



**Technical Specification for  
SHOULDER MARK  
RN Chaplains**

**Defence Clothing**

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PREFACE

TABLE 1 – PRODUCT LIST

<b>Item Name</b>	SHOULDER MARK RN Chaplains	
<b>Development File No.</b>	NN/SCD/P1602	
<b>Product Support File No.</b>	NV/533/07	
<b>NATO Stock Number</b>	<b>Pattern Number</b>	
8455-99-130-3125		22465

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

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TABLE 2 – ISSUE RECORD

<b>Issue No.</b>	<b>Comments</b>	<b>Issue Date</b>
3	Reformatted. Removal of DEF STAN 83-65, pattern number 8005B.	20 August 2009
2	Reformatted and technically reviewed.	12 December 2003
1	Specification reformatted without technical change and re-issued as Issue 1. Amendment 1 is included at page 6 (May 2002).	09 September 1982

PART 11. THE PRODUCT

a. Use of the Product. Detachable embellished shoulder marks for wear by RN Chaplains.

TABLE 3 – RELATED SPECIFICATIONS AND DOCUMENTS

<b>Specification/Document</b>	<b>Detail</b>
BS EN 12950	Industrial Sewing Threads made wholly or partly from synthetic fibre.
BS 3870. Parts 1 and 2	Stitches and seams.
BS 4973-4	Interlinings – Specification for woven sew-in interlinings.
UK/SC/6576	Cloths, Twill, polyester/ cotton, No1.

2. PATTERNS.

a. Master Patterns. The DC holds a Master Pattern for this product. Potential contractors may view the pattern on site by arrangement with the DC Commercial Department.

b. Standard Patterns. A Standard Pattern may be obtained from the DC Technical Information Office and may be used to provide the criteria for all materials, components and manufacturing features not fully defined in this specification.

PART 2

3. PRODUCT DESIGN

a. Product Description. Detachable shoulder marks, embellished with the chaplain's insignia, to fit over the shoulder straps of clothing and fasten with press stud fasteners. The badges are to be made and provisioned in pairs.

TABLE 4 – PRODUCT COMPONENTS

4.1 Fabric	<ul style="list-style-type: none"><li>• Cloth, twill, polyester and cotton No. 1, black, FS, Pattern No. 8171C to UK/SC/6576, NATO Stock No. 8305-99-139-6619, or an approved alternative.</li></ul>
4.2 Interlining	<ul style="list-style-type: none"><li>• Cloth, buckram, flax and jute No. 2, Pattern No. 8320A to BS 4973-4, NATO Stock No. 8305-99-942-8282 or an approved alternative.</li></ul>
4.3 Lining	<ul style="list-style-type: none"><li>• Cloth, twill, cotton, black, SF, colour fastness requirements to BS 4560 or an approved alternative.</li></ul>
4.4 Insignia	<ul style="list-style-type: none"><li>• Gilt fouled anchor superimposed on a cross of plain seeded silver plate with a raised burnished edge, 35mm overall length and width with the anchor cable transposed for left and right shoulders to comply in all respects to that on the Standard Pattern.</li></ul>
4.5 Fastening	<ul style="list-style-type: none"><li>• Fastener, snap, cap, black enamelled, as on the Standard Pattern.</li></ul>
4.6 Sewing Threads for all purposes	<ul style="list-style-type: none"><li>• Thread, polyester and cotton, CF polyester core, cotton sheath, black, Metric Count 75, to BS EN 12950.</li><li>• Or an alternative approved by DC</li></ul>

TABLE 5 – PRODUCT CONSTRUCTION

5.1 Sleeve	<ul style="list-style-type: none"><li>• The outer fabric is to be sewn centrally on the lining using a single row of stitching. The finished width is to be 6cm.</li><li>• The lining, two ply, is to be sewn using seam type 1.06.02 of BS 3870. The four sides are to be edge stitched.</li><li>• The interlining is to be enclosed between the lining and outer fabric.</li><li>• A protective tunnel 5.5cm wide is to be sewn to the back of the sleeve with the ends finished using seam type 6.02.01 of BS 3870.</li><li>• Two pairs of snap fasteners are to be clenched to the badge with the female positioned at the corners and the male in correct register with the female.</li></ul>
5.2 Insignia	<ul style="list-style-type: none"><li>• The fouling of the anchor on the insignia is reversed for right and left sides, with the start of the anchor cable towards the front of the respective shoulder.</li><li>• The insignia is to be mounted centrally on the sleeve with the attachment prongs passed through the sleeve and opened behind the tunnel.</li></ul>
5.3 Stitching	<ul style="list-style-type: none"><li>• Machine stitching is to be stitch type 301 of BS 3870 with at least eight but not more than ten stitches per 2cm.</li></ul>
5.4 General	<ul style="list-style-type: none"><li>• Sewing threads may be treated with stain free lubricants.</li><li>• Seams are to be free from pucker.</li><li>• The shoulder marks are to be free from all ends of sewing threads, they are to be pressed, and delivered in a clean condition.</li></ul>

TABLE 6 – MEASUREMENTS

- The shoulder marks are to conform to the following dimensions:

Effective width	5.5cm
Full width	14cm
Length	6.5cm

4. LABELLING REQUIREMENTS

- Each item is to be individually wrapped (pairs or each) and identified by a clearly printed pressure sensitive self adhesive label firmly adhered to the outside of the polythene envelope/Bag.
- Information and format to be as follows: NATO Stock number, contract number and year of manufacture.

TABLE 7 – SPECIMEN LABELS

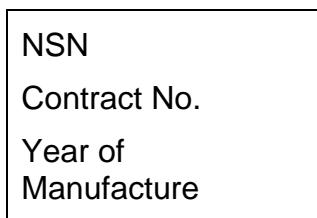


Figure 1 Example Identification and Marking Label