/96/80
TL1034555	8405-99-958-1190	188/100/84
TL1034556	8405-99-958-1191	188/104/88
TL1034557	8405-99-958-1192	188/108/92
TL1034558	8405-99-958-1193	188/112/96
TL1034559	8405-99-958-1194	188/116/100
TL1034560	8405-99-958-1195	188/120/104
TL1034561	8405-99-958-1196	194/96/80
TL1034562	8405-99-958-1197	194/100/84
TL1034563	8405-99-958-1198	194/104/88
TL1034564	8405-99-958-1199	194/108/92
TL1034565	8405-99-958-1200	194/112/96
TL1034566	8405-99-958-1201	194/116/100
TL1034567	8405-99-958-1202	194/120/104

7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued

TL Number	NATO Stock Number	Size
JACKET - REGULAR		
TL1034568	8405-99-958-1203	200/96/80
TL1034569	8405-99-958-1204	200/100/84
TL1034570	8405-99-958-1205	200/104/88
TL1034571	8405-99-958-1206	200/108/92
TL1034572	8405-99-958-1207	200/112/96
TL1034573	8405-99-958-1208	200/116/100
TL1034574	8405-99-958-1209	200/120/104
JACKET - STOUT		
TL1034575	8405-99-958-1210	170/96/88
TL1034576	8405-99-958-1211	170/100/92
TL1034577	8405-99-958-1212	170/104/96
TL1034578	8405-99-958-1213	170/108/100
TL1034579	8405-99-958-1214	170/112/104
TL1034580	8405-99-958-1215	170/116/108
TL1034581	8405-99-958-1216	176/96/88
TL1034582	8405-99-958-1217	176/100/92
TL1034583	8405-99-958-1218	176/104/96
TL1034584	8405-99-958-1219	176/108/100
TL1034585	8405-99-958-1220	176/112/104
TL1034586	8405-99-958-1221	176/116/108
TL1034587	8405-99-958-1222	182/96/88
TL1034588	8405-99-958-1223	182/100/92
TL1034589	8405-99-958-1224	182/104/96
TL1034590	8405-99-958-1225	182/108/100
TL1034591	8405-99-958-1226	182/112/104
TL1034592	8405-99-958-1227	182/116/108
TL1034593	8405-99-958-1228	182/120/112

**7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued**

TL Number	NATO Stock Number	Size
JACKET - STOUT		
TL1034594	8405-99-958-1229	188/96/88
TL1034595	8405-99-958-1230	188/100/92
TL1034596	8405-99-958-1231	188/104/96
TL1034597	8405-99-958-1232	188/108/100
TL1034598	8405-99-958-1233	188/112/104
TL1034599	8405-99-958-1234	188/116/108
TL1034600	8405-99-958-1235	188/120/112
TL1034601	8405-99-958-1236	194/100/92
TL1034602	8405-99-958-1237	194/104/96
TL1034603	8405-99-958-1238	194/108/100
TL1034604	8405-99-958-1239	194/112/104
TL1034605	8405-99-958-1240	194/116/108
TL1034606	8405-99-958-1241	194/120/112
TL1034607	8405-99-958-1242	200/100/92
TL1034608	8405-99-958-1243	200/104/96
TL1034609	8405-99-958-1244	200/108/100
TL1034610	8405-99-958-1245	200/112/104
TL1034611	8405-99-958-1246	200/116/108
TL1034612	8405-99-958-1247	200/120/112
TL1034613	8405-99-958-1248	Outsize
TROUSERS		
TL1034614	8405-99-958-1249	72/68/84
TL1034615	8405-99-958-1250	72/72/88
TL1034616	8405-99-958-1251	72/76/92
TL1034617	8405-99-958-1252	72/80/96
TL1034618	8405-99-958-1253	72/84/100
TL1034619	8405-99-958-1254	72/88/104
TL1032880	8405-99-301-7070	72/92/108



7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued

TL Number	NATO Stock Number	Size
TROUSERS		
TL1034620	8405-99-958-1255	76/72/88
TL1034621	8405-99-958-1256	76/76/92
TL1034622	8405-99-958-1257	76/80/96
TL1034623	8405-99-958-1258	76/84/100
TL1034624	8405-99-958-1259	76/88/104
TL1034625	8405-99-958-1260	76/92/108
TL1034626	8405-99-958-1261	76/96/112
TL1032881	8405-99-301-7071	76/100/116
TL1032882	8405-99-301-7072	76/104/120
TL1032883	8405-99-301-7073	76/108/124
TL1034627	8405-99-958-1262	80/72/88
TL1034628	8405-99-958-1263	80/76/92
TL1034629	8405-99-958-1264	80/80/96
TL1034630	8405-99-958-1265	80/84/100
TL1034631	8405-99-958-1266	80/88/104
TL1034632	8405-99-958-1267	80/92/108
TL1034633	8405-99-958-1268	80/96/112
TL1034634	8405-99-958-1269	80/100/116
TL1032884	8405-99-301-7074	80/104/120
TL1032885	8405-99-301-7075	80/108/124
TL1034635	8405-99-958-1270	84/76/92
TL1034636	8405-99-958-1271	84/80/96
TL1034637	8405-99-958-1272	84/84/100
TL1034638	8405-99-958-1273	84/88/104
TL1034639	8405-99-958-1274	84/92/108
TL1034640	8405-99-958-1275	84/96/112
TL1034641	8405-99-958-1276	84/100/116
TL1032886	8405-99-301-7076	84/104/120
TL1032887	8405-99-301-7077	84/108/124
TL1032888	8405-99-301-7078	84/112/128

7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued

TL Number	NATO Stock Number	Size
TROUSERS		
TL1034642	8405-99-958-1277	88/76/92
TL1034643	8405-99-958-1278	88/80/96
TL1034644	8405-99-958-1279	88/84/100
TL1034645	8405-99-958-1280	88/88/104
TL1034646	8405-99-958-1281	88/92/108
TL1034647	8405-99-958-1282	88/96/112
TL1034648	8405-99-958-1283	88/100/116
TL1034649	8405-99-958-1284	88/104/120
TL1032889	8405-99-301-7079	88/108/124
TL1032890	8405-99-301-7080	88/112/128
TL1034650	8405-99-958-1285	92/80/96
TL1034651	8405-99-958-1286	92/84/100
TL1034652	8405-99-958-1287	92/88/104
TL1034653	8405-99-958-1288	92/92/108
TL1034654	8405-99-958-1289	92/96/112
TL1034655	8405-99-958-1290	92/100/116
TL1034656	8405-99-958-1291	92/104/120
TL1032891	8405-99-301-7081	92/108/124
TL1032892	8405-99-301-7082	92/112/128
TL1034657	8405-99-958-1292	96/80/96
TL1034658	8405-99-958-1293	96/84/100
TL1034659	8405-99-958-1294	96/88/104
TL1034660	8405-99-958-1295	96/92/108
TL1034661	8405-99-958-1296	96/96/112
TL1034662	8405-99-958-1297	96/100/116
TL1034663	8405-99-958-1298	96/104/120
TL1032893	8405-99-301-7102	96/108/124
TL1032894	8405-99-301-7103	96/112/128
TL1034664	8405-99-958-1299	Outsize



## **Manufacturing Specification for SHIRT, MANS, Long Sleeve, Various**

### Defence Clothing (DC)

PROPERTY OF  
MINISTRY OF DEFENCE

Defence Equipment & Support

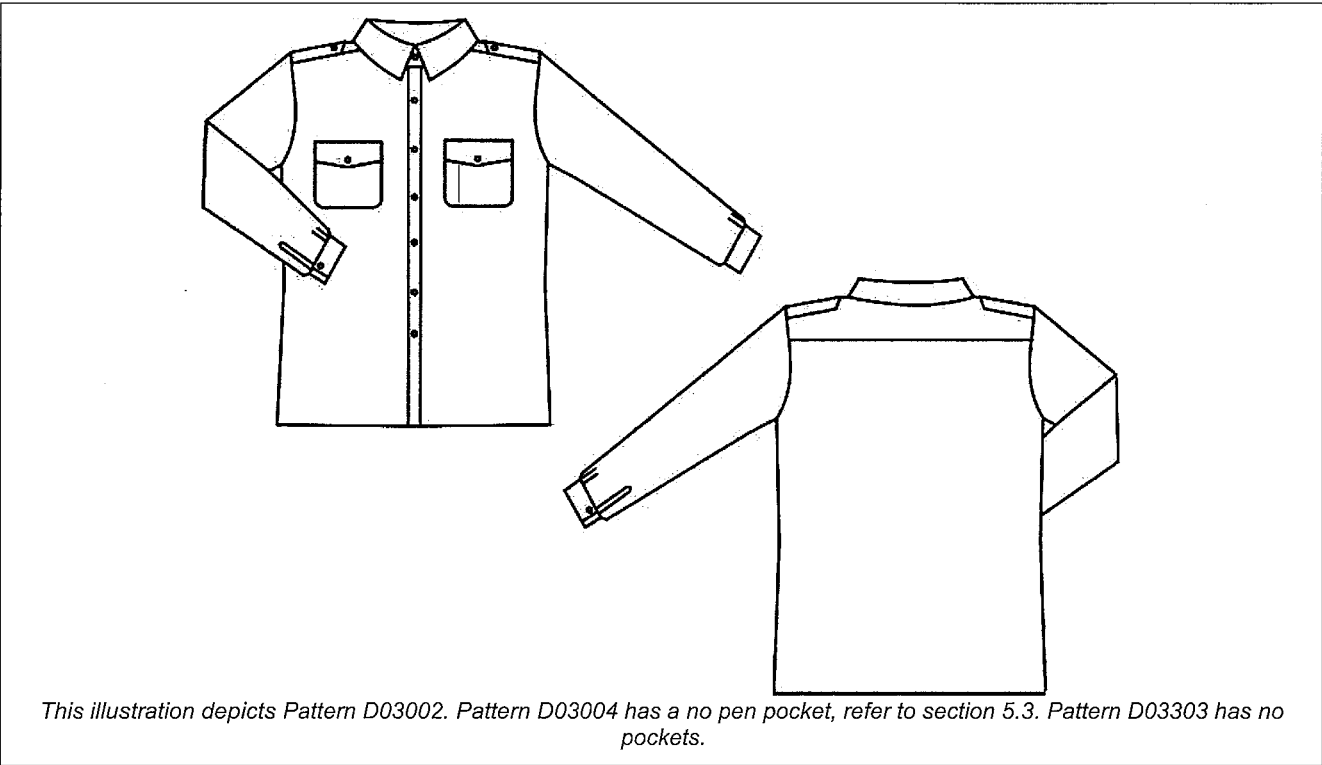


MINISTRY OF DEFENCE

**1. THE ITEM**

Item	Pattern No.	Electronic Pattern No.
SHIRT, MAN'S, Long Sleeve, Stone, RM, RAF & Army	D03002	D03002SH
SHIRT, MAN'S, Long Sleeve, Blue RAF	D03003A	D03002SH
SHIRT, MAN'S, Long Sleeve, Fawn, Army	D03004	D03002SH

Use: A long sleeved shirt made from stone, blue and fawn coloured cotton and polyester fabric. Designed for wear by the RM, RAF and Army. The size schedule provides for seventeen sizes and outsizes for each colourway.



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

IPR STATEMENT

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## 2. ISSUE RECORD

Issue No.	Comments	Issue Date
04	Specification updated to remove pockets for SHIRT, MAN'S, Long Sleeve, Blue RAF under project 03/23 Pattern No D03003 replaced by D03003A	20 February 2023
03	Specification reformatted and layout updated Extra-long sleeve deleted from title as now not required 4: New size table added with new size range Extra-long sleeve NSNs deleted as now obsolete due to new size range. All new TLs, NSNs and pattern numbers Annex A title changed to Performance of Laminates in Fusible Interlinings. Bullet points incorporate construction method	15 December 2020
02	Specification reformatted and layout updated Front page title updated to incorporate 'Various' instead of listing all colours Section 4: Garment sizing and components deleted Performance of laminates moved to the back of the specification Garment sizing table wording updated Section 5: seam type diagrams added and wording in table updated. Quality and design table updated Sections 5.2 to 5.6: diagrams and wording updated Section 6: labelling requirements, specimen labels, and wash care label updated. NSN table amended, TL Numbers added. Section 7: packaging diagrams updated and details amended Section 8: reference to MGS deleted. Specification UK/SC/6557 and 8710B & 8710D replaced by specification UK/SC/6363 and patterns MAT0022C and MAT0022F Section 9: Bill of materials updated	15 March 2018
01	New specification superseding DC/MS/5544-3 and 5544-6	13 May 2015

### 3 TECHNICAL DATA

#### 3.1 RELATED DOCUMENTS

<b>Related Specifications</b>	<b>Title</b>
BS EN ISO 3758	Textiles. Care labelling code using symbols
BS EN 12590	Industrial sewing threads made wholly or partly from synthetic fibres
BS 3866	Specification for holes and shanks for buttons
BS 3870	Stitches and seams
Part 1	Classification and terminology of stitch type
Part 2	Classification and terminology of seam type
BS 4162	Methods of test for buttons
BS 4973	Interlinings.
Part 3	Woven and knitted fusible interlinings
BS 5742	Textile labels requiring to be washed and/or dry cleaned
UK/SC/6363	Cloth, Plain Weave, Cotton and Polyester
MAT0022A	Cloth, Plain weave, polyester and cotton, Fawn
MAT0022C	Cloth, Plain weave, polyester and cotton, Blue
MAT0022F	Cloth, Plain weave, polyester and cotton, Stone

### 3.2 BILL OF MATERIALS

<b>MAIN MATERIAL(S)</b>		
Reference	Description	Notes/NATO Stock No.
UK/SC/6363 Pattern No. MAT0022A	MAIN MATERIAL for fawn shirts Cloths, plain weave, cotton and polyester, Fawn	N/A
UK/SC/6363 Pattern No MAT0022C	MAIN MATERIAL for blue shirts Cloths, plain weave, cotton and polyester, Blue	N/A
UK/SC/6363 Pattern No MAT0022F	Main Material for stone shirts Cloths, plain weave, cotton and polyester, Stone	N/A

<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Buttons	11mm	ALL BUTTONS Button, sewing hole, 2 hole	Style and shade to match standard pattern must comply with BS 3866 and BS 4162
Interlining	White	COLLAR AND SHOULDER STRAPS Interlining, fusible, plain weave cotton	BS 4973 Part 3 Ref. FWK2 See section 3.3
Interlining	White  38mm wide	FRONT STRAP Interlining, fusible, plain weave, polyester	BS 4973 Part 3 Ref. FWK1 See section 3.3
Stiffener		COLLAR Stiffener, polyamide	Or a suitable alternative to be approved by DC
Identification/care instruction label	White	Refer to section 6 for detail	BS 5742 Paragraph 3 and BS EN ISO 3758
Thread	To match main material	ALL SEWING	BS EN 12590 Table 6
Ticket No.	120	Polyester	

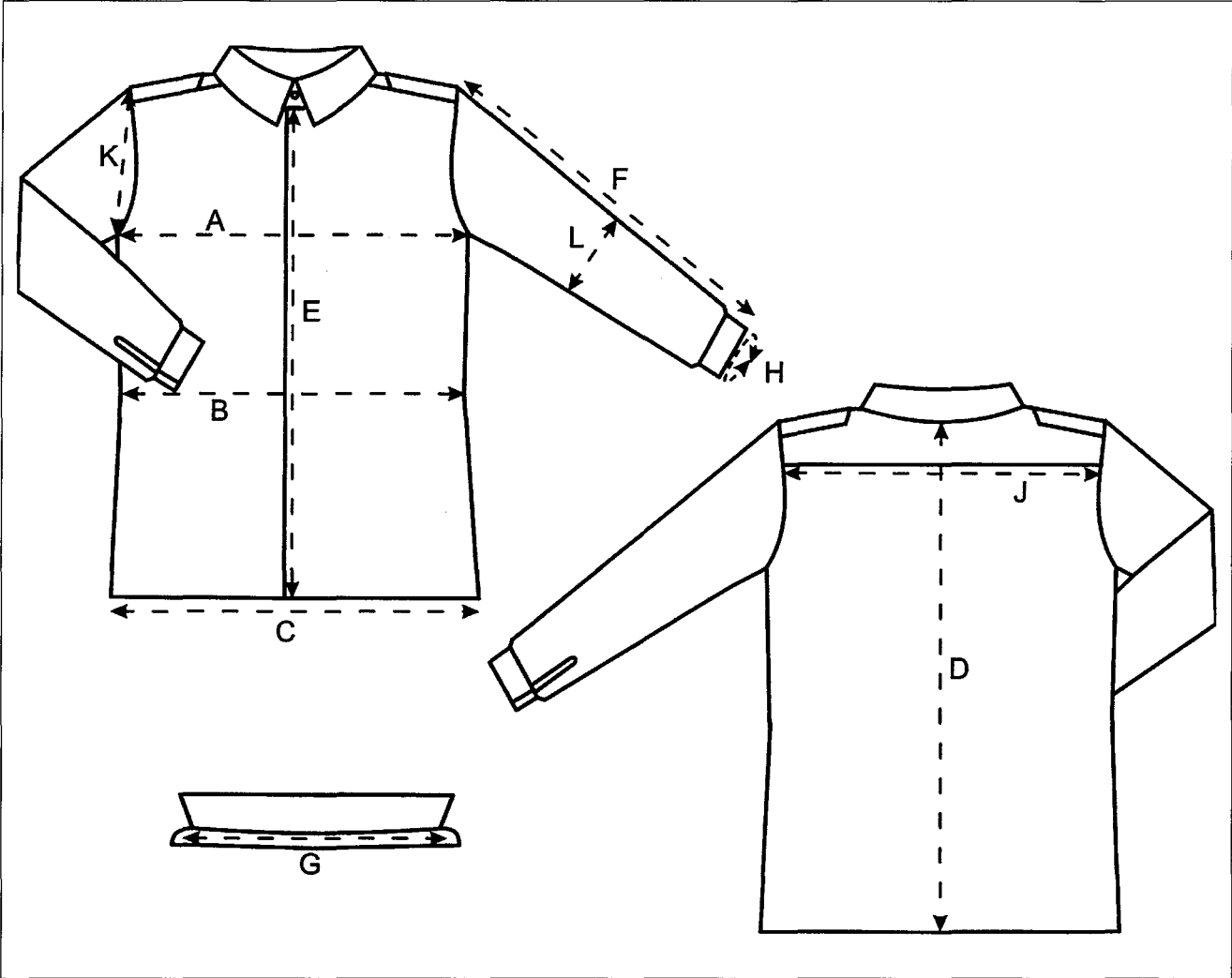
### 3.3 PERFORMANCE OF LAMINATES IN FUSIBLE INTERLININGS

- The main contractor is to ensure that the interlining is laminated strictly in accordance with the interlining manufacturer's recommendations; these recommendations are to be specific to the specified outer cloth for the related garment.
- The fusible interlining recommended must allow the garment to be washed, ironed, dry cleaned and tumble dried as recommended on the care label, throughout the garment life without any visible signs of delamination, puckering, loss of appearance and handle or excessive shrinkage.
- Fusing is to be continuous so that the laminate is free from 'blisters' and there is no 'strike through' of the adhesive onto the face of the laminate or 'strike back' through the interlining.
- The recommendations of the interlining manufacturer regarding fusing must be strictly observed and where those recommendations call for careful control of temperature, time and mechanical pressure, suitable controlled presses must be used.
- The main contractor is to be able to provide evidence to DC on request, of recommendations made by the interlining suppliers and the contractor is to demonstrate compliance with these recommendations throughout the contract. The fusible interlining must be suitable for use with the garment fabric and fused in accordance with the manufacturers recommendations



4. GARMENT SIZING

All measurements in centimetres, unless otherwise shown.



**4. GARMENT SIZING continued**

Size Chest/Collar (Inches)	Around fastened and laid flat			Length					Width of shoulder across bottom of yoke	Depth of armhole	Width across elbow (half underarm excluding cuff)
	Under arm	Waist 24cm below under arm	Bottom edge at hem	From collar Seam at centre		From crown of sleeve to bottom (including cuff)	Of collar from centre of buttonhole to centre of button	Of cuff from end to end			
				Back	Front						
	Ax2	Bx2	Cx2	D	E	F	G	H			
85/30(12")	95	87	93	83	75.5	58	30.5(12")	22	40	24	16.5
90/33(13")	100	92	98	83	75.5	60	33(13")	22	41	25	17
95/35(14")	105	99	105	84	76	60	35.5(14")	22	42	25	17
95/36(14½")	105	99	105	84	76	60	36.5(14½")	22	42	25	17
100/36(14½")	110	104	110	85	76.5	62	36.5(14½")	24	43	26	18
100/38(15")	110	104	110	85	76.5	62	38(15")	24	43	26	18
105/38(15")	115	109	115	85	76.5	64	38(15")	26	44	26	19
105/39(15½")	115	109	115	85	76.5	64	39(15½")	26	44	26	19
110/39(15½")	120	114	120	86	77	66	39(15½")	26	45	27	19.5
110/40(16")	120	114	120	86	77	66	40.5(16")	26	45	27	19.5
115/40(16")	125	119	125	86	77	68	40.5(16")	26	46	28	20
115/42(16½")	125	119	125	86	77	68	42(16½")	26	46	28	20
120/42(16½")	130	124	130	87	77.5	70	42(16½")	26	47	29	20.5
120/43(17")	130	124	130	87	77.5	70	43(17")	28	47	29	21
125/43(17")	135	129	135	87	77.5	72	43(17")	28	48	29	21.5
130/45(18")	140	138	144	88	78	74	45.5(18")	28	49	30	21.5
135/48(19")	145	143	149	89	78.5	74	48(19")	28	50	30	22
Tolerance	±1	±1	±1	±1	±1	±1	0+0.5	±0.5	±1	±1	±0.5

Outsize garments are to be made for the person whose measurements are supplied on the Outsize Form. The size chart is to be used as a guide for the allowance over the measurements supplied and measurements not shown on the form.

## 5. CONSTRUCTION

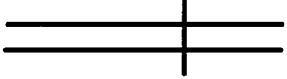
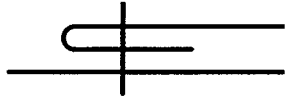
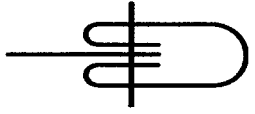
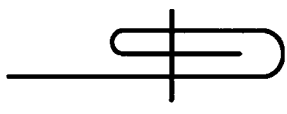
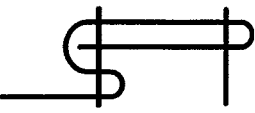
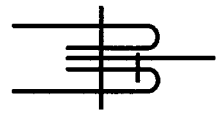
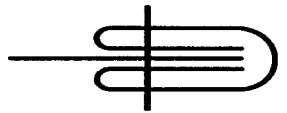
QUALITY
<ul style="list-style-type: none"><li>• The garment is to be made to a high quality.</li><li>• Attention must be paid to features which have a bearing on a neat, smooth superior finish</li><li>• Garments are to be free from all ends of sewing thread, be cleanly pressed and delivered in a clean condition.</li><li>• Uniformity in appearance is essential, therefore there is to be no noticeable variation between production garments and the Standard Pattern</li><li>• Garment parts are correctly aligned in assembly.</li><li>• There is to be no variation in paired features i.e. pockets collar ends, cuffs etc.</li><li>• Sleevehead fullness is correctly distributed, sleeves correctly pitched.</li></ul>

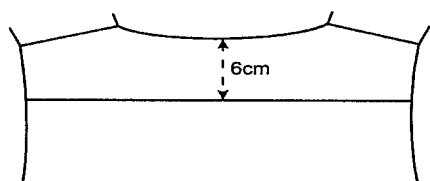
DESIGN
<ul style="list-style-type: none"><li>• Top fused two piece collar</li><li>• Buttoned front placket</li><li>• Pockets with flaps (<b>D03002 and D03004 only</b>)</li><li>• Left breast pocket with pen slot (<b>D03002 only</b>)</li><li>• Back yoke</li><li>• One piece set-in sleeves</li><li>• Two knife pleats at cuff</li><li>• Single buttoned cuff</li><li>• Shoulder straps</li></ul>

SEAMS AND STITCHING to BS 3870
<ul style="list-style-type: none"><li>• Yoke, side and armhole seams are to be seam type 1.01.01, stitch type 301 or 401 and raw edges overlocked.</li><li>• All other raw edges to be finished with stitch type 502, 503, 504 or 505</li><li>• All other stitching is to be stitch type 301</li><li>• All seams to have at 8 to 10 stitches per 2cm and be correctly tensioned</li><li>• Buttonholes are to have 22 stitches per 2cm minimum</li><li>• Buttons are to be securely sewn with at least 16 stitches minimum through each hole.</li><li>• Edges of collars, shoulder straps and pocket flaps, are to be stitched 0.6cm from the edge (where applicable). The stitching is to be regular and unbroken</li></ul>

5. **CONSTRUCTION continued**

The following seam types are referenced in this specification:

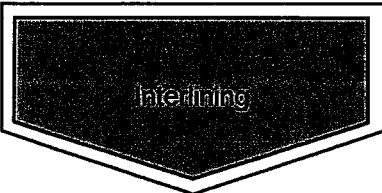
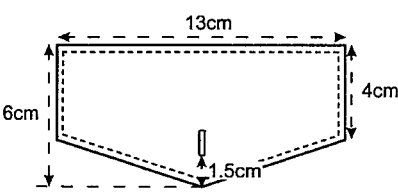
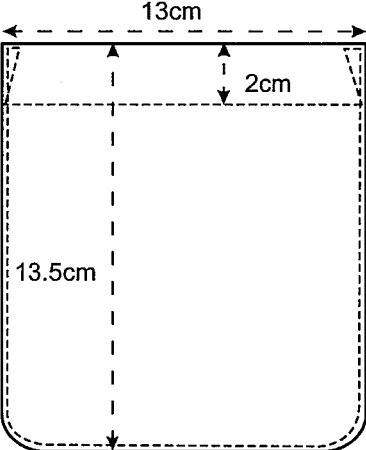
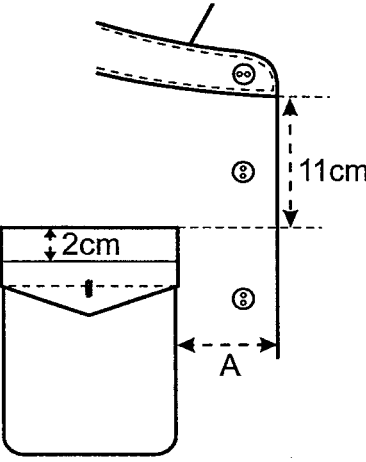
	1.01.01		5.31.01
	3.05.01		6.03.01
	6.08.01		2.42.03
	3.05.03		

PART	DETAIL	SEAM REF
<p>5.1 BACK</p> 	<ul style="list-style-type: none"> <li>• Two ply yoke, 6cm deep at centre back</li> <li>• Yoke to be securely attached to back and front panels</li> </ul>	

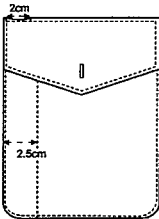
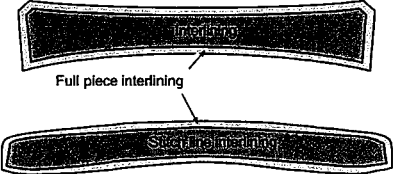
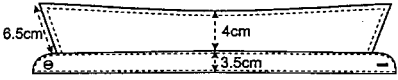
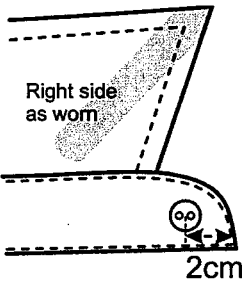
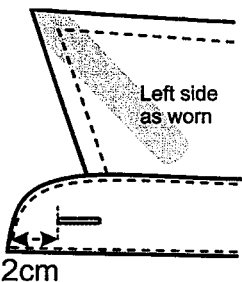
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.2 FRONTS</p> <p>Right side as worn</p> <p>Left Side as worn</p> <p>Inside view</p>	<p><u>Right front</u></p> <ul style="list-style-type: none"> <li>To have grown on facing 5cm deep, finished 4cm</li> <li>Facing to be finished with a 1cm in-turn</li> <li>Six buttons, positioned vertically</li> <li>Positioned 2cm from front edge</li> <li>1<sup>st</sup> button centre to be positioned 7.5cm from collar seam</li> <li>Additional 5 buttons positioned 9cm apart</li> </ul> <p><u>Left Front</u></p> <ul style="list-style-type: none"> <li>To have grown on placket, finished width 4cm</li> <li>Six vertical buttonholes, 1.2cm usable opening</li> <li>Positioned centrally in placket (2cm from front edge)</li> <li>1<sup>st</sup> buttonhole centre to be positioned 7.5cm from collar seam</li> <li>Additional 5 buttonholes positioned 9cm apart</li> <li>Buttons and buttonholes should be correctly aligned so there is no distortion of front when shirt buttoned-up</li> </ul> <p><u>Spare button</u></p> <ul style="list-style-type: none"> <li>One button to be securely sewn to the right front in-turn (stitching not to penetrate both layers)</li> <li>Positioned approximately 10cm from the bottom edge</li> </ul>	<p>6.03.01</p> <p>6.08.01</p>

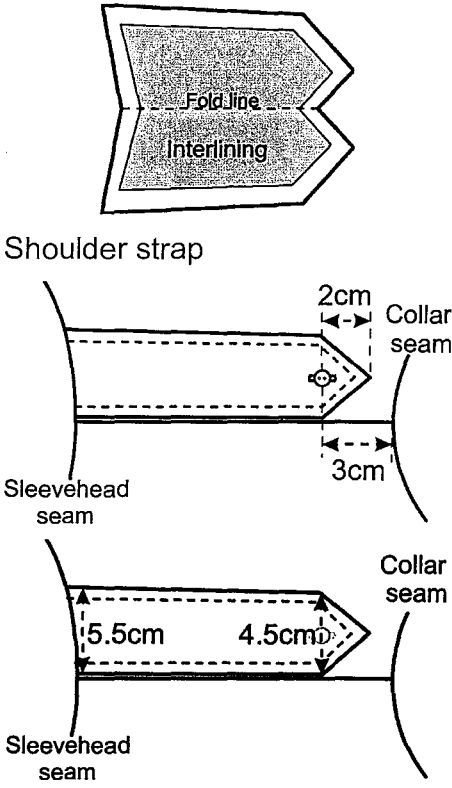
5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF										
<p>5.3 POCKETS</p> <p>Fusible interlining</p>  <p>Flap</p>    <p>Right side as worn</p>	<p><b><u>Pattern No D03002 and D03004 only</u></b></p> <p><u>Flap</u></p> <ul style="list-style-type: none"> <li>• Flap two ply of main material, shaped as standard pattern</li> <li>• Top ply of flap to be interlined (as diagram)</li> <li>• 6cm deep at point, 4cm deep at sides, and 13cm wide</li> <li>• A vertical buttonhole, 1.2cm usable opening, to be worked centrally in flap</li> <li>• Positioned 1.5cm from point</li> </ul> <p><u>Patch</u></p> <ul style="list-style-type: none"> <li>• Patch one ply main material, shaped as standard pattern, with curved corners</li> <li>• 13.5cm deep and 13cm wide</li> <li>• Top edge to have a 2cm in-turn</li> <li>• Button to be positioned vertically and in line with buttonhole</li> <li>• Flap to be securely attached to the shirt fronts, 11cm from collar seam</li> <li>• Patch to be securely attached to the shirt fronts, edge stitched with triangular turn back in stitching</li> <li>• Patch to be positioned 2cm below top edge of flap</li> <li>• Flap and patch positioned as follows:</li> </ul> <table border="1" data-bbox="574 1691 1204 1982"> <thead> <tr> <th>Size</th> <th>Distance from front edge A (cm)</th> </tr> </thead> <tbody> <tr> <td>95-100</td> <td>6</td> </tr> <tr> <td>105-110</td> <td>6.5</td> </tr> <tr> <td>115-125</td> <td>7</td> </tr> <tr> <td>130-135</td> <td>7.5</td> </tr> </tbody> </table>	Size	Distance from front edge A (cm)	95-100	6	105-110	6.5	115-125	7	130-135	7.5	<p>6.03.01</p> <p>5.31.05</p> <p>5.31.01</p>
Size	Distance from front edge A (cm)											
95-100	6											
105-110	6.5											
115-125	7											
130-135	7.5											

5. **CONSTRUCTION continued**

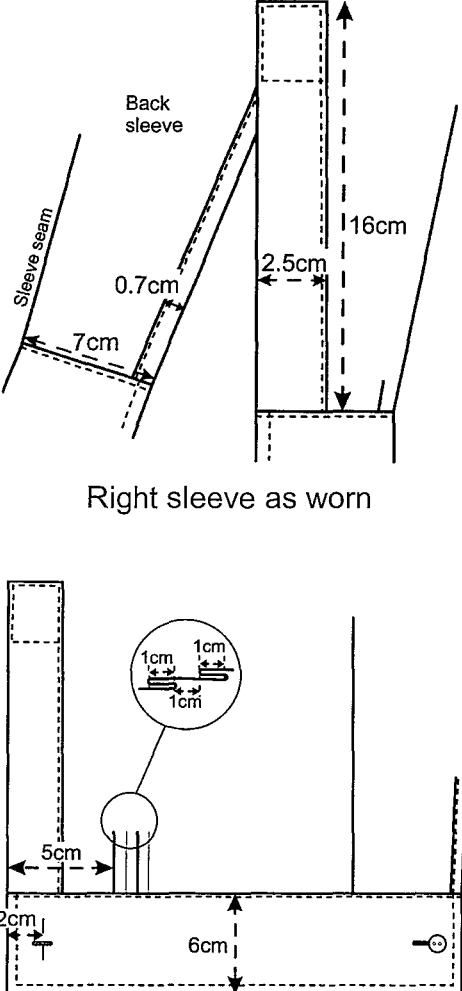
PART	DETAIL	SEAM REF
<p>5.3 POCKETS continued</p> 	<p><b>Pattern No D03002 only</b></p> <ul style="list-style-type: none"> <li>• Left patch, as worn, to have a vertical row of stitching, 2.5cm from front edge</li> <li>• Flap to have an opening left in the top, 2cm and edges of opening bar-tacked</li> </ul>	
<p>5.4 COLLAR</p> <p>Fusible interlining</p>  <p>Collar</p>   	<ul style="list-style-type: none"> <li>• Two piece, stand and fall, shaped as on the Standard Pattern</li> <li>• Dimensions: fall at back 4cm at points 6.5cm, stand at back 3.5cm.</li> <li>• Collar to be interlined (as diagram)</li> <li>• Top collar with a two-ply fusible interlining, first ply cut to full dimensions of collar pieces.</li> <li>• The second ply cut to clear the fall edge, sewing lines and the break line.</li> <li>• A stiffener is to be inserted into the collar point and to be retained by top stitching.</li> <li>• The stand, outside of shirt, to be securely attached to the shirt at the neck edge.</li> <li>• The stand, inside of shirt, to be turned in and edge stitched to the neck seam.</li> <li>• A button is sewn centrally on the right side of the collar stand 2cm from the end to the centre of the button</li> <li>• A buttonhole, 1.2cm usable opening, is worked horizontally and centrally in the left side of the collar stand</li> <li>• Positioned 2cm from the end to the start of the buttonhole.</li> </ul>	<p>2.42.03</p>

5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.5 SHOULDER STRAPS Fusible interlining</p> 	<ul style="list-style-type: none"> <li>• Shoulder straps shaped as standard pattern with pointed free end.</li> <li>• Cut one piece and folded.</li> <li>• Fold line to be positioned to front of garment.</li> <li>• Shoulder strap to be interlined (as diagram)</li> <li>• Length as required by the shoulder button</li> <li>• 5.5cm wide at the sleevehead tapering to 4.5cm wide at the buttonhole.</li> <li>• A buttonhole, 1.2cm usable opening, worked centrally in the strap with the centre 2cm from the point.</li> <li>• Shoulder strap to be topstitched 0.6cm</li> <li>• A button sewn to the shoulder 3cm from the collar seam.</li> <li>• The strap to be sewn in the sleevehead seam, with the front edge aligned with the front yoke seam.</li> </ul>	



5. **CONSTRUCTION continued**


PART	DETAIL	SEAM REF
<p>5.6 SLEEVES</p>  <p>Back sleeve</p> <p>Sleeve seam</p> <p>0.7cm</p> <p>7cm</p> <p>2.5cm</p> <p>16cm</p> <p>Right sleeve as worn</p> <p>1cm 1cm</p> <p>1cm</p> <p>5cm</p> <p>2cm</p> <p>6cm</p> <p>Right sleeve as worn</p>	<p><u>Guarded Vent</u></p> <ul style="list-style-type: none"> <li>Vent to be cut in the back of the sleeve, 7cm from under-arm seam</li> <li>0.7cm wide guard to be securely attached to the back edge</li> <li>2.5cm wide and 16cm long guard to be securely attached to the front edge</li> <li>Box stitched at top and edge stitched</li> </ul> <p><u>Pleats</u></p> <ul style="list-style-type: none"> <li>Two 1cm knife pleats, positioned 1cm apart are to be worked in the sleeve end</li> <li>1<sup>st</sup> pleat positioned 5cm from the edge of the vent</li> </ul> <p><u>Cuff</u></p> <ul style="list-style-type: none"> <li>Cuff, two ply material 6cm deep</li> <li>Outside ply of cuff to have fusible interlining</li> <li>The outside ply to be securely attached to the bottom sleeve</li> <li>The inside ply is to be turned back and edge stitched</li> <li>Cuff to be topstitched on 3 sides 0.6cm</li> <li>A buttonhole, 1.2cm usable opening, is worked in each end of the cuff</li> <li>Positioned horizontally and centrally with the centre of each hole 2cm from the end of the cuff</li> <li>A button is to be sewn to the outside of the underlap end of the cuff, positioned at the end of the buttonhole</li> </ul>	<p>3.05.03</p> <p>3.05.01</p> <p>2.42.03</p>
<p>5.7 HEM</p>	<ul style="list-style-type: none"> <li>Finished with a 0.6cm upturn</li> </ul>	<p>6.03.01</p>

**6. LABELLING REQUIREMENTS**


Labels	Position
Identification and care labels (can be combined to produce one label)	Side seam positioned 10cm from hem

Identification Label

Stock sizes






SHIRT, MAN'S, Stone, Long Sleeve 
8405-99-615-9744
Size: 85/30(12")
Contract No:
Date of Manufacture: MM/YYYY
Name:
No:
<i>(Fibre content to be added here)</i>

Outsize

SHIRT, MAN'S, Stone, Long Sleeve 
8405-99-615-9761
Collar:*
Chest:*
Contract No:
Date of Manufacture: MM/YYYY
Name:
No:
<i>(Fibre content to be added here)</i>

\*Size as appropriate for measurements supplied

Care Label

	Wash as cotton Medium Wash
	DO NOT BLEACH
	Tumble Dry Higher heat setting
	Warm Iron
	DO NOT DRY CLEAN

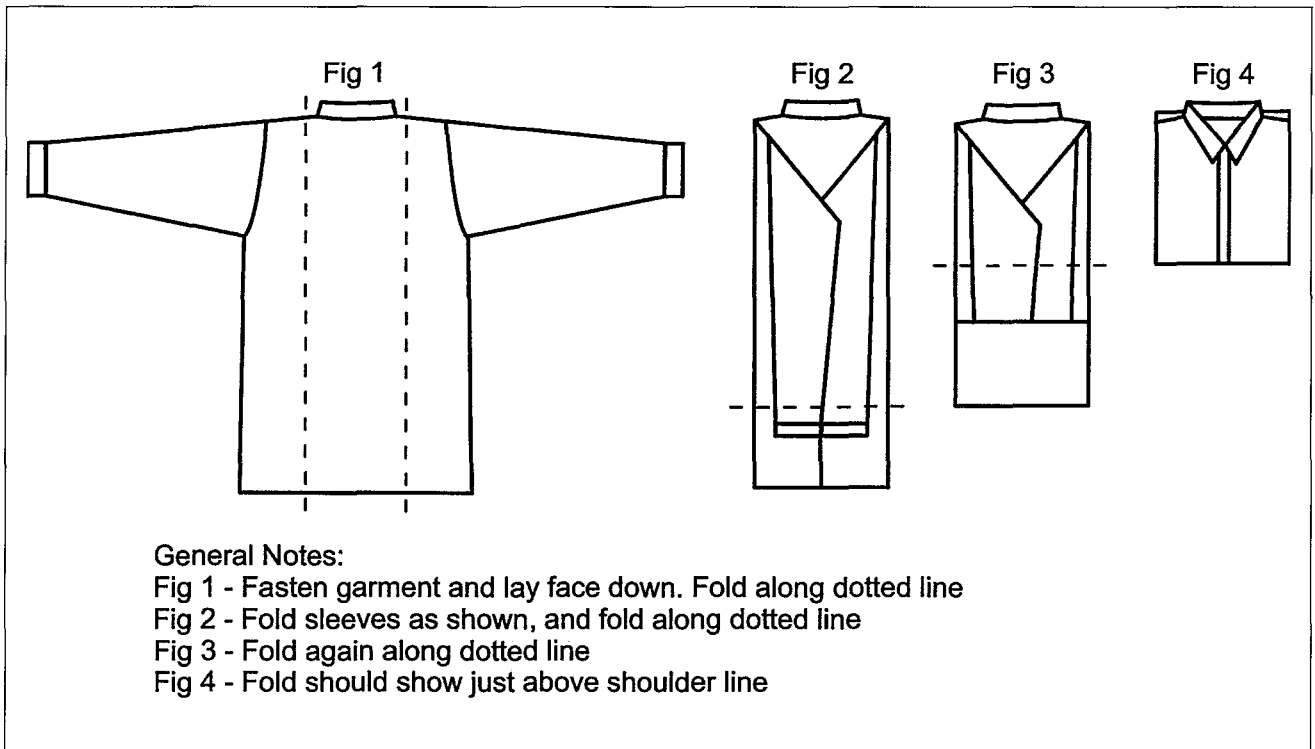
Manufacturer Information

The contractor's name, logo or trademark should not appear on any labels, garment bags or packaging.

## 7. PACKAGING

All shirts are to be folded as illustrated. Boarded including collar support, secured by non-metallic fasteners and packed individually in a transparent polythene bag.

Identification label to be attached to the outside of the polythene bag, including item name, NSN, Size and Contract Number.



**8. TL NUMBER, NATO STOCK NUMBER AND SIZE**

TL Number	NATO Stock Number (Fawn)	Size	TL Number	NATO Stock Number (Blue)	Size	TL Number	NATO Stock Number (Stone)	Size
TL1084561	8405-99-615-9780	85/30(12")	TL1084543	8405-99-615-9762	85/30(12")	TL1084525	8405-99-615-9744	85/30(12")
TL1084562	8405-99-615-9781	90/33(13")	TL1084544	8405-99-615-9763	90/33(13")	TL1084526	8405-99-615-9745	90/33(13")
TL1084563	8405-99-615-9782	95/35(14")	TL1084545	8405-99-615-9764	95/35(14")	TL1084527	8405-99-615-9746	95/35(14")
TL1084564	8405-99-615-9783	95/36(14½")	TL1084546	8405-99-615-9765	95/36(14½")	TL1084528	8405-99-615-9747	95/36(14½")
TL1084565	8405-99-615-9784	100/36(14½")	TL1084547	8405-99-615-9766	100/36(14½")	TL1084529	8405-99-615-9748	100/36(14½")
TL1084566	8405-99-615-9785	100/38(15")	TL1084548	8405-99-615-9767	100/38(15")	TL1084530	8405-99-615-9749	100/38(15")
TL1084567	8405-99-615-9786	105/38(15")	TL1084549	8405-99-615-9768	105/38(15")	TL1084531	8405-99-615-9750	105/38(15")
TL1084568	8405-99-615-9787	105/39(15½")	TL1084550	8405-99-615-9769	105/39(15½")	TL1084532	8405-99-615-9751	105/39(15½")
TL1084569	8405-99-615-9788	110/39(15½")	TL1084551	8405-99-615-9770	110/39(15½")	TL1084533	8405-99-615-9752	110/39(15½")
TL1084570	8405-99-615-9789	110/40(16")	TL1084552	8405-99-615-9771	110/40(16")	TL1084534	8405-99-615-9753	110/40(16")
TL1084571	8405-99-615-9790	115/40(16")	TL1084553	8405-99-615-9772	115/40(16")	TL1084535	8405-99-615-9754	115/40(16")
TL1084572	8405-99-615-9791	115/42(16½")	TL1084554	8405-99-615-9773	115/42(16½")	TL1084536	8405-99-615-9755	115/42(16½")
TL1084573	8405-99-615-9792	120/42(16½")	TL1084555	8405-99-615-9774	120/42(16½")	TL1084537	8405-99-615-9756	120/42(16½")
TL1084574	8405-99-615-9793	120/43(17")	TL1084556	8405-99-615-9775	120/43(17")	TL1084538	8405-99-615-9757	120/43(17")
TL1084575	8405-99-615-9794	125/43(17")	TL1084557	8405-99-615-9776	125/43(17")	TL1084539	8405-99-615-9758	125/43(17")
TL1084576	8405-99-615-9795	130/45(18")	TL1084558	8405-99-615-9777	130/45(18")	TL1084540	8405-99-615-9759	130/45(18")
TL1084577	8405-99-615-9796	135/48(19")	TL1084559	8405-99-615-9778	135/48(19")	TL1084541	8405-99-615-9760	135/48(19")
TL1084578	8405-99-615-9797	Outsize	TL1084560	8405-99-615-9779	Outsize	TL1084542	8405-99-615-9761	Outsize



**Manufacturing Specification for  
TROUSERS, WOMAN'S, No.2 Dress, Army, All Ranks,  
The Royal Dragoon Guards, OR and  
The Royal Hussars, OR**

**Defence Clothing (DC)**

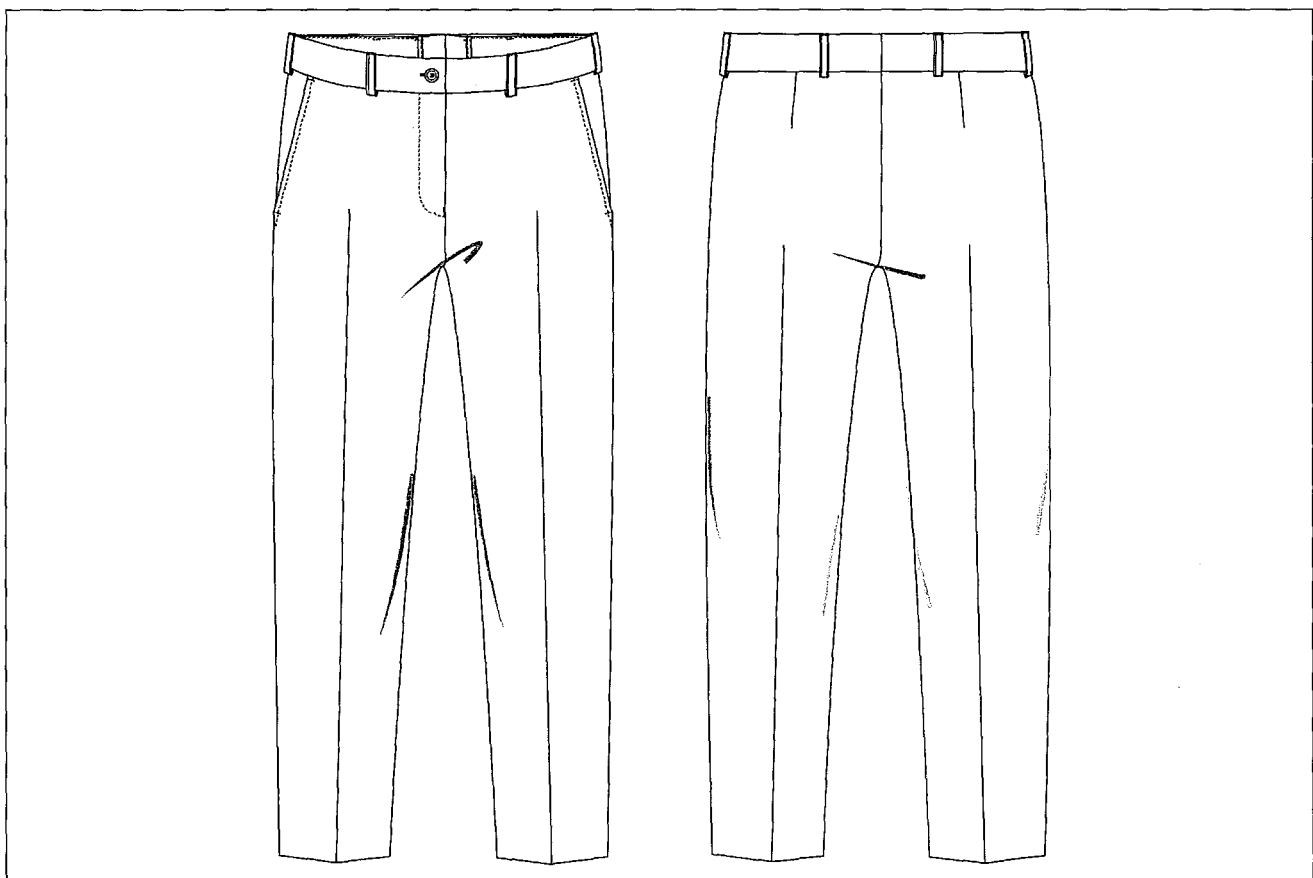
PROPERTY OF  
MINISTRY OF DEFENCE



1. **THE ITEM**

Item	Pattern No.	Electronic Pattern No.
TROUSERS, WOMAN'S, No.2 Dress, Army, All Ranks	D03119	D03119T
TROUSERS, WOMAN'S, No.2 Dress. Army, The Royal Dragoon Guards, OR	D03119TG	D03119T
TROUSERS, WOMEN'S, No.2 Dress, Army, The Royal Hussars, OR	D03119TG	D03119T

Use: Trousers: Baratheia wool material, for wear by army service women. Provided in 31 sizes and an outsize or outsize only.



1. **THE ITEM continued**

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

**IPR STATEMENT**

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**Technical documents in this specification refer to the edition current at the date of tender or contract unless otherwise stated.**

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2. **ISSUE RECORD**

Issue No.	Comments	Issue Date
01	New specification following Development Project LCST-578, part of tri-service size and styling rationalisation project and PSED  Khaki version trousers supersede Female Barrack Dress Trousers, specification DC/MS/6506 NSNs 8410-99-990-6849 to 6916	22 May 2023



### 3. TECHNICAL DATA

#### 3.1 RELATED DOCUMENTS

Document	Title
BS EN ISO 3758	Textiles. Care labelling code using symbols
BS ISO 7769	Test method for assessing the appearance of creases in fabrics after cleansing
BS EN 12590	Industrial sewing threads made wholly or partly from synthetic fibres
BS 3870 Part 1 Part 2	Stitches and seams Classification and terminology of stitch type Classification and terminology of seam type
BS 4973 Part 2 Part 3	Interlinings Non-woven fusible interlinings Woven and knitted fusible interlinings
BS 5742	Textile labels requiring to be washed and/or dry cleaned
UK/SC/4559	Slide fasteners, metallic and non-metallic chains
UK/SC/4885	Cloth, barathea, wool, worsted
UK/SC/6409	Cloths, barathea, wool, worsted
UK/SC/6577	Cloth, twill, polyester/cotton
8373B	Cloth, barathea, wool, worsted, khaki
8303J	Cloth, barathea, wool, worsted, green No.7
8303C	Cloth, barathea, wool, worsted, crimson No.1

3.2 **BILL OF MATERIALS**

<b>MAIN MATERIAL(S)</b>		
Reference	Description	Notes/NATO Stock No.
UK/SC/4885 Pattern No. 8373B	MAIN MATERIAL KHAKI Cloth, barathea, wool, worsted, khaki	
UK/SC/6409 Pattern No.8303J	MAIN MATERIAL THE ROYAL DRAGOON GUARDS Cloth, barathea, wool, worsted, green No.7	
UK/SC/6409 Pattern No.8303C	MAIN MATERIAL THE ROYAL HUSSARS Cloth, barathea, wool, worsted, crimson, No.1	
UK/SC/6577 Pattern No. 8190U	TROUSER POCKETS, FORK STAYS, CROTCH LINING, FLY LINING, BINDING SEAT SEAM AND POCKET BAGS Cloth, twill, polyester and cotton. Shade to match main material	Or a suitable alternative to be approved by DC

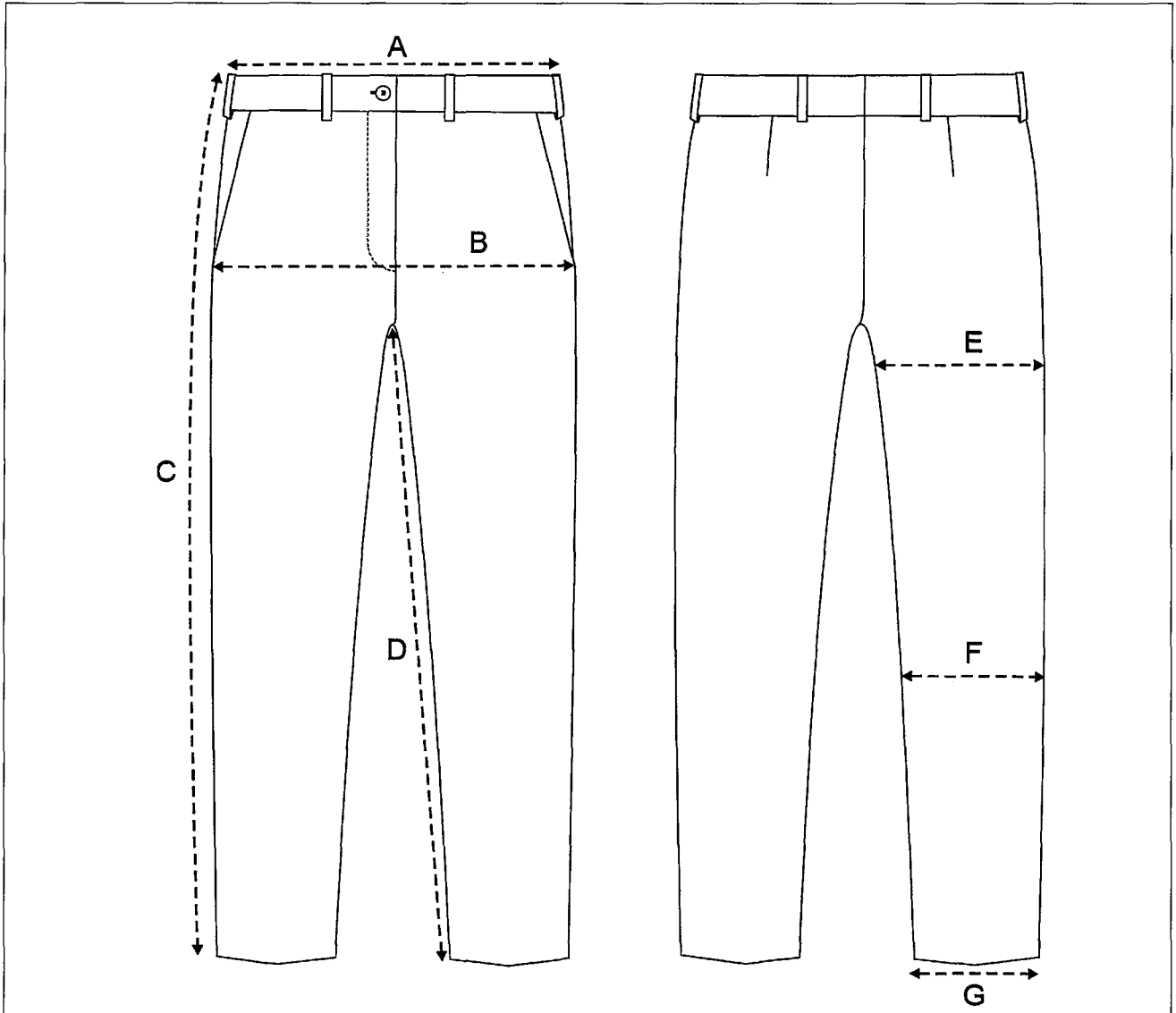
<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Interlining	Charcoal	WAISTBAND Interlining fusible, woven, knitted or non woven type	BS 4973 Part 3 or 2
Reinforcement	Black 2.5cm wide finished items to weigh at least 5.5g/m2	WAISTBAND Interlining plain weave continuous filament polyester warp, 100 Tex mono filament nylon weft, acrylic melamine resin finish with at least 34 ends per width and 10 picks per cm. Edged sealed with PVC heat set into a concave shape	Or a suitable alternative to be approved by DC
Stay	30mm	SIDE POCKETS Tape, woven, fusible	
Slide Fastener	Shade to match main material 11mm wide stringer	FLY Fastener slide lightweight polyester or polyamide, spiral chain, closed end, auto locking slider, and bottom stop	UK/SC/4559

3.2 **BILL OF MATERIALS continued**

<b>COMPONENTS</b>			
	Size/Colour	Reference/Description	Notes/NATO Stock No.
Button	Shade to match material 16mm	WAIST BUTTON  Button sewing 4 hole	As standard pattern
Permanent Crease		Resinated Bead from a 1mm nib (Supercrease® from Clantex Ltd has been found acceptable when applied using the appropriate formers)	BS ISO 7769 to comply with the requirements of CR-5
Reinforcement	Shade to match material 25mm	TROUSER BOTTOM  Webbing nylon	Or a suitable alternative to be approved by DC
Identification/ care instruction labels	White	Refer to section 6 for detail	BS 5742 Paragraph 3 and BS EN ISO 3758
Thread  Ticket No	To match main material  60	Polyamide, nylon 6.6 continuous filament  SEWING BUTTONHOLES	BS EN 12590 Table 7
Thread  Ticket No Ticket No Ticket No	To match main material  12 180 75	Polyester/cotton corespun  BUTTONHOLES OVEREDGING ALL OTHER SEWING	BS EN 12590 Table 5  Gimp

#### 4. GARMENT SIZING

All measurements in centimetres.



Outsize garments are to be made for the person whose measurements are supplied on the Outsize Form. The size chart is to be used as a guide for the allowance over the measurements supplied and measurements not shown on the form.

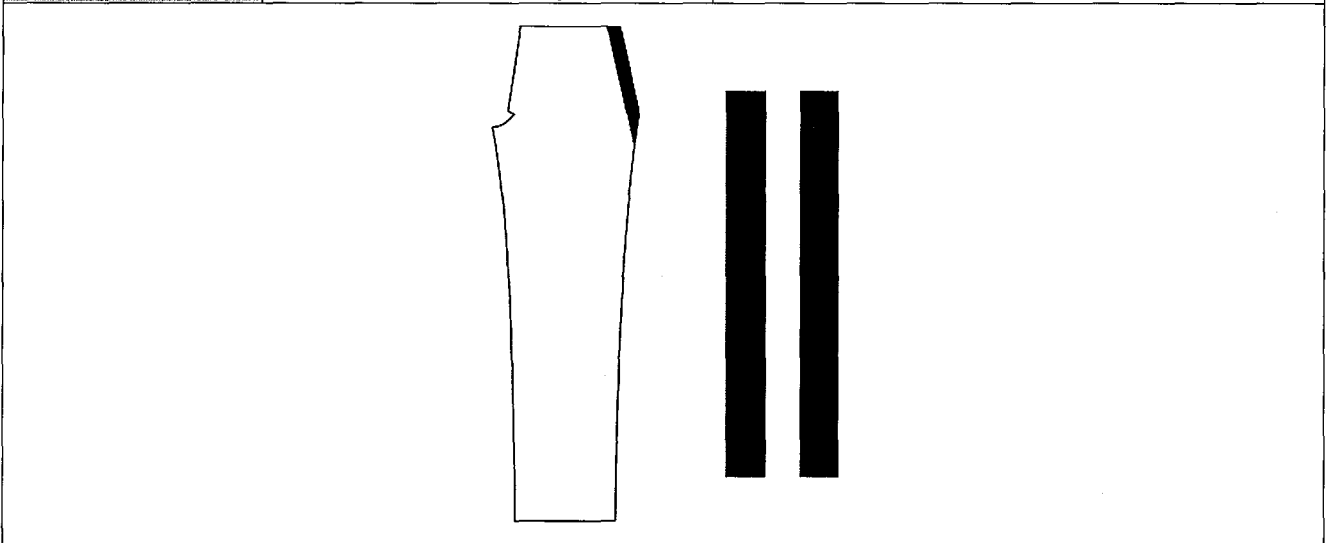
4. **GARMENT SIZING continued**

Size Inside Leg/Waist/Hips	Measurements of garment fastened and laid flat						
	Around		Length of		Thigh 5cm below fork	Knee ½ inside leg plus 5cm towards fork	Bottom
	Waist at top edge of waistband	Hips at bottom fly	Outside leg excluding waistband	Inside leg seam			
	Ax2	Bx2	C	D	Ex2	Fx2	Gx2
70/60/84	62	94	96	70	56	46	43
70/65/89	67	99	96.5		58	47	43
70/70/94	72	104	97		60	48	43
70/75/99	77	109	97.5		62	49	44
70/80/104	82	114	98		64	50.5	44
75/60/84	62	94	101.5	75	56	46	43
75/65/89	67	99	102		58	47	43
75/70/94	72	104	102.5		60	48	43
75/75/99	77	109	103		62	49	44
75/80/104	82	114	103.5		64	50.5	44
75/85/109	87	119	104		66	52	44
75/90/114	92	124	104.5		68	53.5	44
75/95/119	97	129	105		70	55	44
80/65/89	67	99	107	80	58	47	43
80/70/94	72	104	107.5		60	48	43
80/75/99	77	109	108		62	49	44
80/80/104	82	114	108.5		64	50.5	44
80/85/109	87	119	109		66	52	44
80/90/114	92	124	109.5		68	53.5	44
80/95/119	97	129	110		70	55	44
80/100/124	102	134	110.5		72	56.5	44
80/105/129	107	139	111		74	58	44
85/65/89	67	99	112.5	85	58	47	43
85/70/94	72	104	113		60	48	43
85/75/99	77	109	113.5		62	49	44
85/80/104	82	114	114		64	50.5	44
85/85/109	87	119	114.5		66	52	44
85/90/114	92	124	115		68	53.5	44
85/95/119	97	129	115.5		70	55	44
85/100/124	102	134	116		72	56.5	44
85/105/129	107	139	116.5		74	58	44
Tolerances+/-	1	1	1	1	0.5	0.5	0.5

**5. CONSTRUCTION**

FUSING DIAGRAM

COLOUR	PRODUCT	DESCRIPTION
	20mm woven tape	
	Non-woven	
	Woven, knitted or non-woven	Waistband
	Plain weave cotton	Waistband
	30mm woven tape	Side pocket
	Cloth non-woven polyester	



The fusible interlining must be suitable for use with the garment fabric and fused in accordance with the manufacturers recommendations.

The resulting laminate shall be free from blisters and there shall not be strike through of adhesive on either the face or back.

The garment must be able to be laundered throughout its life in accordance with the care label, without any visible signs of delamination, puckering, loss of appearance and handle or excessive shrinkage.

## 5. CONSTRUCTION continued

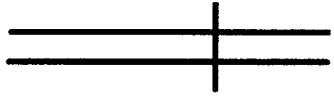

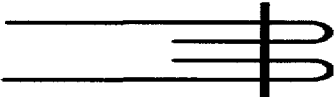


QUALITY
<ul style="list-style-type: none"><li>• The garment is to be made to a high quality standard using sound tailoring production techniques to give a neat, smooth superior finish.</li><li>• Uniformity in appearance is essential. There should not be any noticeable variation between production garments and the Standard Pattern.</li><li>• It is essential that:<ul style="list-style-type: none"><li>• Garment parts are correctly aligned and the run of seams is regular and neatly under and top pressed</li></ul></li><li>• Paired features (e.g. left and right collar end, cuffs, pockets etc.) must be balanced and should not be at the extremes of the tolerance, ensuring symmetry.</li></ul>

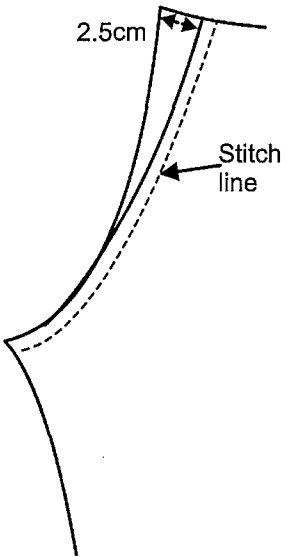
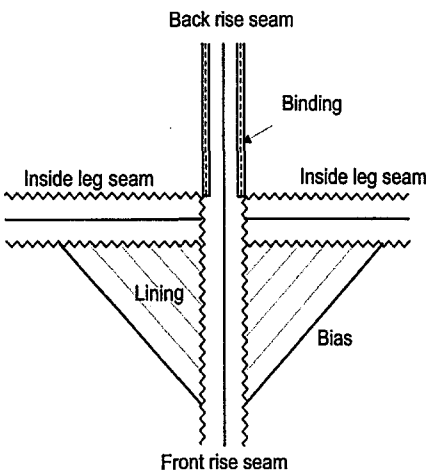
DESIGN
<ul style="list-style-type: none"><li>• Front opening with slide fastener</li><li>• One dart in each underside</li><li>• Permanent crease treatment in front crease</li><li>• Slanted side pockets</li><li>• Belt loops</li><li>• Plain bottoms</li></ul>

SEAMS AND STITCHING to BS 3870
<ul style="list-style-type: none"><li>• Seat, leg and side seams seam type 1.01.01 and pressed open</li><li>• Seat, leg and side seams can be sewn with stitch type 301 or 401</li><li>• Two rows required when seat seam is sewn using stitch type 301</li><li>• All other stitching type 301</li><li>• 301 and 401 to have 8-10 stitches per 2cm</li><li>• Raw edges finished using stitch type 501, 502, 503, 504 or 505</li><li>• Belt loops and fly guard edge stitched</li><li>• Side pocket openings stitched 0.6cm from edge</li><li>• Hem stitch type 103 with at least 4 stitches per 2cm</li><li>• Button hole cut before worked type, with at least 22 stitches per 2cm, bar tack finished</li><li>• Button sewn with at least 12 stitches through each hole</li></ul>

**5. CONSTRUCTION continued**

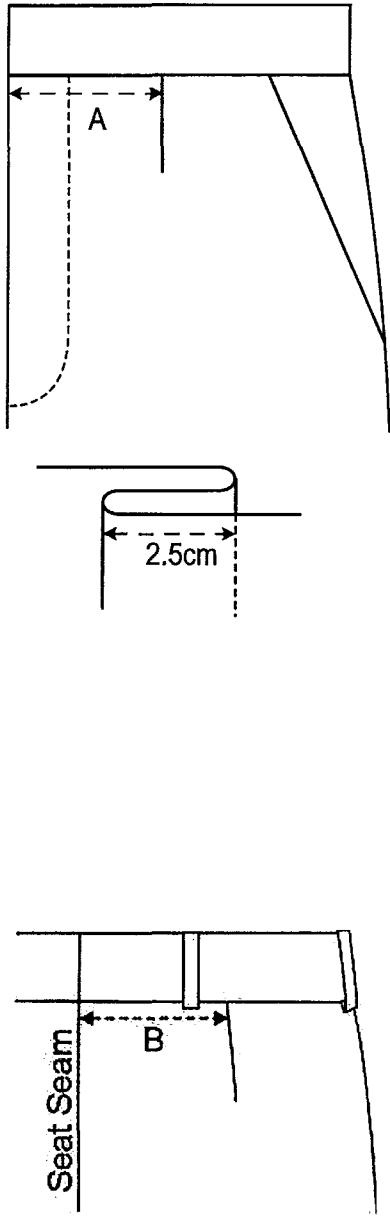
The following seam types are referenced in this specification:

	1.01.01		6.02.02
	1.06.02		8.02.01
	3.05.03		

PART	DETAIL	SEAM REF
<p>5.1 INLAYS</p> 	<ul style="list-style-type: none"> <li>• 2.5cm wide at seat seam to nothing approximately 16.5cm from the fork</li> <li>• Corresponding inlay on waistband interlining and lining</li> </ul>	
<p>5.2 FORK STAY</p> 	<ul style="list-style-type: none"> <li>• Fork stay of folded lining sewn in with leg and fork seams</li> <li>• Folded edge on the bias</li> <li>• Ease required across the inside leg seams</li> </ul>	



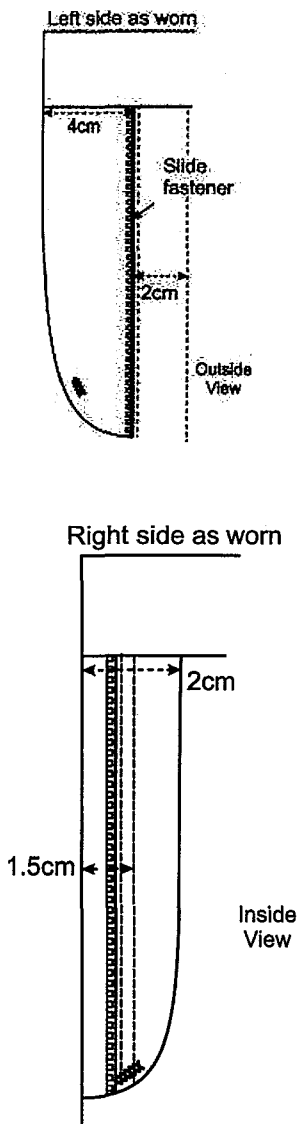
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF																																												
<p>5.3 PLEATS AND DARTS</p>  <p>The drawing shows a side view of a skirt waistband. A pleat is formed at the top, with a depth of 2.5cm. A dart is located on the underside, with a length of 6cm and a width of 1.5cm. Dimension A is the distance from the front edge to the start of the pleat. Dimension B is the distance from the seat seam to the start of the dart. A detailed view of the pleat shows a 2.5cm depth.</p>	<ul style="list-style-type: none"> <li>• 2.5cm deep pleat</li> <li>• The pleat forms the start of the permanent crease extending to the bottom hem</li> <li>• A bead of resin is to be positioned correctly into the fold of the pleat</li> <li>• Pleat position A from front edge:</li> </ul> <table border="1" data-bbox="614 719 1203 1227"> <thead> <tr> <th>Waist Size</th> <th>A (cm)</th> </tr> </thead> <tbody> <tr><td>60</td><td>8</td></tr> <tr><td>65</td><td>8.5</td></tr> <tr><td>70</td><td>9</td></tr> <tr><td>75</td><td>9.5</td></tr> <tr><td>80</td><td>10</td></tr> <tr><td>85</td><td>10.5</td></tr> <tr><td>90</td><td>11</td></tr> <tr><td>95</td><td>11.5</td></tr> <tr><td>100</td><td>12</td></tr> <tr><td>105</td><td>12.5</td></tr> </tbody> </table> <ul style="list-style-type: none"> <li>• One 1.5 cm uncut dart on each underside</li> <li>• Length 6 cm</li> <li>• Dart position B from seat seam:</li> </ul> <table border="1" data-bbox="614 1420 1203 1928"> <thead> <tr> <th>Waist Size</th> <th>B (cm)</th> </tr> </thead> <tbody> <tr><td>60</td><td>6.5</td></tr> <tr><td>65</td><td>7.0</td></tr> <tr><td>70</td><td>8.0</td></tr> <tr><td>75</td><td>8.5</td></tr> <tr><td>80</td><td>9.0</td></tr> <tr><td>85</td><td>10</td></tr> <tr><td>90</td><td>10.5</td></tr> <tr><td>95</td><td>11</td></tr> <tr><td>100</td><td>11.5</td></tr> <tr><td>105</td><td>12</td></tr> </tbody> </table>	Waist Size	A (cm)	60	8	65	8.5	70	9	75	9.5	80	10	85	10.5	90	11	95	11.5	100	12	105	12.5	Waist Size	B (cm)	60	6.5	65	7.0	70	8.0	75	8.5	80	9.0	85	10	90	10.5	95	11	100	11.5	105	12	
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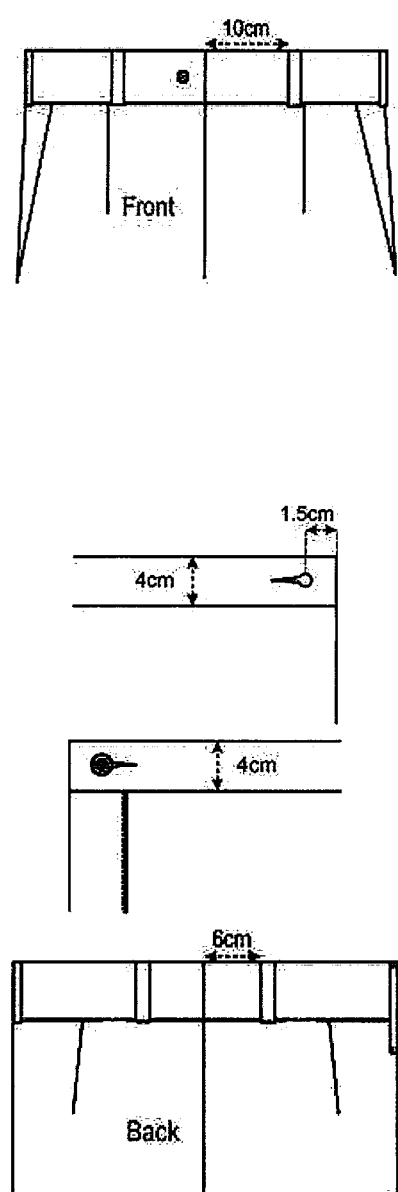
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.4 SIDE POCKETS</p> <p>Inside view</p> <p>Inside view</p> <p>Inside view</p>	<ul style="list-style-type: none"> <li>• 4cm from side seam</li> <li>• 16cm opening stayed with fusible tape</li> <li>• Tacked at each end</li> <li>• Top tack 2.5cm below waistband seam</li> <li>• Pocket bag 10cm deep, 13cm wide measured from bottom tack</li> <li>• Opening is 0.6cm topstitched</li> <li>• Pocket edges to be bound</li> <li>• With the top sewn into the waistband</li> <li>• The bag is tacked to the side seam 4cm below the bottom opening tack</li> </ul> <ul style="list-style-type: none"> <li>• Pocket facing is 4.5cm wide at the waist seam tapering 3cm below the bottom tack</li> <li>• Facing sewn in waistband seam</li> </ul> <ul style="list-style-type: none"> <li>• Pocket bearer is 8cm wide at the top tack</li> <li>• 4cm wide at the bottom tack</li> <li>• Bearer sewn in with waistband seam</li> <li>• Inner edges of bearer to be sewn</li> <li>• Or overedge and stitched down</li> </ul>	<p>1.06.02</p> <p>3.05.03</p>

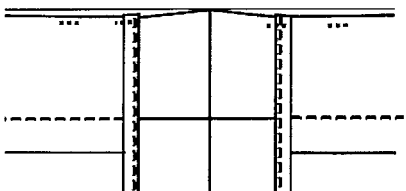
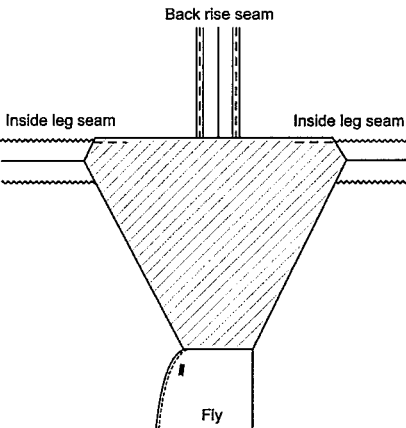
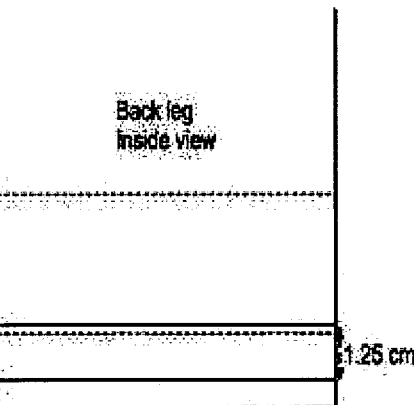
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.5 FRONT OPENING</p>  <p>Left side as worn</p> <p>4cm</p> <p>Slide fastener</p> <p>2cm</p> <p>Outside View</p> <p>Right side as worn</p> <p>2cm</p> <p>1.5cm</p> <p>Inside View</p>	<p><u>Left side as worn</u></p> <ul style="list-style-type: none"> <li>• A grown on facing 2cm wide</li> <li>• A lined slide fastener guard 4cm wide tapering at the base</li> <li>• The guard and slide fastener to be sewn to left topside</li> </ul> <p><u>Right side as worn</u></p> <ul style="list-style-type: none"> <li>• A grown on facing 2cm wide</li> <li>• Slide fastener stitched with one row through all layers</li> <li>• Positioned 1.5cm from opening edge</li> <li>• No joins permitted in this sewing</li> <li>• The outer edge of the facing and guard, are securely tacked together level with the fly tack</li> </ul>	

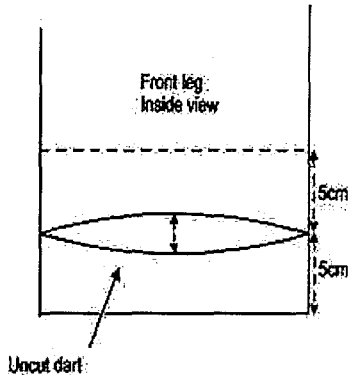
5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.6 WAISTBAND AND BELT LOOPS</p>  <p>Front</p> <p>Back</p>	<ul style="list-style-type: none"> <li>To have a fusible interlining</li> <li>To stay the buttonhole/button fusible to be double thickness</li> <li>Waistband depth 4cm</li> <li>Interlined with plain weave, cotton and concave reinforcement, lined with poly/cotton</li> <li>The concave side of the reinforcement is sewn to the interlining</li> <li>With a central row of stitching, 4 stitches per 2cm</li> </ul> <p><u>Right side as worn</u></p> <ul style="list-style-type: none"> <li>2cm long buttonhole</li> <li>Positioned centrally</li> <li>1.5cm from the right end of waistband</li> </ul> <p><u>Left side as worn</u></p> <ul style="list-style-type: none"> <li>Button sewn centrally on the left side waistband</li> <li>In register with the buttonhole</li> </ul> <p><u>Belt Loops</u></p> <ul style="list-style-type: none"> <li>Belt loops to be 1cm wide and 4cm effective length</li> <li>One to be positioned 10cm either side of the centre front</li> <li>One to be positioned 6cm either side of the centre back</li> <li>And one over each side seam</li> </ul>	<p>8.02.01</p>

5. **CONSTRUCTION continued**

PART	DETAIL	SEAM REF
<p>5.7 SEAT SEAM</p> 	<ul style="list-style-type: none"> <li>• Seat seam is bound and pressed open</li> <li>• Secured to the waistband lining with tacks each side</li> </ul>	<p>3.05.03</p>
<p>5.8 CROTCH LINING</p> 	<ul style="list-style-type: none"> <li>• Double ply triangular shape</li> <li>• Stitched to the bottom of the fly guard lining and tacked to the inside leg seams</li> </ul>	
<p>5.9 BOTTOMS</p> 	<ul style="list-style-type: none"> <li>• A length of nylon webbing 2.5cm wide</li> <li>• Folded down the centre to form a strip 1.25cm wide</li> <li>• The folded edge of webbing positioned 0.2cm from the bottom of the upturn</li> <li>• Sewn on the underside of each leg into the side seams</li> <li>• Top edge of the strip edge stitched through upturn</li> <li>• Stitches not to show on the outside of the garment</li> <li>• The ends to be caught in with the seams</li> <li>• Care should be taken to ensure the extra thickness does not create a point liable to cause extra wear</li> </ul>	


5. CONSTRUCTION continued

PART	DETAIL	SEAM REF
<p>5.9 BOTTOMS continued</p> 	<ul style="list-style-type: none"> <li>• 5cm up-turn</li> <li>• An uncut dart is formed to hollow the bottom of the leg over the instep</li> <li>• Dart to be 1cm on the double at the crease and tapering to nothing at the side and leg seams</li> <li>• Dart is not to show on the outside when the bottoms are finished</li> </ul>	<p>6.02.02</p>

## 6. LABELLING REQUIREMENTS






Labels	Position
Identification and care labels (can be combined to produce one label)	Right side waistband seam

### Identification Label

TROUSER, WOMAN'S, Army, No.2  Dress, All Ranks* 8410-99-671-7854* 70/60/84* Contract No. Name: No: Date of Manufacture: MM/YYYY <i>(Fibre content to be added here)</i>
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\*Amend as appropriate for end item

### Care Label

	DO NOT WASH
	DO NOT BLEACH
	DO NOT TUMBLE DRY
	DO NOT IRON
	Dry Clean Only

### Manufacturer Information

The contractor's name, logo or trademark should not appear on any labels, garment bags or packaging.

**7. TL NUMBER, NATO STOCK NUMBER AND SIZE**

TL Number	NATO Stock Number	Size
<b>KHAKI</b>		
TL1701329	8410-99-671-7854	70/60/84
TL1701330	8410-99-671-7855	70/65/89
TL1701331	8410-99-671-7856	70/70/94
TL1701332	8410-99-671-7857	70/75/99
TL1701333	8410-99-671-7858	70/80/104
TL1701334	8410-99-671-7859	75/60/84
TL1701335	8410-99-671-7860	75/65/89
TL1701336	8410-99-671-7861	75/70/94
TL1701337	8410-99-671-7862	75/75/99
TL1701338	8410-99-671-7863	75/80/104
TL1701339	8410-99-671-7864	75/85/109
TL1701340	8410-99-671-7865	75/90/114
TL1701341	8410-99-671-7866	75/95/119
TL1701342	8410-99-671-7867	80/65/89
TL1701343	8410-99-671-7868	80/70/94
TL1701344	8410-99-671-7869	80/75/99
TL1701345	8410-99-671-7870	80/80/104
TL1701346	8410-99-671-7871	80/85/109
TL1701347	8410-99-671-7872	80/90/114
TL1701348	8410-99-671-7873	80/95/119
TL1701349	8410-99-671-7874	80/100/124
TL1701350	8410-99-671-7875	80/105/129
TL1701351	8410-99-671-7876	85/65/89
TL1701352	8410-99-671-7877	85/70/94
TL1701353	8410-99-671-7878	85/75/99
TL1701354	8410-99-671-7879	85/80/104
TL1701355	8410-99-671-7880	85/85/109
TL1701356	8410-99-671-7881	85/90/114
TL1701357	8410-99-671-7882	85/95/119
TL1701358	8410-99-671-7883	85/100/124
TL1701359	8410-99-671-7884	85/105/129
TL1701360	8410-99-671-7885	Outsize



7. TL NUMBER, NATO STOCK NUMBER AND SIZE continued

TL Number	NATO Stock Number	Size
<b>THE ROYAL DRAGOON GUARDS</b>		
TL1702433	8410-99-847-6898	Outsize
<b>THE ROYAL HUSSARS</b>		
TL1702434	8410-99-847-6899	Outsize



**Technical Specification for  
CAP, SERVICE, Man's,  
No.1 and No.2 Dress, Regt and Corps  
(except Household Brigade)  
and the MOD Guard Service**

**Defence Clothing (DC)**

PROPERTY OF  
MINISTRY OF DEFENCE

**Defence Equipment & Support**



MINISTRY OF DEFENCE

PREFACE

TABLE 1 – PRODUCT LIST

Item Name	CAP, SERVICE, Man's, No.1 and No.2 Dress, Regts and Corps (except Household Brigade) and the MOD Guard Service	
<b>NATO Stock Numbers</b>	<b>Regiment</b>	<b>Pattern No.</b>
8405-99-136-0002 to 0014	Royals and Royal Military Academy Sandhurst (RMAS)	20350B
8405-99-136-0162 to 0174	Non Royals	20351B
8405-99-136-0021 to 0028	The Queen's Dragoon Guards (QDG)	28358A
8405-99-132-2652 to 2661	The Royal Scots Dragoon Guards (Scots DG)	20328A
8405-99-136-0036 to 0045	Royal Dragoon Guards (RDG)	28359A
8405-99-136-0228 to 0238	Queen's Royal Hussars (QRH) & Light Dragoons (LD)	28360A
8405-99-136-0389 to 0399	The Royal Lancers (RL)	20357
8405-99-136-0197 to 0204	The King's Royal Hussars (KRH)	28362
8405-99-136-0322 to 0334	Royal Engineers (RE), Military Provost Staff (MPS)	20354B
8405-99-136-0178 to 0190	Royal Signals (RS)	28363A
8405-99-136-0356 to 0366	The Rifles and The Royal Yeomanry (RY)	20355A
8405-99-136-0084 to 0094	Royal Army Veterinary Corps (RAVC) and Royal Army Medical Corps (RAMC)	28366A
8405-99-136-0100 to 0108	Royal Army Dental Corps (RADC)	28367A
8405-99-978-9839 to 9851	Royal Logistics Corps (RLC)	27499A
8405-99-978-9940 to 9952	Queen Alexandra Royal Army Nursing Corps (QARANC)	27551
8405-99-130-6451 to 6462	Ministry of Defence Guard Service (MGS)	28043A

PREFACE continued

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

IPR STATEMENT

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**Technical documents in this specification refer to the edition current at the date of tender or contract unless otherwise stated.**

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TABLE 2 – ISSUE RECORD

Issue No	Comments	Issue Date
27	QRH NSN 136-0226 was made obsolete at Issue 19 but not deleted from body of spec. This is now corrected.	08 February 2024
26	20354B renamed to remove Drum Major and Drummers as no longer worn by them due to introduction of RCAM uniform	17 March 2023
25	Reference to UK/SC/4687 replaced with UK/SC/7011	25 April 2022
24	Pattern Numbers updated	11 February 2022
23	NSN range 8405-99-136-0067 to 0078 deleted as obsolete, superseded by 8405-99-136-0084 to 0094 to be used by both RAMC and RAVC TL numbers added	15 April 2021
22	Formatting updated Regiment names checked and updated throughout Table 1: 20354 pattern number updated to A version Table 4 Para 4.2: BS 4560 for lining deleted and replaced with Table 9 to rationalise with other headwear specifications Table 4 Para 4.7: Band stiffener options for buckram and glued hessian deleted as these materials are becoming increasingly hard to source and have not been used in this headwear for at least six years Table 4 Para 4.13: Wire for crown updated Table 4 Para 4.14: NSN 8315-99-973-0787 deleted as no longer called up in UK/SC/4687	15 February 2018
21	Specification formatting amended Page 2 – Royal Army Dental Corps (RADDC) outsize NSN 8405-99-136-0111 deleted as no longer used Page 6 - Related specifications and documents reviewed and labelling requirements updated 8849B Scarlet removed as obsolete and replaced with 8849Z Tunic Scarlet Queen's Royal Lancers (QRL) NSN range 8405-99-136-0422 to 0429 deleted as no longer used	06 October 2016
20	Description change from RGJ to The Rifles and The Yeomanry, NSN8405-99-136-0356 to 0366, pattern number 20355 Added full title description	07 July 2011

TABLE 2 – ISSUE RECORD continued

Issue No	Comments	Issue Date
19	<p>Pattern 8204B superseded by 8849C</p> <p>NSN's amended (not live on ISIS/SS3) 136-0000 - 0015 to 136-0002 - 0014; 136-0160 - 0175 to 136-0162 - 0174; 136-0021 - 0031 to 136-0021 - 0028; 132-2652 - 2663 to 132-2652 - 2661; 136-0047 deleted not on ISIS/SS3; 136-0225 - 0239 to 136-0226 &amp; 136-0228 - 0238; 136-0385 - 0400 to 136-0389 - 0399; 136-0195 - 0207 to 136-0197 - 0204; 136-0417 - 0432 to 136-0422 - 0429; 136-0321 - 0335 to 136-0322 - 0334; 136-0176 - 0191 to 136-0178 - 0190; 136-0352 - 0367 to 136-0356 - 0366; 136-0064 - 0079 to 136-0067 - 0078; 136-0095 to 0094; 136-0096 to 0100; 136-0288 - 0303 deleted as inactive on ISIS/SS3; 978-9852 to 9851; 978-9938 - 9953 to 978-9940 - 9952</p>	11 April 2011
19	<p>All reference to range NSN 8405-99-136-0261 to 0269 &amp; 136-0271 Pattern No. 29361 QRIH has been deleted</p> <p>Pattern No. 20350A updated</p> <p>Reformatted to remove IPT references</p> <p>Para 4.6 bow for head leather inserted, following para's re-numbered</p>	11 April 2011
18	<p>Reformatted to DE&amp;S template</p> <p>Updated specs &amp; docs</p>	12 November 2008
17	<p>All Spec – The Royals Cap (NSN 8405-99-136-0000 to 0015) will now be used by RMAS as well</p>	23 August 2005
16	<p>All spec - Honourable Artillery Company Cap NSN 8405-99-136-0368 to 0384 Pattern No.20356A has been removed from the specification</p> <p>The HAC Cap has been transferred to UK/SC/3979 Cap No 1 Dress Footguards</p> <p>All spec - Change Title from Police Constable MGS and Sergeants to MGS</p>	14 February 2005
15	<p>Page 6 and 7 – All reference to UK/SC/5594 and Pattern 8236A deleted. Pattern 8849J inserted</p> <p>Page 8 – Correction to dimensions in para 4.6</p> <p>Page 19 – Pattern 8849J inserted. Pattern 8236A deleted</p>	22 September 2004
14	<p>Table 7, Measurements - Peak Length - Reverted back to original measurement in previous issues of 23cm</p> <p>Table 4, Product Components – 4.1 Amended typing error and included all fabrics detailed in Table 8</p>	09 March 2004

TABLE 2 – ISSUE RECORD continued

<b>Issue No</b>	<b>Comments</b>	<b>Issue Date</b>
13	New format, changes to size schedule, changes to main materials	14 August 2003
12	Size and NSN schedule added	04 April 2002

PART 1

1. THE PRODUCT

- a. Use of the Product A peaked cap for wear with No.1 or No.2 Dress by Regiments and Corps (except Household Brigade) and the Ministry of Defence Guard Service.

FIGURE 1

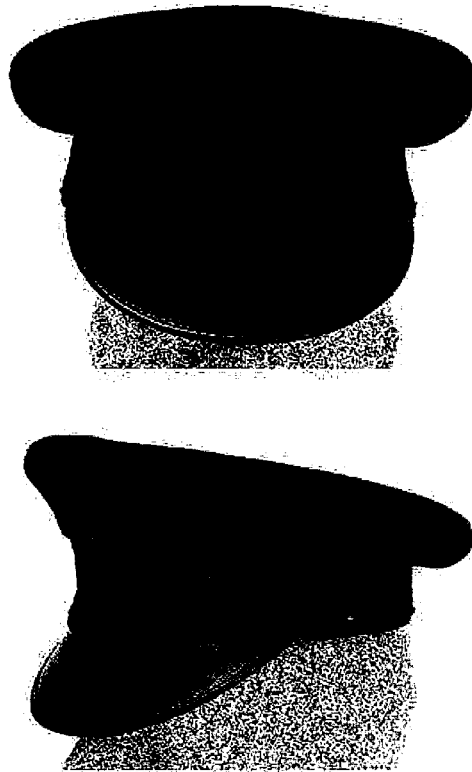




TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

Specification/Document	Detail
BS EN ISO 105 Part E04 Part X12	Textiles. Tests for colour fastness Colour fastness to perspiration Colour fastness to rubbing
BS EN ISO 139	Textiles. Standard atmospheres for conditioning and testing
BS EN ISO 845	Cellular plastics and rubbers. Determination of apparent (bulk) density
BS EN 12590	Textiles. Industrial sewing threads made wholly or partly made from synthetic fibres
BS 2780	Glossary of leather terms
BS 3412	Methods of specifying general purpose polyethylene materials for moulding and extrusion
BS 3870 Part 1 Part 2	Stitches and seams Classification and terminology of stitch type Classification and terminology of seam type
UK/SC/5126	Insignia, buttons, pins and titles, manufactured from gilding metal, brass and nickel silver
UK/SC/5516	Cloth, melton, wool, for dress uniforms
UK/SC/5628	Cloth, velvet, cotton and silk, WR
UK/SC/5696	Leather, sheep, head leathers
UK/SC/7011	Narrow Fabrics, 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 Service cap with patent peak, crown, bevel and band piping. The design and dimensions of the cap are as stated in Tables 7 and 8. The size schedule provides for up to thirteen sizes and outsize depending on cap.

TABLE 4 – PRODUCT COMPONENTS

<p>4.1 Crown tip and bevel, band and piping</p> <ul style="list-style-type: none"> <li>Cloth, Melton, Wool, Plain Weave</li> <li>395 – 420 g/m<sup>2</sup></li> <li>Blown finish</li> <li>Shade and finish to match Pattern No. 8849 specified</li> <li>Colourfastness &amp; steam shrinkage requirements to meet those in UK/SC/5516</li> </ul>	<ul style="list-style-type: none"> <li>Details as specified in Table 8; to conform to UK/SC/5516 shades as specified below</li> </ul>																																				
	<table border="1"> <thead> <tr> <th>Pattern No.</th> <th>Colour</th> <th>NATO Stock No</th> </tr> </thead> <tbody> <tr> <td>8849A</td> <td>Red</td> <td>8305-99-869-4372</td> </tr> <tr> <td>8849C</td> <td>Crimson</td> <td>8305-99-869-4374</td> </tr> <tr> <td>8849E</td> <td>Rifle Green</td> <td>8305-99-869-4376</td> </tr> <tr> <td>8849F</td> <td>White</td> <td>8305-99-869-4377</td> </tr> <tr> <td>8849J</td> <td>Dark Navy</td> <td>8305-99-869-4380</td> </tr> <tr> <td>8849K</td> <td>Yellow</td> <td>8305-99-869-4381</td> </tr> <tr> <td>8849L</td> <td>Grey</td> <td>8305-99-869-4382</td> </tr> <tr> <td>8849P</td> <td>Light Navy</td> <td>8305-99-869-5466</td> </tr> <tr> <td>8849W</td> <td>Guards Green</td> <td>8305-99-471-3333</td> </tr> <tr> <td>8849U</td> <td>Navy</td> <td>8305-99-471-3331</td> </tr> <tr> <td>8849Z</td> <td>Tunic Scarlet</td> <td>8305-99-666-6727</td> </tr> </tbody> </table>	Pattern No.	Colour	NATO Stock No	8849A	Red	8305-99-869-4372	8849C	Crimson	8305-99-869-4374	8849E	Rifle Green	8305-99-869-4376	8849F	White	8305-99-869-4377	8849J	Dark Navy	8305-99-869-4380	8849K	Yellow	8305-99-869-4381	8849L	Grey	8305-99-869-4382	8849P	Light Navy	8305-99-869-5466	8849W	Guards Green	8305-99-471-3333	8849U	Navy	8305-99-471-3331	8849Z	Tunic Scarlet	8305-99-666-6727
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<ul style="list-style-type: none"> <li>Cloth, velvet, blue, to UK/SC/5628, Pattern No. 8865B</li> <li>Or a suitable alternative to be approved by DC</li> </ul>																																					
<p>4.2 Crown, bevel and band lining</p> <ul style="list-style-type: none"> <li>Cloth, twill viscose, plain weave polyester or plain weave viscose</li> <li>All linings to be grey or black to meet the colour fastness requirements of Table 9</li> </ul>																																					
<p>4.3 Crown disc</p> <ul style="list-style-type: none"> <li>Colourless cellulose acetate sheet or polyethylene film or PVC sheeting not less than 0.1mm or more than 0.3mm thick</li> </ul>																																					
<p>4.4 Interlining, crown, bevel and piping</p> <ul style="list-style-type: none"> <li>Flexible polyurethane, having cells of uniform size, not less than 3mm or more than 5mm thick and conforming to the requirements of Table 11</li> </ul>																																					

TABLE 4 – PRODUCT COMPONENTS continued

4.5 Head leather	<ul style="list-style-type: none"> <li>Leather, sheep, basil, at least 1.0mm, but no more than 1.3mm thick, to UK/SC/5696</li> <li>The term basil is defined in BS 2780</li> <li>Or an imitation leather of poromeric quality</li> <li>Or a suitable alternative to be approved by DC</li> </ul>
4.6 Bow for head leather	<ul style="list-style-type: none"> <li>Braid, white or fawn, 13mm +/- 1mm</li> </ul>
4.7 Band stiffener (in order of preference)	<ul style="list-style-type: none"> <li>High density polyethylene sheet, 1.0mm thickness <math>\pm</math> 0.10mm, either solid or perforated</li> <li>Or, air expanded plastic 1.2mm thickness</li> <li>Or, high density polypropylene sheet 1.0mm thickness <math>\pm</math> 0.10 mm, either solid or perforated</li> </ul>
4.8 Peak	<ul style="list-style-type: none"> <li>Flexible PVC, black/beige laminate with black side polished and beige side flock sprayed, approximately 1.0mm thick laminated to flexible vulcanised fibre or flexible fibreboard</li> <li>Or two part laminate, polyester/cotton, impregnated with polyurethane with black patent finish approximately 1.0mm thick, laminated to polypropylene/polyethylene, surface finish leather grain, colour to be bottle green, approximately 1.5mm thick</li> <li>Total thickness of peaks to be no less than 2.5mm and no more than 2.8mm</li> <li>To comply with the requirements of Table 13</li> </ul>
4.9 Lining for peak (except two part laminate)	<ul style="list-style-type: none"> <li>Skiver green or imitation skiver green embossed cotton backed plastic</li> <li>The term skiver is defined in BS 2780</li> <li>The peak lining fabric is to conform to Table 10</li> <li>Or a suitable alternative to be approved by DC</li> </ul>
4.10 Binding for peak	<ul style="list-style-type: none"> <li>PVC, black, 0.6mm thick</li> </ul>
4.11 Binding stiffener at peak	<ul style="list-style-type: none"> <li>Cloth, velveteen, black to comply with the requirements of UK/SC/5628</li> <li>Or a suitable alternative to be approved by DC</li> </ul>
4.12 Support for front	<ul style="list-style-type: none"> <li>High density polyethylene conforming to BS 3412 Section 3, Type A, Class Q, 1.0 to 1.3mm thick</li> </ul>

TABLE 4 – PRODUCT COMPONENTS continued

4.13 Wire for crown	<ul style="list-style-type: none"> <li>• Spring steel, 3mm to 5mm x 0.5mm or spring steel wire, 2mm, corrosion resistant, ends securely fastened</li> <li>• Or a suitable alternative to be approved by DC</li> </ul>
4.14 Additional headband Pattern No. 20355A	<ul style="list-style-type: none"> <li>• Braid, worsted, textile, flat, black, 44mm, to UK/SC/7011, Pattern No. 9337A</li> </ul>
4.15 Badge Holder except Pattern No. 28363A	<ul style="list-style-type: none"> <li>• Brass as on the standard pattern</li> <li>• Or a suitable alternative to be approved by DC</li> </ul>
4.16 Buttons for Pattern No. 28043A MGS	<ul style="list-style-type: none"> <li>• Button, Insignia, 14mm, MOD Constabulary and Army Fire Brigade, UK/SC/5126, Pattern No. 15914, NSN 8455-99-973-0374</li> </ul>
4.17 Chinstrap for Pattern No. 28043A MGS	<ul style="list-style-type: none"> <li>• PVC black, 10mm wide by 480mm long</li> <li>• At least 1.0mm but not more than 1.3mm thick with buckles as per standard pattern</li> </ul>
4.18 Sewing thread for all purposes	<ul style="list-style-type: none"> <li>• Thread, polyester/cotton, corespun to BS EN 12590 Table 5, shades to match cap</li> <li>• Ticket No. 25 for peak to stiffener</li> <li>• Ticket No. 36 for bevel, band, sewing in crown, back and front finishing, lining and all hand sewing</li> <li>• Ticket No. 75 for all other sewing</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION

<p>5.1 Crown</p>	<ul style="list-style-type: none"> <li>• The crown tip, oval in shape, is to comply with the measurements set out in Table 7, the measurements are to be taken from the crown tip piping seam</li> <li>• The perimeter of the crown tip is to have a piped edge joined in line with the back seam of the bevel quarters</li> <li>• The crown and piping are to be combined to the interlining</li> <li>• The interlining is to be bonded to the outer material and the laminate produced is to comply with the requirements set out in Table 12</li> <li>• The bond is to be continuous to ensure that the outer material is free from blisters</li> </ul>
<p>5.2 Bevel</p>	<ul style="list-style-type: none"> <li>• The bevel, combined to interlining as in 5.1, is to be quartered with the seams opened and pressed flat</li> <li>• The band/bevel seam is to be pressed open at the centre front to the side bevel seams only</li> </ul>
<p>5.3 Band</p>	<ul style="list-style-type: none"> <li>• The band is to be constructed as detailed in Table 8</li> </ul>
<p>5.4 Additional headband for Pattern No. 20355A</p>	<ul style="list-style-type: none"> <li>• The additional headband is to be fitted with the join at the centre front, seamed 1.5cm, be pressed flat with the corners turned in and secured to prevent fraying</li> </ul>
<p>5.5 Band stiffener</p>	<ul style="list-style-type: none"> <li>• The stiffener is to be cut sufficiently long to allow a 2cm overlap where it is joined at the back of the cap, slightly offset to reduce thickness</li> <li>• The stiffener is to be stitched through the outer material immediately below the stitched out welt or through the seam joining the two piece band, and basted to the band/bevel seam</li> <li>• The stiffener is to be oval (head shaped) to eliminate undue pressure on the wearer's head</li> </ul>
<p>5.6 Lining</p>	<ul style="list-style-type: none"> <li>• The crown lining is to be sewn in with the crown tip piping seam and be securely attached at the bottom edge of the stiffener by hand or machine stitching or securely glued with a suitable adhesive</li> <li>• The lining is to be cut deep enough to allow the side and back bevel to roll without distortion</li> <li>• A detachable transparent disc, sufficient to cover the crown tip is to be inserted on top of the crown lining</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION continued

<p>5.7 Peak</p>	<ul style="list-style-type: none"> <li>• The peak, black side uppermost, chamfer edged on the brow line and lined on the underside is to be identical in shape to that of the standard pattern</li> <li>• The outer edge is to be bound with black PVC, 0.6cm deep when finished</li> <li>• When fitted the peak is to be correctly balanced and central to the front seam of the bevel quarters</li> <li>• The peak may be fitted to the band stiffener by sewing the inner edge of the peak to either the inner or outer edge of the stiffener</li> <li>• The seam allowance from seam to inner peak edge is not to be less than 0.3cm and not more than 0.5cm</li> <li>• When fitting the peak to the outer edge of the stiffener, the bottom edge of the stiffener is to be bound with velveteen</li> <li>• When fitting the peak to the inner edge of the stiffener, a strip of velveteen, depth 2.5cm is to be sewn to the head leather prior to attaching the head leather to the cap, extending the length of the peak</li> <li>• The peak is to be securely sewn on to the stiffener with approximately four stitches per 2cm</li> </ul>
<p>5.8 Head leather</p>	<ul style="list-style-type: none"> <li>• Each cap is to have a brachered head leather, the ends of which are to be overlapped not less than 1cm and not more than 4cm at the centre back of the cap and tacked together at the top edge through a braid bow</li> <li>• The taping on the head leather may be sewn to the band by hand or machine, but in neither case is the head leather to show below the bottom edge of the band</li> </ul>
<p>5.9 Crown wire</p>	<ul style="list-style-type: none"> <li>• A cap wire with a connecting tube is to be fitted on the inside of the piping of the crown</li> </ul>
<p>5.10 Button position and chinstrap position Pattern No. 28043A</p>	<ul style="list-style-type: none"> <li>• The button position is to be indicated on each side of the cap by sewing a small piece of knotted white sewing thread or a plastic tag 0.6cm from the bottom edge of the band and in line with the side seam of the bevel</li> <li>• Buttons Insignia to be attached to the band/welt seam in line with the cap side bevels</li> <li>• Chinstrap as specified to be attached</li> </ul>

TABLE 5 – PRODUCT CONSTRUCTION continued

<p>5.11 Front support</p>	<ul style="list-style-type: none"> <li>• The support is to have a curved top edge and be securely attached to the band stiffener, positioned at the centre front and 1.5cm below the top edge</li> <li>• The front support is not to protrude above the crown/bevel seam</li> </ul>
<p>5.12 Badge holder (except Pattern No. 28363A)</p>	<ul style="list-style-type: none"> <li>• The badge holder is to be fitted vertically between the band and the stiffener at the centre front of the cap, with the socket next to the band. The projection at the top of the holder protruding on the outside 0.5cm above the band/bevel seam or, where relevant, the band piping/bevel seam</li> <li>• The holder is to be securely sewn, through the holes in the sides to the stiffener. The opening, made in the band/bevel or band piping/bevel seam to accommodate the shank of the badge, is to be securely tacked at each side of the badge holder</li> </ul>
<p>5.13 Bevel roll Pattern No. 28043A</p>	<ul style="list-style-type: none"> <li>• The front bevel is to be padded, so as to give the same effect and appearance as that of the standard pattern</li> </ul>
<p>5.14 Seams and stitching to BS3870</p>	<ul style="list-style-type: none"> <li>• Machine stitching is to be stitch type 301, with at least eight but not more than ten stitches per 2cm</li> <li>• The piping is to be formed using seam type 1.12.01</li> <li>• The binding on the peak is to be formed using seam type 3.01.01</li> <li>• The brachering on the head leather is to be stitch type 304 with at least six stitches per 2cm</li> <li>• The felling on the head leather is to have at least six stitches per 2cm</li> <li>• The peak is to be sewn to the stiffener with approximately four stitches per 2cm</li> </ul>
<p>5.15 General</p>	<ul style="list-style-type: none"> <li>• Sewing threads may be treated with a stain free lubricant</li> <li>• All seams are to be free from pucker</li> <li>• The cap is to be free from all ends of sewing thread, be blocked and pressed and delivered in a clean condition</li> <li>• The surface of the peak is to be free from cracking and other defects</li> </ul>

TABLE 6 – SCHEDULE OF TL NUMBERS, NATO STOCK NUMBERS AND SIZES

Regt or Corp	50	51	52	53	54	55	56	57	58	59	60	61	62	Outsize
	NATO Stock Numbers 8405-99-													
Royals and RMAS	136-0002	136-0003	136-0004	136-0005	136-0006	136-0007	136-0008	136-0009	136-0010	136-0011	136-0012	136-0013	136-0014	-
<b>TL Number</b>	1031991	1031992	1031993	1031994	1031995	1031996	1031997	1031998	1031999	1032000	1032001	1032002	1032003	-
Non Royals	136-0162	136-0163	136-0164	136-0165	136-0166	136-0167	136-0168	136-0169	136-0170	136-0171	136-0172	136-0173	136-0174	-
<b>TL Number</b>	1032054	1032055	1032056	1032057	1032058	1032059	1032060	1032061	1032062	1032063	1032064	1032065	1032066	-
QDG	-	-	-	136-0021	136-0022	136-0023	136-0024	136-0025	136-0026	136-0027	136-0028	-	-	-
<b>TL Number</b>	-	-	-	1032004	1032005	1032006	1032007	1032008	1032009	1032010	1032011	-	-	-
Scots DG	-	-	132-2652	132-2653	132-2654	132-2655	132-2656	132-2657	132-2658	132-2659	132-2660	132-2661	-	-
<b>TL Number</b>	-	-	1031704	1031705	1031706	1031707	1031708	1031709	1031710	1031711	1031712	1031713	-	-
RDG	-	-	136-0036	136-0037	136-0038	136-0039	136-0040	136-0041	136-0042	136-0043	136-0044	136-0045	-	-
<b>TL Number</b>	-	-	1032012	1032013	1032014	1032015	1032016	1032017	1032018	1032019	1032020	1032021	-	-
QRH & LD	-	-	136-0228	136-0229	136-0230	136-0231	136-0232	136-0233	136-0234	136-0235	136-0236	136-0237	136-0238	-
<b>TL Number</b>	1032088	-	1032089	1032090	1032091	1032092	1032093	1032094	1032095	1032096	1032097	1032098	1032099	-
RL	-	-	136-0389	136-0390	136-0391	136-0392	136-0393	136-0394	136-0395	136-0396	136-0397	136-0398	136-0399	-
<b>TL Number</b>	-	-	1032138	1032139	1032140	1032141	1032142	1032143	1032144	1032145	1032146	1032147	1032148	-
KRH	-	-	-	136-0197	136-0198	136-0199	136-0200	136-0201	136-0202	136-0203	136-0204	-	-	-
<b>TL Number</b>	-	-	-	1032080	1032081	1032082	1032083	1032084	1032085	1032086	1032087	-	-	-
RE, MPS	136-0322	136-0323	136-0324	136-0325	136-0326	136-0327	136-0328	136-0329	136-0330	136-0331	136-0332	136-0333	136-0334	-
<b>TL Number</b>	1032100	1032101	1032102	1032103	1032104	1032105	1032106	1032107	1032108	1032109	1032110	1032111	1032112	-
RS	136-0178	136-0179	136-0180	136-0181	136-0182	136-0183	136-0184	136-0185	136-0186	136-0187	136-0188	136-0189	136-0190	-
<b>TL Number</b>	1032067	1032068	1032069	1032070	1032071	1032072	1032073	1032074	1032075	1032076	1032077	1032078	1032079	-



TABLE 6 – SCHEDULE OF TL NUMBERS, NATO STOCK NUMBERS AND SIZES continued

Regt or Corp	50	51	52	53	54	55	56	57	58	59	60	61	62	Outsize
	NATO Stock Numbers 8405-99-													
The Rifles & RY	-	-	136-0356	136-0357	136-0358	136-0359	136-0360	136-0361	136-0362	136-0363	136-0364	136-0365	136-0366	-
<b>TL Number</b>	-	-	1032113	1032114	1032115	1032116	1032117	1032118	1032119	1032120	1032121	1032122	1032123	-
RAVC and RAMC	-	-	136-0084	136-0085	136-0086	136-0087	136-0088	136-0089	136-0090	136-0091	136-0092	136-0093	136-0094	-
<b>TL Number</b>	-	-	1032034	1032035	1032036	1032037	1032038	1032039	1032040	1032041	1032042	1032043	1032044	-
RADC	-	-	136-0100	136-0101	136-0102	136-0103	136-0104	136-0105	136-0106	136-0107	136-0108	-	-	-
<b>TL Number</b>	-	-	1032045	1032046	1032047	1032048	1032049	1032050	1032051	1032052	1032053	-	-	-
RLC	978-9839	978-9840	978-9841	978-9842	978-9843	978-9844	978-9845	978-9846	978-9847	978-9848	978-9849	978-9850	978-9851	-
<b>TL Number</b>	1035826	1035827	1035828	1035829	1035830	1035831	1035832	1035833	1035834	1035835	1035836	1035837	1035838	-
QARANC	978-9940	978-9941	978-9942	978-9943	978-9944	978-9945	978-9946	978-9947	978-9948	978-9949	978-9950	978-9951	978-9952	-
<b>TL Number</b>	1035839	1035840	1035841	1035842	1035843	1035844	1035845	1035846	1035847	1035848	1035849	1035850	1035851	-
MGS	-	-	130-6451	130-6452	130-6453	130-6454	130-6455	130-6456	130-6457	130-6458	130-6459	130-6460	130-6461	130-6462
<b>TL Number</b>	-	-	1031318	1031319	1031320	1031321	1031322	1031323	1031324	1031325	1031326	1031327	1031328	1031329

TABLE 7 – MEASUREMENTS AND TOLERANCES

All measurements are in centimetres unless otherwise stated.

Size and Internal Circumference		50	51	52	53	54	55	56	57	58	59	60	61	62	Outsize	Tolerances +/- (mm)
Crown 1.2 Oval	Length	25.5	25.8	26.1	26.4	26.7	27.0	27.3	27.6	27.9	28.2	28.5	28.8	29.1	-	2
	Width	24.3	24.6	24.9	25.2	25.5	25.8	26.1	26.4	26.7	27	27.3	27.6	27.9	-	2
Bevel Depth		5														2
Band Width		5														2
Peak Depth	Centre front	5														1
Peak Length	From point to point	23														5
Head leather		4														2
Stiffener		5.5														2
Front support		6.5														2

TABLE 8 – CAP, SERVICE, No.1 and No.2 Dress Regts &amp; Corps (except Household Brigade) and MGS

Serial No	NSN 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
1	136-0002 to 0014	<b>Royals &amp; RMAS</b> RA, R Anglian, Duke of Lancaster's Regiment, RWF (WO1 only) RRW, REME, SASC, DYRMS, PWRR, RLC, AGC, Rifles, RMAS	20350B	<b><u>Number 1</u></b> The band is to be constructed in two parts. The top portion is to be 44mm wide and the bottom portion 6mm wide. The seam is to be pressed open. Upper band to be joined at centre back. The seam joining the bottom portion is to be in line with the side bevel seam.	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton Wool, Tunic Scarlet, Pattern No. 8849Z and Navy Pattern No. 8849U	Cloth, Melton, Wool, Tunic Scarlet, Pattern No. 8849Z
2	136-0162 to 0174	<b>Non Royals</b> Yorks, Mercians, Rifles, APTC, Army Apprentices College Birmingham, Bristol, Gloucester, Northumbrian, Leeds, Liverpool, London, Manchester, East Midlands, Oxford, Queen's (Belfast) & Sheffield University OTC	20351B	<b><u>Number 2</u></b> The band cut from one piece of cloth, is to be joined at the centre back of the cap in line with the seam of the bevel quarters. The band is to have a stitched out welt 6mm from the bottom edge formed with one row of stitching made to comply with seam type 6.05.01 of BS 3870.	Cloth, Melton, Wool, Navy, Pattern No. 8849U		Cloth, Melton, Wool, Tunic Scarlet, Pattern No. 8849Z

TABLE 8 – CAP, SERVICE, No.1 and No.2 Dress Regts &amp; Corps (except Household Brigade) and MGS continued

Serial No	NSN 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
3	136-0021 to 0028	<b>QDG</b>	28358A	<b><u>As Number 1</u></b>	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, velvet, blue 8865B and Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, velvet, blue, 8865B
4	132-2652 to 2661	<b>Scots DG</b>	20328A	<b><u>As Number 2</u></b> In addition, a cloth vandyked band of 13 points is to be superimposed and edge stitched to the headband with the points terminating at the waist seam and the welt. The vandyking is to be of uniform size and shape and measure 16mm across the bars when measured at right angles to the line of the vandyking.	Cloth, Melton, Wool, Navy, Pattern No. 8849U, and Vandyked with Cloth, Melton, Wool, Yellow, Pattern No. 8849K		Cloth, Melton, Wool, Yellow, Pattern No. 8849K
5	136-0036 to 0045	<b>RDG</b>	28359A	<b><u>As Number 1</u></b>	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool Light Navy, Pattern No. 8849P and Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Light Navy, Pattern No. 8849P

TABLE 8 – CAP, SERVICE, No.1 and No.2 Dress Regts & Corps (except Household Brigade) and MGS continued

Serial No	NSN 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
6	136-0228 to 0238	QRH & LD	28360A	<u>As Number 2</u>	Cloth, Melton, Wool, Tunic Scarlet, Pattern No. 8849Z		
7	136-0389 to 0399	RL	20357A	<u>As Number 1</u> In addition, the waist seam, bevel quarter seams and the seam joining the top and bottom portion of the band are to be piped	Cloth, Melton, Wool, Tunic Scarlet, Pattern No. 8849Z	Cloth, Melton, Wool, Navy, Pattern No. 8849U (and bevel quarter, waist seam and band seam piping)	
8	136-0197 to 0204	KRH	28362	<u>As Number 2</u>	Cloth, Melton, Wool, Crimson, Pattern No. 8849C		
9	136-0322 to 0334	RE, MPS 71(SC) Engr Regt, 74 (Antrim Arty) Engr Regt	20354B	<u>As Number 2</u> In addition, the waist seam is to be piped	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Tunic Scarlet, Pattern No. 8849Z (and waist seam piping)	
10	136-0178 to 0190	RS	28363A	<u>As Number 2</u> But without badge holder	Cloth, Melton, Wool, Navy, Pattern No. 8849U		
11	136-0356 to 0366	The Rifles & RY	20355A	<u>As Number 1</u> In addition, the waist seam & the seam joining the top & bottom portions of the band are to be piped. A detachable band of black braid is to be fitted	Cloth, Melton, Wool, Rifle Green, Pattern No. 8849E Additional band, Braid, Worsted, Black, 44mm, Pattern No. 9337A	Cloth, Melton, Wool, Dark Navy, Pattern No. 8849J (and waist seam and band seam piping)	

TABLE 8 – CAP, SERVICE, No.1 and No.2 Dress Regts &amp; Corps (except Household Brigade) and MGS continued

Serial No	NSN 8405-99-	Regiment or Corps	Pattern No	Make up of headband	Body material	Band material	Crown piping
12	136-0084 to 0094	RAVC and RAMC	28366A	<u>As Number 1</u>	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Crimson, Pattern No. 8849C and Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Crimson, Pattern No. 8849C
13	136-0100 to 0108	RADC	28367A	<u>As Number 1</u>	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Guards Green, Pattern No. 8849W and Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Guards Green, Pattern No. 8849W
14	978-9839 to 9851	RLC	27499A	<u>As Number 1</u>	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, velvet, blue, 8865B and Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Tunic Scarlet, Pattern No. 8849Z
15	978-9940 to 9952	QARANC	27551	<u>The cloth band is constructed in three parts. Scarlet stripes to be 2cm and centre Grey stripe to be 1cm. Seams to be pressed open</u>	Cloth, Melton, Wool, Navy, Pattern No. 8849U	Cloth, Melton, Wool, Tunic Scarlet, Pattern No. 8849Z and Grey, Pattern No. 8849L	Cloth, Melton, Wool, Navy, Pattern No. 8849U
16	130-6451 to 6462	MGS	28043A	<u>As Number 2</u>	Cloth, Melton, Wool, Navy, Pattern No. 8849U		

TABLE 9 – TEST REQUIREMENTS – CROWN, BEVEL AND BAND LINING

Method of Test BS EN ISO 105		
Part E04		Part X12
Perspiration		Rubbing wet
Staining	Colour Change	Colour Change
4-5	5	4

TABLE 10 – TEST REQUIREMENTS - PEAK LINING

Agency	Rating for staining	Method of Test
Rubbing wet	4	BS EN ISO 105 (X12)

TABLE 11 – TEST REQUIREMENTS - FLEXIBLE POLYURETHANE FOAM

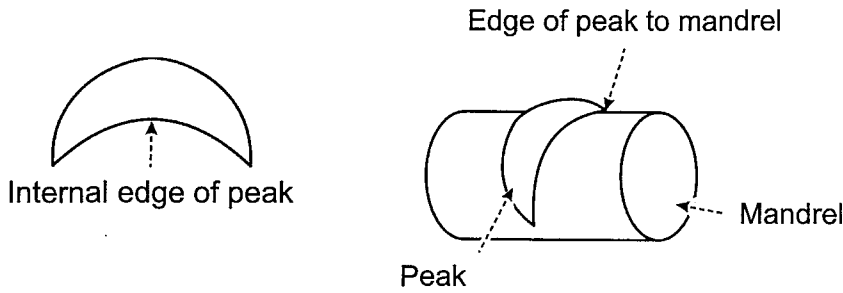
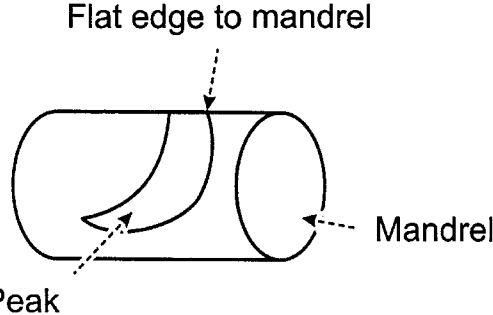
Property	Requirement	Method of Test
Apparent density kg/m <sup>3</sup>	25 - 30	BS EN ISO 845

TABLE 12 – METHOD OF TEST

Determination of fabric/foam laminate bond strength. The minimum bond strength of the laminated fabric is to be 1.25N/25mm when determined by the following method:

12.1 Sample preparation	<ul style="list-style-type: none"> <li>Specimens which have been conditioned for 24 hours in the standard testing atmosphere defined in BS EN ISO 139 are to be cut 200mm x 25mm with at least two samples being cut with the 200mm dimension in the warp and weft direction respectively</li> </ul>
12.2 Procedure	<ul style="list-style-type: none"> <li>The conditioned samples are to be delaminated by hand for 100mm</li> <li>The tails are to be clamped in the jaws of a CRE tensile testing machine</li> <li>The sample is then to be peeled apart with a jaw separation of 100mm/min for a 50mm length of sample</li> </ul>
12.3 Calculation and expression of results	<ul style="list-style-type: none"> <li>The maximum value of peel bond strength is to be recorded for each sample that peels for 50mm without the foam breaking</li> <li>If the foam does break during delamination this fact is to be noted and the value at break recorded</li> <li>The mean value of two results for samples, which delaminate for 50mm without the foam breaking, is to be calculated in the warp and weft direction respectively</li> </ul>

TABLE 13 – TEST FOR THE DELAMINATION OF PEAKS

<p>13.1 Test procedure</p>	<ul style="list-style-type: none"> <li>Four cap peaks (detached from caps) are to be taken from batches of up to 500 and conditioned for 24 hours in the standard atmosphere defined in BS EN ISO 139.</li> <li>Two peaks are to be placed in an environmental chamber at <math>70 \pm 2^\circ\text{C}</math> and 95 - 100% relative humidity for 6 hours <math>\pm</math> 15 minutes. After removal, the peaks are to be examined for delamination of the black PVC and the (green) skiver, delamination of either peak is to render the batch rejected. Any degree of distortion is to be such that it will not affect the subsequent fitting of the peak to a cap; severe distortion of either peak is to render the batch rejected.</li> <li>Two peaks are to be placed in a freezer at <math>-20 \pm 2^\circ\text{C}</math> for <math>2\frac{1}{2}</math> hours <math>\pm</math> 5 minutes. Immediately after removal, each peak is to be subjected to the following two tests using a mandrel of diameter <math>150 \pm 1\text{mm}</math>.</li> </ul>
<p>13.2 Edge test</p>	<div style="text-align: center;">  </div> <ul style="list-style-type: none"> <li>Use the minimum of force required to bend the internal edge of the peak around the mandrel, ensuring free contact with the circumference of the mandrel. Repeat with the other side up. Examine both sides of the peak for fractures or cracks; any such damage on either peak is to render the batch rejected.</li> </ul>
<p>13.3 Flat test</p>	<div style="text-align: center;">  </div> <ul style="list-style-type: none"> <li>Use the minimum force required to bend the face of the peak around the mandrel, ensuring free contact with the circumference of the mandrel. Repeat with the other side up. Examine both sides of the peak for fractures and cracks: any such damage on either peak is to render the batch rejected.</li> </ul>



#### 4. LABELLING

Label is to be as follows:

- Clearly marked on a label to be sewn to the centre of the crown lining, or
- Clearly printed on a pressure sensitive self-adhesive label to be adhered to the crown lining

The identification label is to be covered by the crown disc, including pressure sensitive self-adhesive labels.

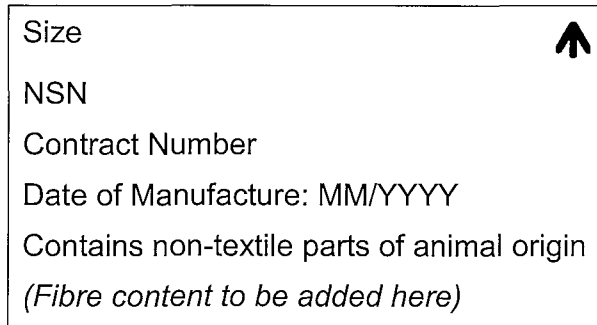


FIGURE 2 Identification and marking label