

PRIVATE SPECIFICATION

Prepared for the

SOUTH AFRICAN AIR FORCE



EMBROIDERED ONLAYS FOR BRIMS OF WOMEN'S HATS

For

Major

Senior Officers

General Officers



SALM 238
Revised June 2010

1. Scope

This specification covers the material, cut and make of embroidered onlays for brims of women's hats. The variations of brim onlays covered by this specification are as follows:

	Rank	National Stock Number
1.1	Major	18-420-9815
1.2	Lt Colonel and Colonel (Senior Officers)	18-420-9818
1.3	General (General Officers)	18-175-6734

2. Definitions and Abbreviations

For the purpose of this specification the definitions given in SANS 10371 "Terms and definitions for clothing" and the following shall apply:

acceptable: acceptable to the South African Air Force

assaying: the testing of a metal or ore to determine its ingredients and quality

inductively coupled plasma (ICP): precise and accurate multi-element analytical technique for the determination of trace elements in a variety of liquid and solid sample materials

nominal: subject to the tolerances normal to good manufacturing practice

SANS: South African National Standard

X-ray fluorescent spectrometry: is a non-destructive analytical technique used to identify and determine the concentrations of elements present in solid, powdered and liquid samples

3. Style

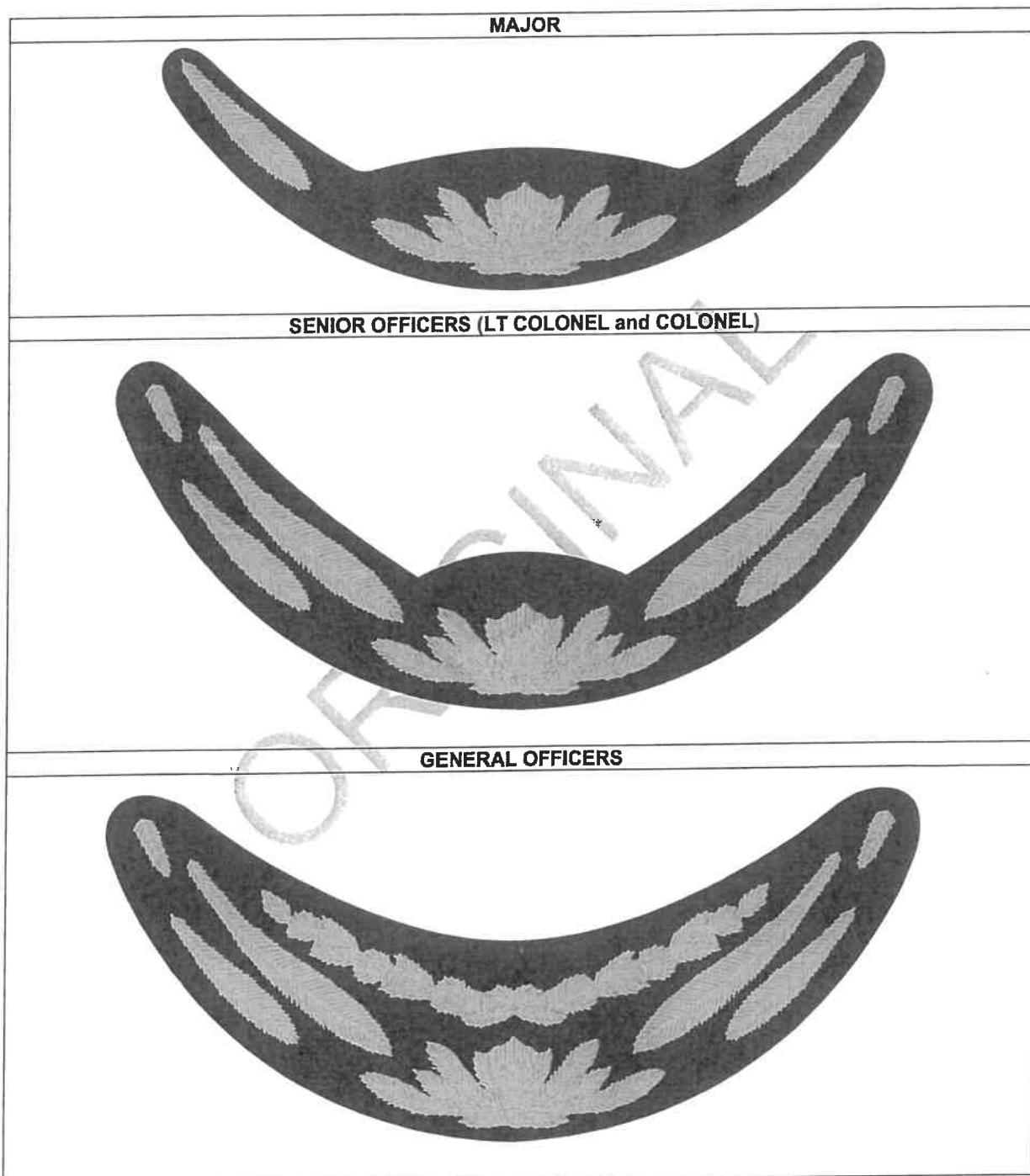
The style is as follows:

- ◆ supplied in three variations (according to rank)
- ◆ melton base fabric
- ◆ fully lined (backed) with calico fabric
- ◆ fitted with gold wire embroidery
- ◆ shape of onlay to correspond with shape of embroidery

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4. Illustrations

Illustrations are not to scale and are for guidance only.



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5. Client Furnished Materials

No materials will be supplied by the South African Air Force.

6. Component Materials

The following materials shall be supplied and used by the manufacturer. Trim charts shall also be submitted by the manufacturer (see Annex A).

6.1 Base fabric

- ◆ be a woollen melton fabric
- ◆ nominal mass per area of 360 g/m² when tested in accordance with SANS 79 (or SANS 80 in case of a dispute)
- ◆ colour to be a match, in terms of SANS 10076-5, The assessment of defects in textile piece-goods and made-up articles Part 5: Defects in woven woollen and worsted piece-goods, to colour No 461-06c "SAAF Dark blue grey" of CKS 129 "Colours for textiles"

6.2 Backing fabric

- ◆ an acceptable black calico fabric
- ◆ of nominal mass per area 160 g/m² when tested in accordance with SANS 79 or 80 (as relevant)
- ◆ comply with the performance requirements as given in SANS 1401-7 "Woven cotton and similar household fabrics and articles Part 7: Cotton curtain lining

6.3 Gold wire (for embroidery)

- ◆ shall be tubular
- ◆ type and finished used:
 - Matt or Bright tubular gold wire
 - Jaceron
- ◆ to be as given in section 10
- ◆ with nominal outside diameter of 0,8 mm
- ◆ to be tarnish treated and the composition shall be as given in table 1
- ◆ content shall be tested by the following
 - assaying
 - X-ray fluorescent spectrometry
 - inductively coupled plasma (ICP)

Table 1 – Composition of gold wire¹

Metal type	Content %
Gold	2 (min.)
Silver	1
Nickel	5
Copper	92

¹ See Annex B.

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7. Workmanship

The embroidered onlays shall be:

- ◆ cut, made and embroidered with first-class workmanship throughout
- ◆ of uniform and acceptable make, colour and finish
- ◆ durable at all times and no separation shall occur between the adhesive, base fabric and backing cloth

Embroidery shall be free from:

- ◆ defects, that affect their appearance or may affect their serviceability (or both)
- ◆ marks
- ◆ spots
- ◆ stains, incurred in the making-up

Ends of embroidery threads shall be:

- ◆ trimmed

All loose embroidery threads shall be:

- ◆ removed

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8. Sizes and dimensions

A tolerance of ± 2 mm applies to all measurements given in 8.1, 8.2 and 8.3.

8.1 Major

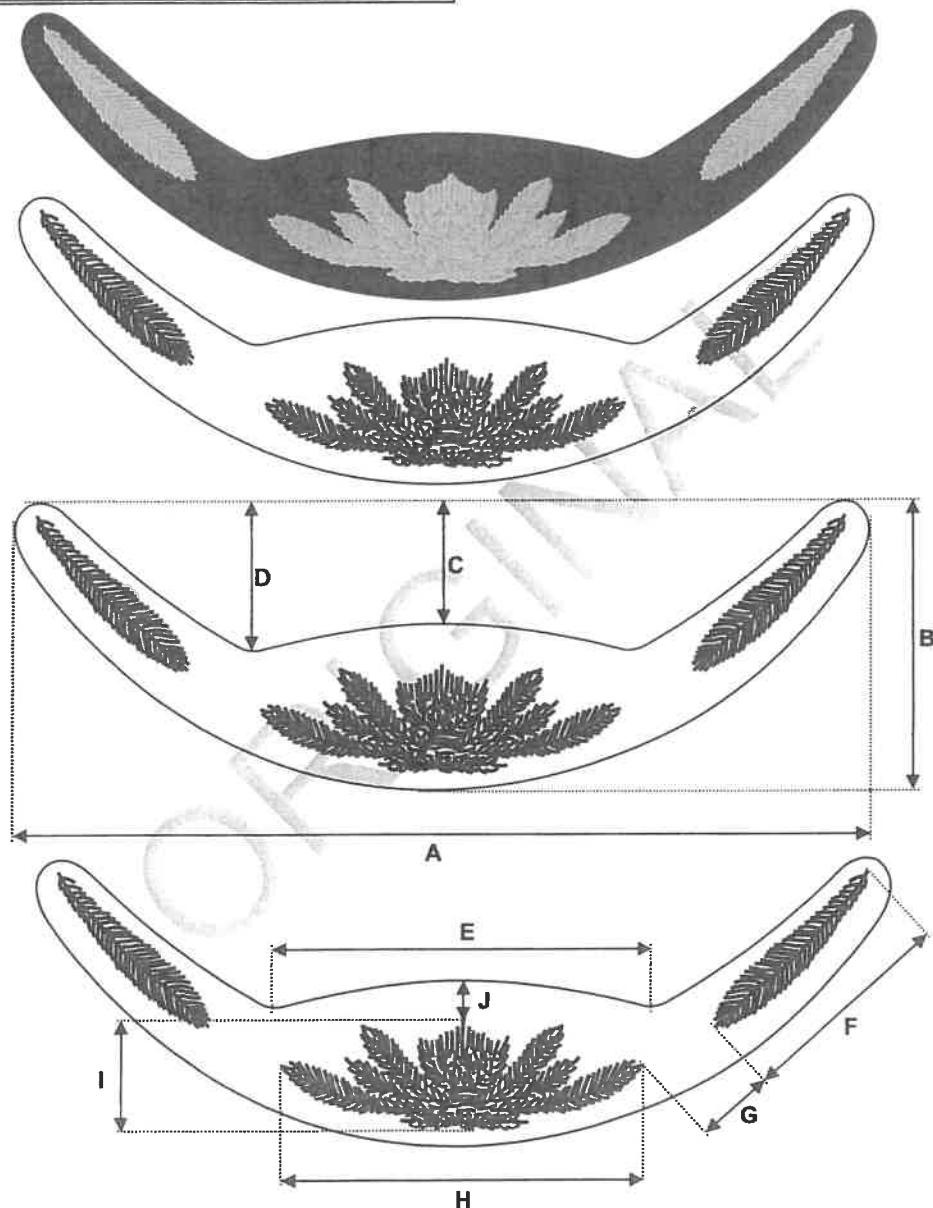
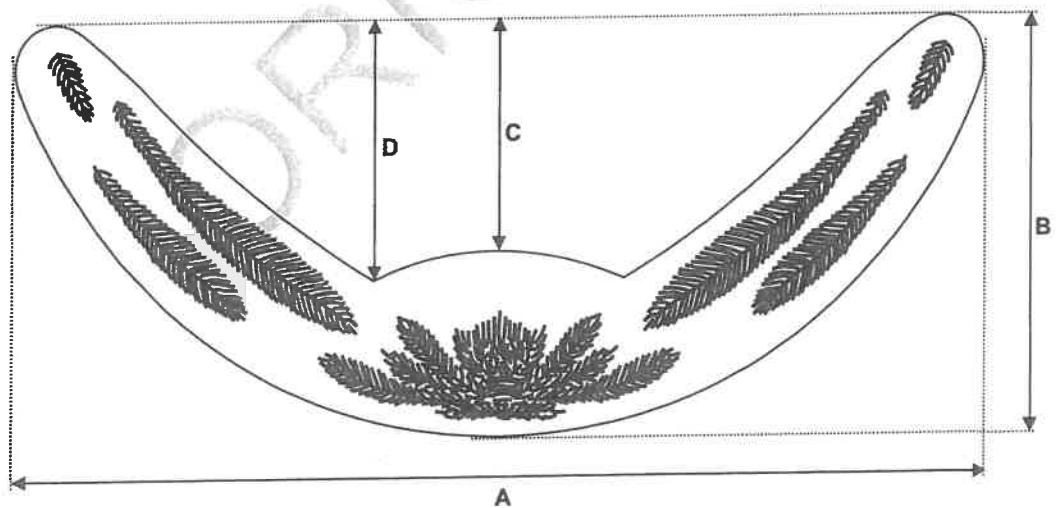


Table 2 – Dimensions of peak onlay for rank: Major

Rank	A	B	C	D	-	-
Major	145 mm	50 mm	20 mm	26 mm	-	-
	E	F	G	H	I	J
	60 mm	37 mm	13 mm	62 mm	19 mm	5 mm

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8.2 Lt Colonel and Colonel (Senior Officers)



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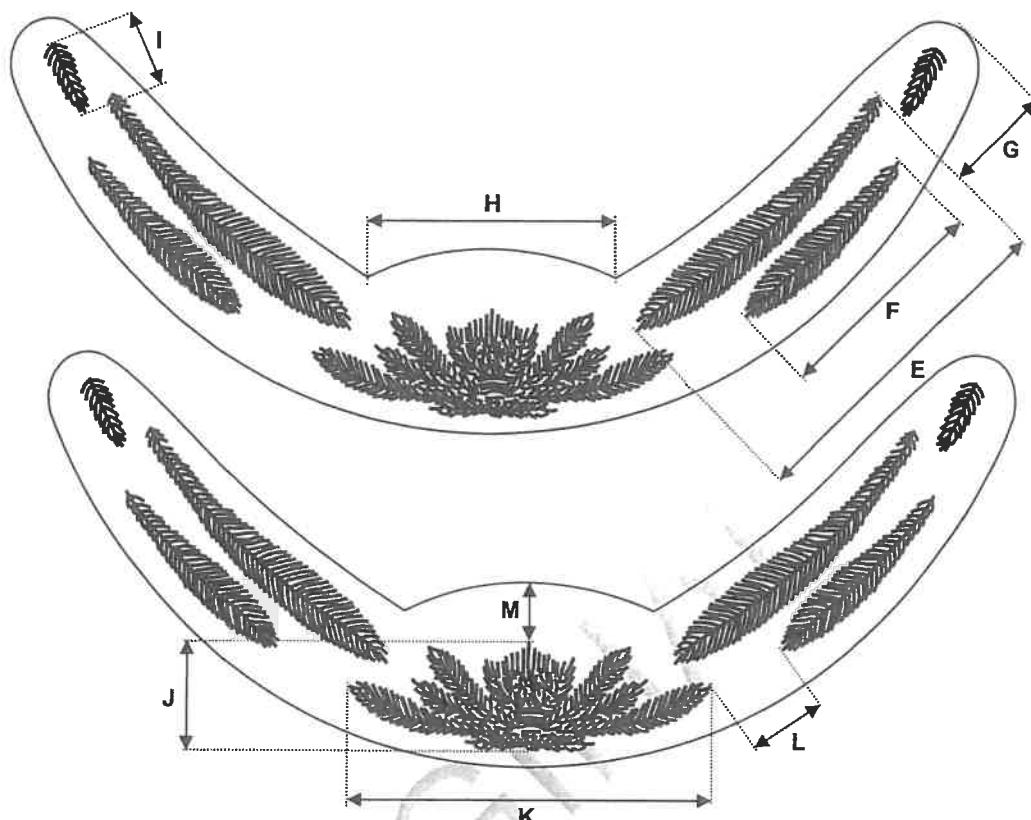
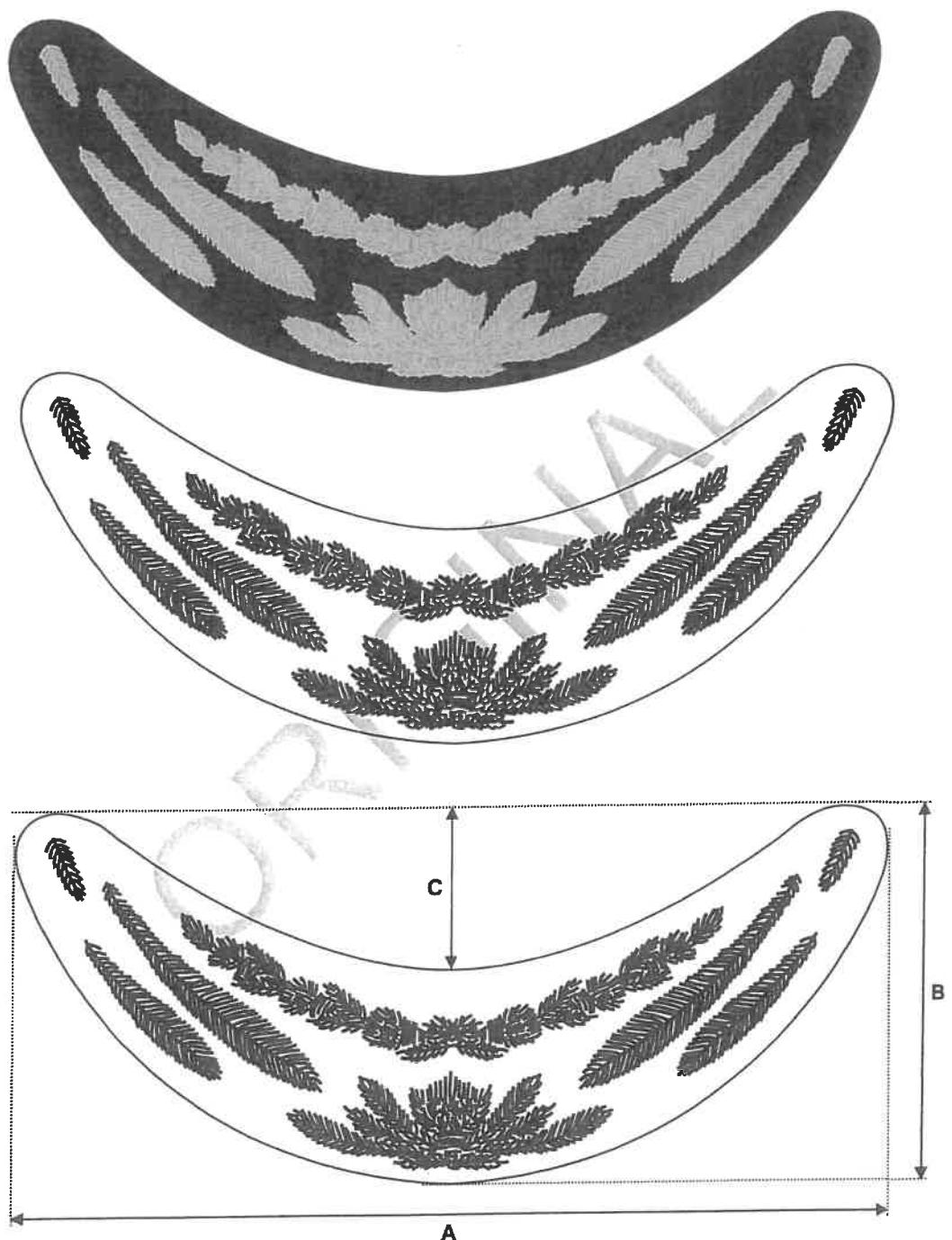


Table 3 - Dimensions of peak onlays for Senior Officers

Rank	A	B	C	D	-
Senior Officers	178 mm	75 mm	42 mm	46 mm	-
	E	F	G	H	I
	57 mm	34 mm	22 mm	45 mm	13 mm
	J	K	L	M	-
	19 mm	59 mm	18 mm	7 mm	-

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8.3 General Officers



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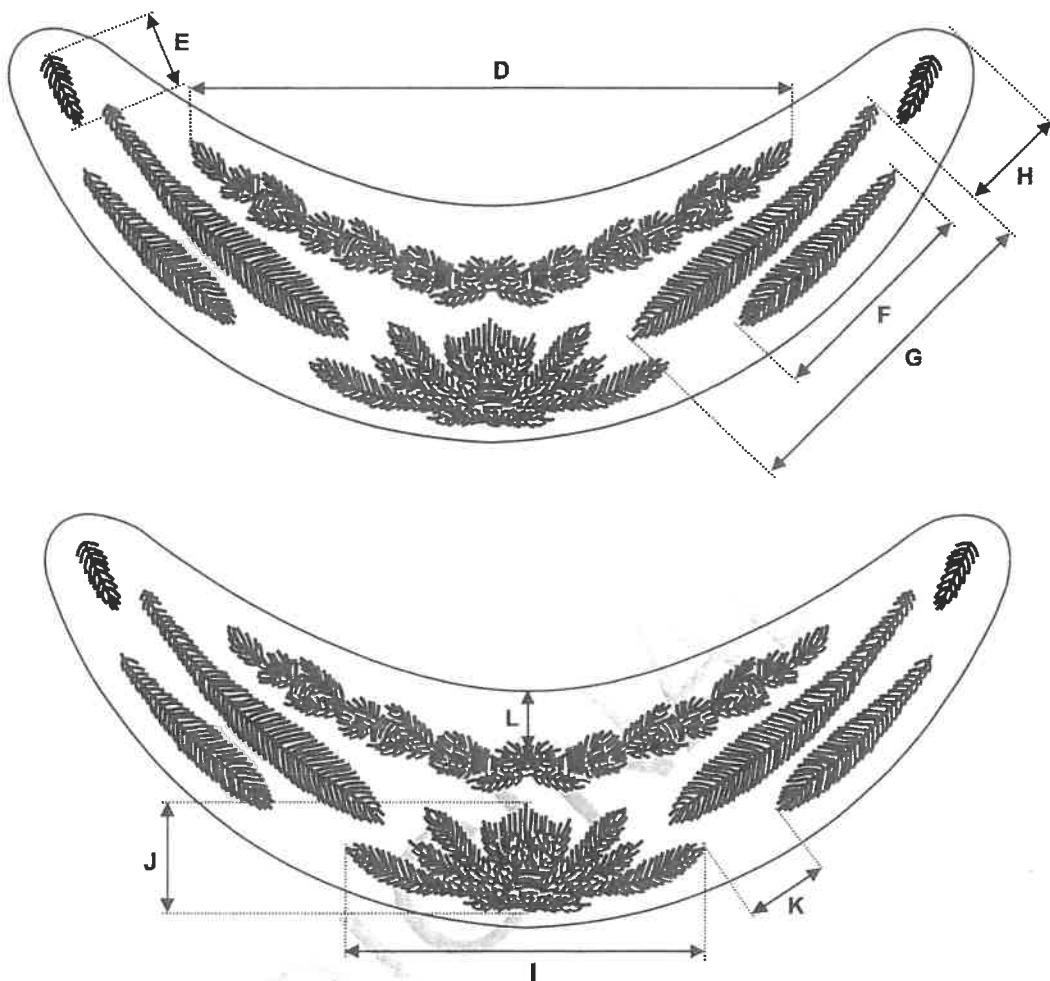


Table 4 - Dimensions of peak onlays for General Officers

Rank	A	B	C	-	-
General Officers	175 mm	74 mm	32 mm	-	-
	D	E	F	G	H
	106 mm	13 mm	39 mm	58 mm	23 mm
	I	J	K	L	-
	64 mm	20 mm	14 mm	7 mm	-

9. Make

Illustrations are not to scale and are for guidance only, and unless inconsistent with the text, all measurements are nominal.

9.1 General

Each onlay shall be:

- ◆ made of base material
- ◆ embroidered with gold wire
- ◆ lined with backing fabric
- ◆ 100% proportionate in size to the relevant sealed sample

Base material and backing fabric shall be:

- ◆ bonded in such a way that the bonded unit:
 - has a uniform finish
 - is free from perforations, untreated areas and other imperfections (e.g. blisters and ripples)
- ◆ acceptably finished that no fraying shall occur along the cut edges

Adhesive used for bonding shall:

- ◆ not contain any constituent that may have a toxic or irritating effect on the skin
- ◆ be such that it adheres to both materials and will not under any circumstances emit an unpleasant odour

9.2 Gold wire embroidery

- ◆ to be made to the design and dimensions as given below:
 - Major: See section 8.1 and 10.1
 - Senior Officers: see section 8.2 and 10.2
 - General Officers: see section 8.3 and 10.3
- ◆ to be hand embroidered
- ◆ the pieces of gold wire shall be laid close together so that no base material is visible between the wire

10. Component identification

The black colour-filled section indicates the application of the relevant component and colour.

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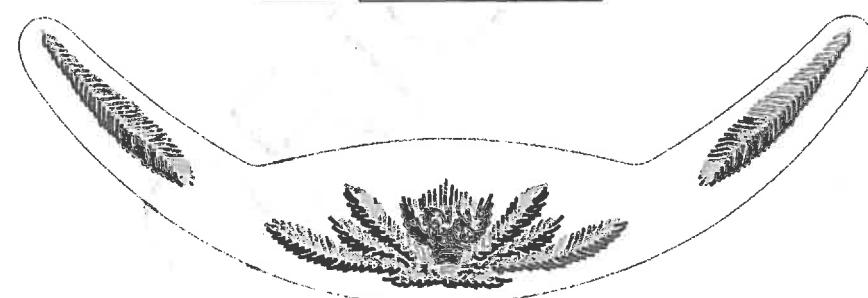
10.1 Major



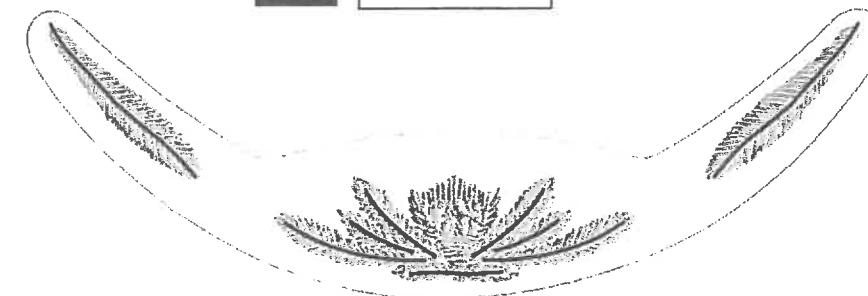
Colour No. 461c-06 "SAAF Dark blue grey"



Bright Gold wire



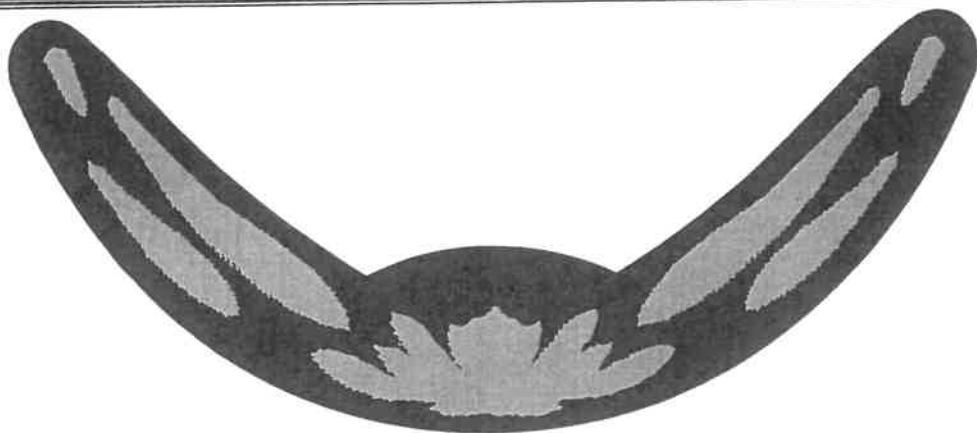
Matt Gold wire



Jaceron

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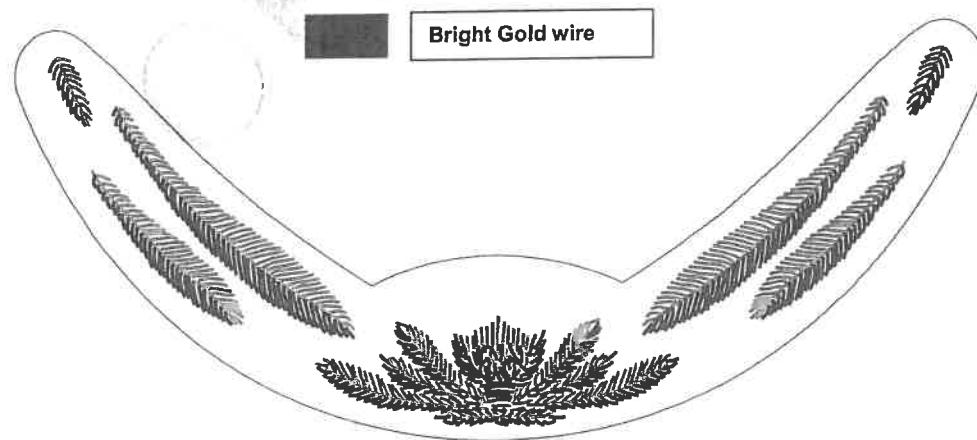
10.2 Senior Officers



Colour No. 461c-06 "SAAF Dark blue grey"

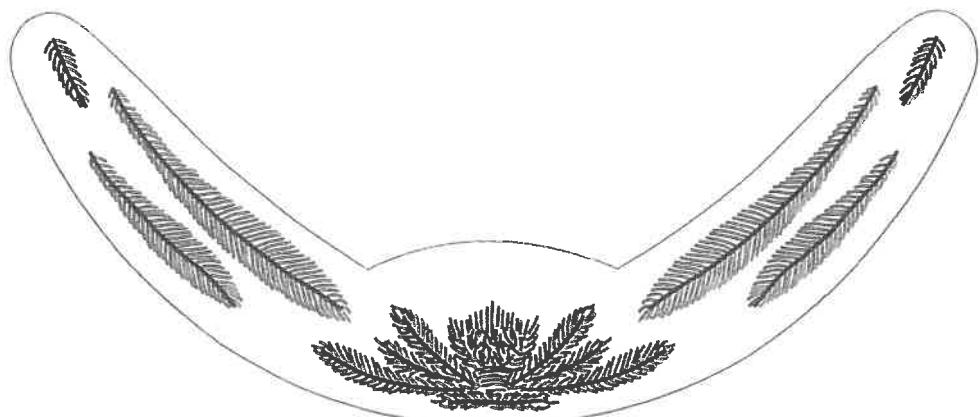


Bright Gold wire



Matt Gold wire

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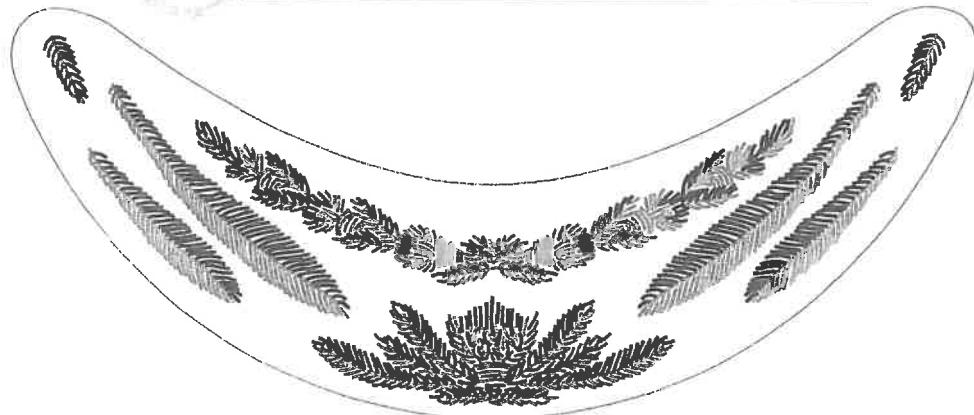


Jaceron

10.3 General Officers

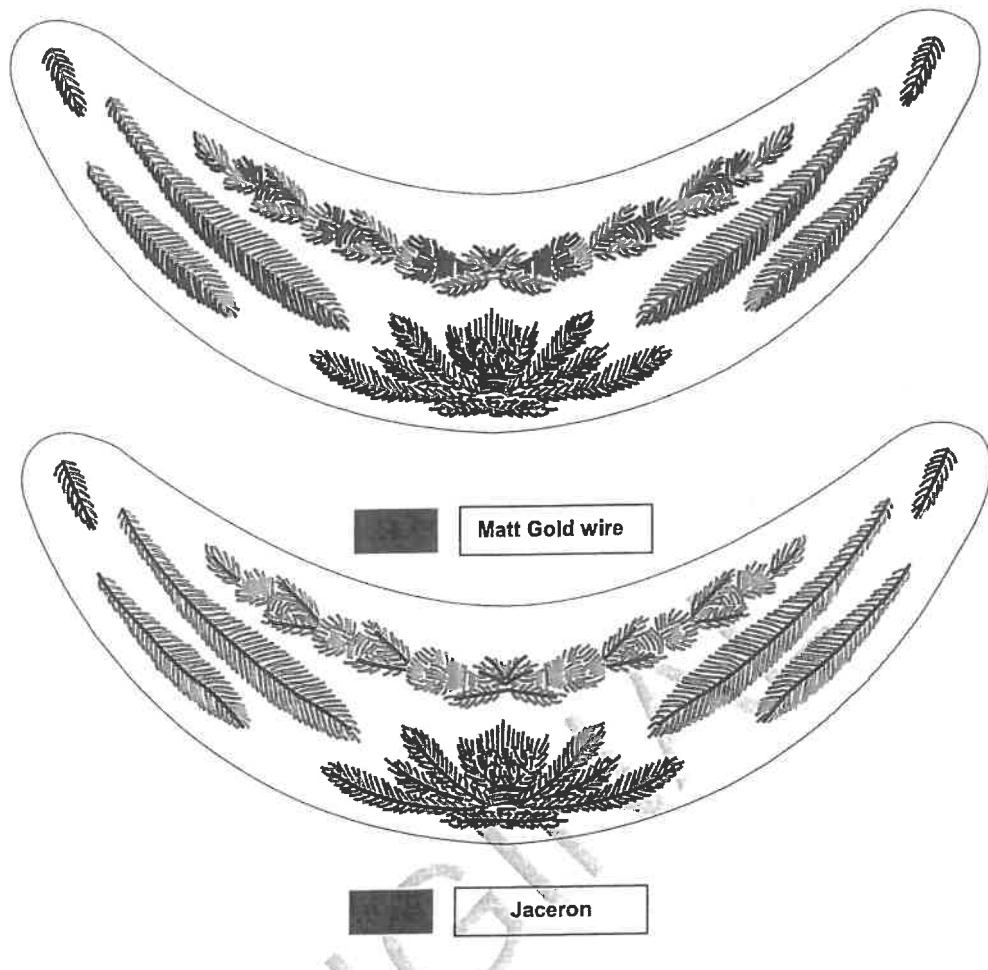


Colour No. 461c-06 "SAAF Dark blue grey"



Bright Gold wire

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11. Packing and marking of packaging

11.1 Packing

11.1.1 The onlays shall be:

- ◆ delivered in a commercially dry condition
- ◆ so packed that they will not be damaged in transit or in storage
- ◆ individually packed in a clear plastics envelope of suitable size and shape with a pull and press closure

The individually packed embroidered onlays shall be:

- ◆ packed in clear bulk plastics envelopes of suitable size and shape

The bulk plastics envelopes shall be:

- ◆ packed in a bulk container that shall comply with the requirements as given in SALM 108 "Corrugated board boxes for clothing".

11.1.2 Onlays:

- ◆ of the same type (rank variation) to be packed together in a bulk plastics envelope and bulk container (unless quantities ordered are such that packing together of the same rank only is not justified)

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- ♦ of different ranks may also be packed together in a bulk container to accommodate the last part of an order or contract

11.2 Marking of packaging

11.2.1 Individual and bulk plastics envelopes:

Plastics envelope to be clearly marked with the following information:

- ♦ the designation, i.e. "Embroidered onlays, hat brims (women's)"
- ♦ the rank
- ♦ the NSN
- ♦ the manufacturer's name or trademark
- ♦ the year of manufacture

11.2.2 Bulk containers:

Each bulk container shall be labelled as given in paragraph 11.2 of SALM 108 "Corrugated board boxes for clothing".

11.3 Additional marking

When so required by the South African Air Force, onlays, individual plastics envelopes, bulk plastics envelopes or bulk containers (or any combination of these) to bear information additional to that specified above.

12. Normative References

The following documents contain provisions which, through reference in this text, constitute provisions of this specification. All documents are subject to revision and, since any reference to a document is deemed to be a reference to the latest edition of that document, parties to agreements based on this specification are encouraged to take steps to ensure the use of the most recent editions of the documents indicated below. Information on currently valid national, international and CKS documents may be obtained from SABS Standards Division *.

SALM 108, Corrugated board boxes for clothing.

SANS 79, Textiles – Mass per unit area of conditioned fabrics.

SANS 80, Mass (oven-dry plus conventional allowance) per unit area of textile fabrics, free from non-fibrous material.

SANS 1401-7, Woven cotton and similar household fabrics and articles Part 7: Cotton curtain lining.

SANS 10371, Terms and definitions for clothing.

SANS 10076-5, The assessment of defects in textile piece-goods and made-up articles, Part 5: Defects in woven woollen and worsted piece-goods.

* South African Bureau of Standards: Tel. +27 (0) 12 4287911

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ANNEX A

(Normative)

Special conditions of tender

A-1 GENERAL

A-1.1 Unless otherwise stated, the South African Bureau of Standards shall be the inspecting authority.

A-1.2 Two pre-production sample embroidered onlays of each type, shall have been inspected, tested and approved by the inspecting authority before bulk production is commenced. The sample embroidered onlays shall be accompanied by a trim chart containing a sample of each component material (as given in 6) and the relevant certificates. It shall be the duty of the manufacturer to give adequate notice to the inspecting authority of the availability of the sample.

Note: In instances where a new tender has been awarded and the successful tenderer had previously manufactured embroidered onlays according to the SAAF specification, the tenderer may apply for re-sealing of a previously submitted pre-production sample embroidered onlay. The re-sealing will be allowed at the discretion of the South African Air Force and is applicable to pre-production samples not older than three years.

A-1.3 The onlays shall be subject to inspection during the course of manufacture. The inspector shall, during normal working hours, be given all reasonable facilities for carrying out his duties and shall have the right of entry into the contractor's factory and the factory or works of any subcontractor where work on onlays supplied to this specification may be in progress.

A-1.4 The contractor shall inspect the finished onlays for compliance with the specification before submitting them to the inspecting authority for final inspection.

A-1.5 Before acceptance, the onlays shall have been inspected and tested by the inspecting authority and found to comply with the requirements of the specification.

A-2 DOCUMENTATION

One container of each consignment shall be marked "DOCUMENTS" and in addition to the onlays, shall contain the following:

- a) The packaging slip or delivery note;
- b) where applicable the inspection certificate(s);
- c) a copy of the invoice containing the following information:
 - the order number
 - the financial authority number
 - a full description of the consignment, i.e. National Stock Number, quantity, etc

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ANNEX B

(Normative)

Additional information on the composition of the wire

Base alloy(white metal): Copper – 95%; Nickel – 5 %

Electroplated with silver (1%)

Electroplated with gold (2,2%)

ANNEX C

(Normative)

CKS 129 Colours

Due to the fact that colours can change over a period of time, any colour standard which has been registered for a period of SEVEN YEARS or more shall be considered obsolete. These standards shall then be allocated an archived status (as opposed to current status) and re-registration shall be required.

A. The following scenarios require a submission of three metres of fabric (where relevant) from the successful tenderer:

1. A colour standard is archived.
2. First time registration is required (CKS 129 colour number does not exist).
3. Colour swatch stock at the SABS is no longer available.

B. Requirements for the submission of fabric as identified in A:

1. The colour shall be as agreed upon between the South African Air Force and the successful tenderer.
2. The fabric shall be used to make new colour swatches which shall be the responsibility of the SABS.
3. The cost of the three metres of fabric shall be incorporated in the relevant tender submission.

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HISTORY SHEET

DOC ISSUE	DATE	AMENDMENTS/HISTORY	CHECKED	
			NAME	INIT.
1	March 2006	First release		
2	June 2010	a) Updated format and layout of spec. b) Add definitions. c) Delete reference to withdrawn standard SANS 941. d) Amended gold wire composition. Add annex B. e) Add Annex C f) Add dimensions of embroidered design on peak. g) Add matt, bright and Jaceron gold wire application.		

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PRIVATE SPECIFICATION

Prepared for the

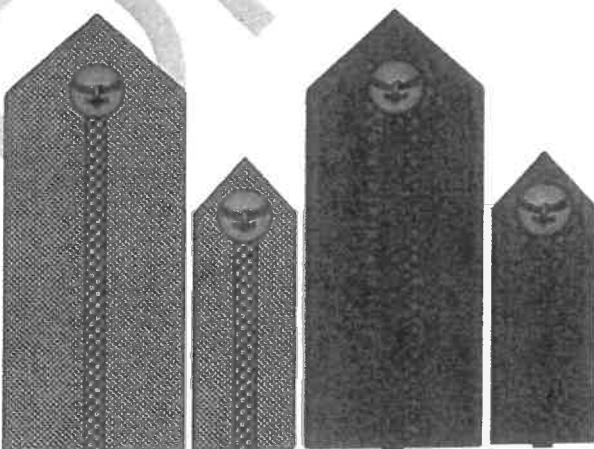
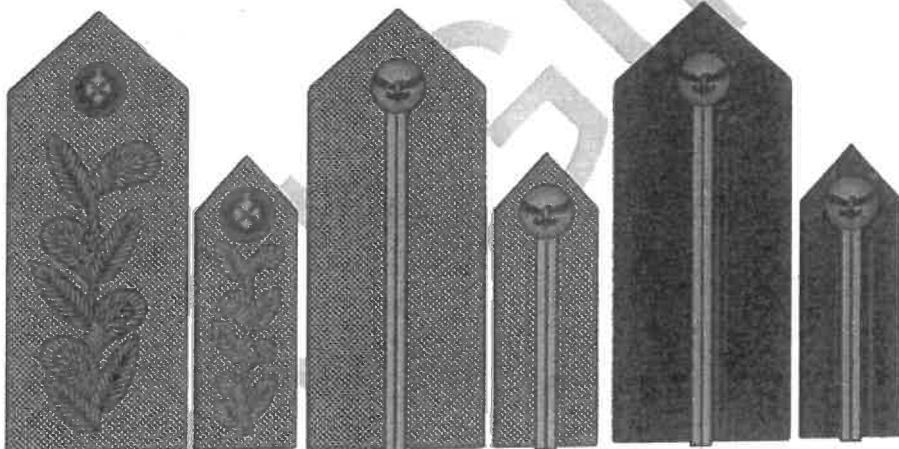
South African Air Force



GORGET PATCHES

for

Generals, Colonels, Colonel Chaplains & Chaplains
(Regular and Miniature for Summer Ceremonial Dress)



SALM 441
Version 07.0/April 2020

1. Scope

This specification covers the material, cut, make and trim of five types (each type in two size variations) of gorget patches for personnel of the South African Air Force. This specification covers the variations as given in table 1.

2. Definitions and Abbreviations

For the purpose of this specification the following shall apply:

acceptable: acceptable to the South African Air Force

nominal: subject to the tolerances normal to good manufacturing practice

SANS: South African National Standard

3. Style

- ◆ five types
- ◆ each type to be supplied in two size variations
- ◆ each type to be supplied in pairs
- ◆ types to be as given in table 1

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Table 1 – Gorget types

Type	National Stock Number	Item description	Illustration
1(a)	18-400-5821	Gorget patch, Generals, Regular	
1(b)	18-181-8606	Gorget patch, Generals, Miniature for Summer Ceremonial Dress	
2(a)	18-400-5817	Gorget patch, Colonels, Staff Qualified, Regular	
2(b)	18-181-8607	Gorget patch, Colonels, Staff Qualified, Miniature for Summer Ceremonial Dress	
3(a)	18-407-3633	Gorget patch, Colonel Chaplains, Regular	
3(b)	18-182-5960	Gorget patch, Colonel Chaplains, Miniature for Summer Ceremonial Dress	
4(a)	18-191-6082	Gorget patch, Chaplains, Non-staff Qualified, Spectrum Violet on Spectrum Violet, Regular	
4(b)	18-191-6083	Gorget patch, Chaplains, Non-staff Qualified, Spectrum Violet on Spectrum Violet, Miniature for Summer Ceremonial Dress	
5(a)	18-407-3635	Gorget patch, Colonel, Non-staff Qualified, Blue on Blue, Regular	
5(b)	18-191-6080	Gorget patch, Colonel, Non-staff Qualified, Blue on Blue, Miniature for Summer Ceremonial Dress	

4. Illustrations

Illustrations are not to scale and are for guidance only.

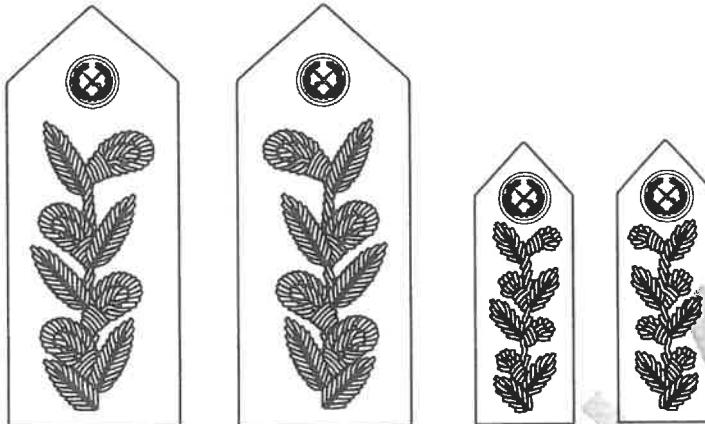


Figure 1 – Gorget patches, Generals, Regular & Miniature

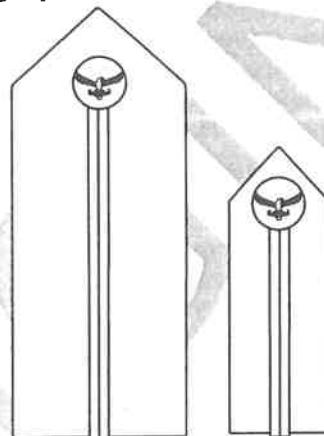


Figure 2 – Gorget patches, Staff Qualified Colonels and Colonel Chaplains, Regular & Miniature

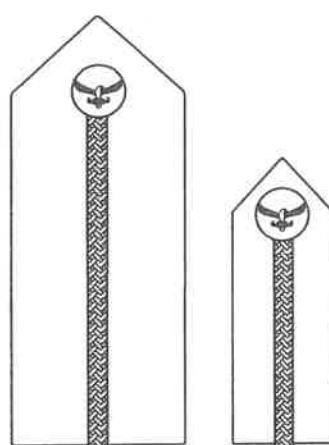


Figure 2 – Gorget patches, Non-Staff Qualified Colonels and Chaplains, Regular & Miniature

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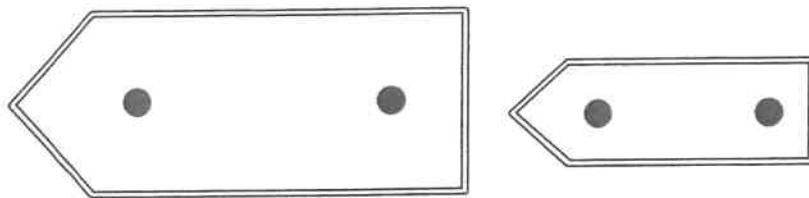


Figure 3 – Back view of gorget patches for Generals

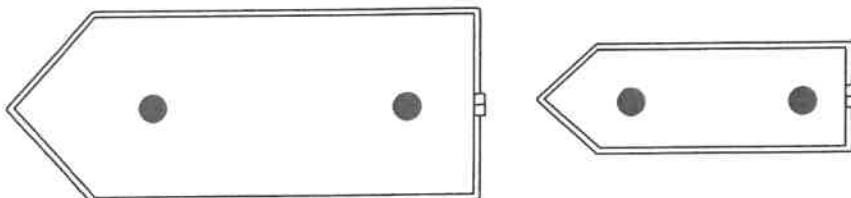


Figure 4 – Back view of gorget patches for Staff Qualified Colonels and Colonel Chaplains

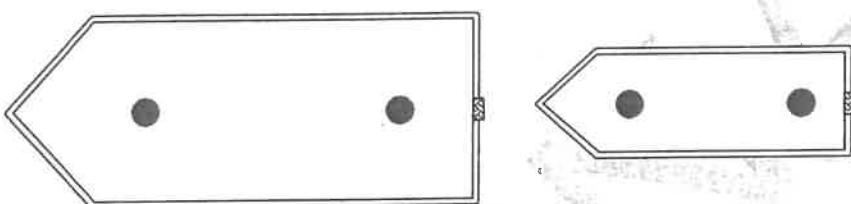


Figure 5 – Back view of gorget patches for Non-Staff Qualified Colonels and Chaplains

5. Client Furnished Materials

The South African Air Force shall supply the following:

5.1 Outer material

- ◆ to be a barathea fabric that complies with the requirements for type 68 of SANS 346
- ◆ colour to be a match, in terms of SANS 10076-5, to the following CKS 129 "Colours for textiles" colours as given in table 2
- ◆ quantity supplied shall be in accordance with the material ratings agreed upon between the South African Air Force and the successful bidder in order to fulfil the contract
- ◆ outer material for pre-production samples and for testing purposes to be estimated and rated additionally

Table 2 – Colour of outer material

Item	Colour No.	Title
Gorgets for Generals and Colonels	509c-96	Flight blue
Gorgets for Chaplains and Colonel Chaplains	545c-06	Spectrum violet

5.2 Metal buttons

- ◆ two different types of metal buttons shall be supplied and shall be as given in 5.2.1 to 5.2.2
- ◆ quantity supplied shall be in accordance with the quantity required in order to fulfil the contract
- ◆ buttons for pre-production samples to be added as well

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5.2.1 Generals

- ◆ 10 mm metal shank button
- ◆ incorporating a wreath, crossed sword and baton



5.2.2 All other ranks

- ◆ 10 mm metal shank buttons
- ◆ incorporating the SAAF eagle



6. Component Materials

The following materials shall be supplied and used by the manufacturer. Trim charts shall also be submitted by the manufacturer (see Annex A).

6.1 Interlining

- ◆ an acceptable woven or non-woven fusible interlining
- ◆ to comply with the requirements of SANS 1254 "Fusible interlinings"

The selection of interlining of appropriate mass per unit area to be determined by consultation with the supplier of the interlining.

6.2 Stiffener strip

- ◆ an acceptable firm plastics stiffener
- ◆ not to become brittle with age
- ◆ of nominal thickness 1 mm

6.3 Lining

- ◆ an acceptable cotton or polyester and cotton fabric
- ◆ colour to be black

6.4 Gold wire (for embroidery)

- ◆ shall be tubular
- ◆ shall have a matt or bright finish as relevant
- ◆ with nominal outside diameter of 0,8 mm
- ◆ to be tarnish treated
- ◆ composition shall be as given in table 3
- ◆ content shall be tested by the following
 - assaying
 - X-ray fluorescent spectrometry
 - inductively coupled plasma (ICP)

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Table 3 – Composition of gold wire¹

1	2
Metal type	Content %
Gold	2 (min.)
Silver	1
Nickel	5
Copper	92

6.5 Braid

- ◆ two types of braids shall be used
- ◆ to be as given in table 4
- ◆ both types shall be synthetic
- ◆ both shall be of nominal width 4 mm

Table 4 - Braid

1	2	3
Rank	Description	CKS 129 Colour
Staff Qualified Colonels	Synthetic piping braid that consists of two cores interlaced with a herringbone pattern	Colour to be an acceptable gold colour as agreed upon between SAAF and the successful tenderer
Colonel Chaplains		
Non-staff Qualified Chaplains	Synthetic flat braid	Colour No. 545c-06 "Spectrum violet"
Non-staff Qualified Colonels		Colour No. 509c-96 "Flight blue"

6.6 Brass plate with prongs

- ◆ an acceptable brass plate with two soldered prongs
 - hard or silver soldered to the brass plate
 - made from cold drawn bright nickel silver or brass wire
 - of dimensions to be as given in figure 6
 - sharp point shall be free from burrs
 - any distortion of the prongs shall be rectified during soldering
 - all soldering shall be clean, strong, smooth and free from flux and excess soldering
 - centrally positioned on the brass plate
 - positioned in such a way that when the brass plate is positioned on the underside of the plastics stiffener:
 - the first prong shall be positioned as close as possible to the shank of the button, but with enough space allowed for the successful engagement of a clutch
 - the second prong shall be positioned approximately 15 mm from the square outer edge of the gorget patch, such as to not interfere with the folded edge of the piping (where relevant)
- ◆ brass plate to be supplied in two sizes
 - width to correspond with the dimensions of the regular and miniature gorget patches respectively
- ◆ brass plate to extend from the base of the mitre to the outer edge of the gorget patch (applicable to both sizes, i.e. Regular and Miniature)
- ◆ brass plate to incorporate holes to allow sewing thread to pass through the plastics stiffener and brass plate to secure all components
- ◆ clutches to comply with the requirements as given in paragraph 6.7

¹ See Annex B.

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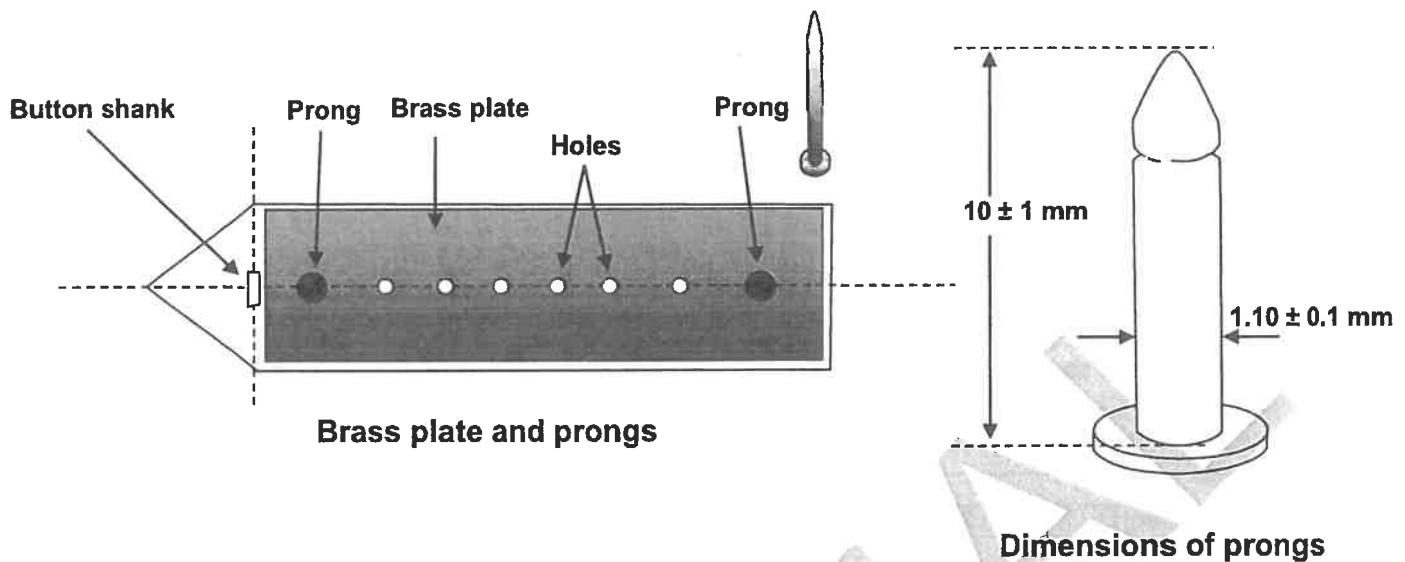


Figure 6 – Prongs and brass plate

6.7 Clutches

- ◆ acceptable rubber PVC clutches
- ◆ design to be as given in figure below
- ◆ nominal diameter of base to be 11 mm
- ◆ colour to be black or white
- ◆ the diameter of the shaft (centre hole) shall be such as to permit full and secure engagement of the prong

6.8 Sewing threads

- ◆ to comply with relevant requirements of SANS 1362 "Sewing threads"
- ◆ colour to be an acceptable match to the colour with which it is used
- ◆ polyester-an-cotton core-spun OR staple polyester thread
- ◆ ticket No. 80

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7. Workmanship

The gorgets shall be:

- ◆ cut and made with first-class workmanship throughout
- ◆ of uniform and acceptable make, colour and finish

Shall be free from:

- ◆ defects, that affect their appearance or may affect their serviceability (or both)
- ◆ marks
- ◆ spots
- ◆ stains, incurred in the making-up

Seams and stitches shall be:

- ◆ smooth and uniform
- ◆ free from twists, pleats and puckers
- ◆ sufficiently extensible to avoid seam cracking and undue shrinkage in use

Ends of sewing shall be:

- ◆ trimmed and loose threads removed
- ◆ back-tacked if unsecured

8. Make

Illustrations are not to scale and are for guidance only, and unless inconsistent with the text, all measurements are nominal.

8.1 General

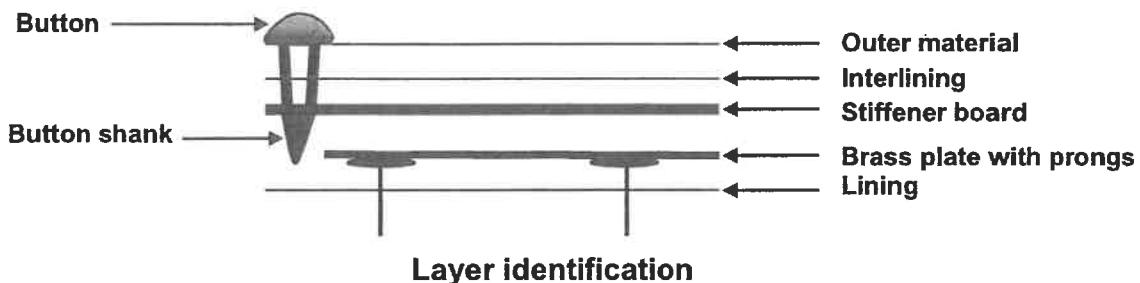
- ◆ the gorgets shall be supplied in five types and two size variations as given in table 1

8.2 Gorget base

Each gorget base shall:

- ◆ consist of the following:
 - outer material that is interlined with interlining
 - colour of outer material to be as given in table 2
 - stiffener board that is covered with outer material
 - outer material to be securely attached to the stiffener board by means of hand felling
 - brass plate positioned at the underside of the stiffener board
 - to be securely attached to the stiffener board by means of hand felling
 - underside of plastics stiffener board to be lined with lining
 - lining to be folded in along the raw edges and securely attached to the outer material by means of hand felling
 - prongs on brass plate to be pressed through the lining and fitted with two clutches
- ◆ be of dimensions as given in section 9

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8.2 Gorget decoration

Each gorget base shall:

- ◆ be fitted with an appropriate button as given in section 5 and table 5
 - button to be positioned on the outside of the gorget patch, with the shank positioned through the outer material, interlining and plastics stiffener board
 - button to be centrally positioned and level with the base of the mitre
 - button to be correctly positioned with the top of the button facing towards the mitred point of the gorget patch
- ◆ be decorated with gold wire embroidery, applicable to the appropriate type as given in table 5
 - to be hand embroidered
 - the pieces of gold wire shall be laid close together so that no outer material is visible between the wire
- ◆ be decorated with braid, applicable to the appropriate types as given in table 5
 - braid to be sewn centrally along the length of the gorget patch
 - braid to extend from the shank of the button to the end of the patch
 - free ends of the piping to be secured on the inside of the patch (sandwiched between the outer material and lining)

Table 5 – Decorations on gorget patches

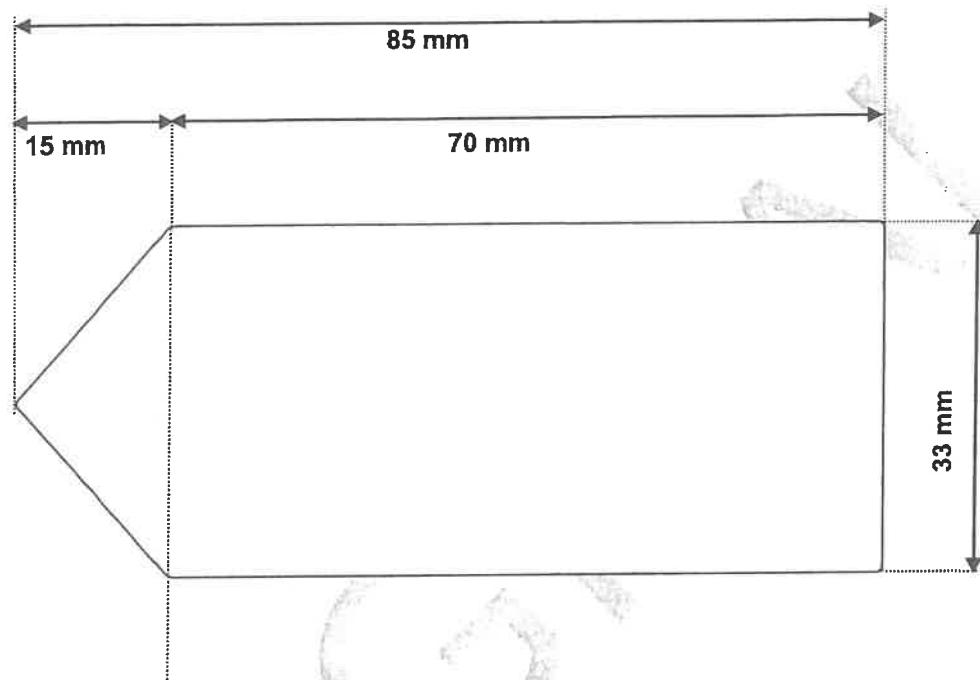
1	2	3	4
Item ¹	Decoration type	Design	Button design
Gorgets for Generals	Gold wire embroidery	See section 10.1 & 10.2	Sword and baton
Gorgets for Staff Qualified Colonels	Piping braid	See section 10.3 & 10.4	SAAF eagle
Gorgets for Colonel Chaplains	Piping braid	See section 10.5 & 10.6	
Gorgets for Chaplains (Spectrum violet on Spectrum Violet)	Flat braid	See section 10.7 & 10.8	
Gorgets for Non-Qualified Colonels (Blue on Blue)	Flat braid	See section 10.9 & 10.10	

¹ Applicable to Regular and Miniature variations.

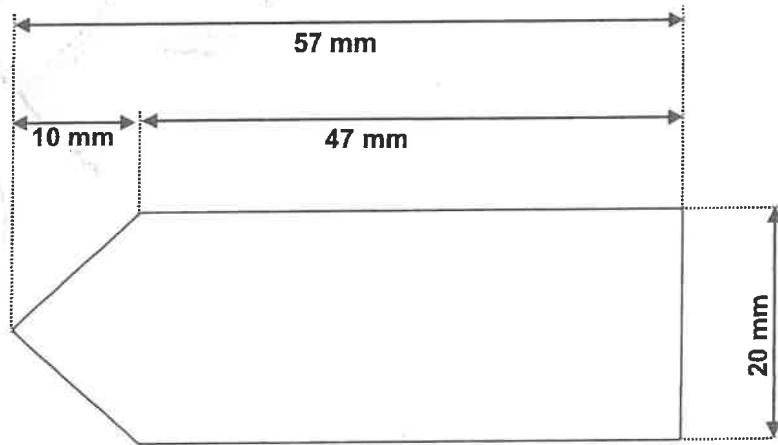
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9. Dimensions of gorget patches

9.1 Dimensions of regular gorget patch

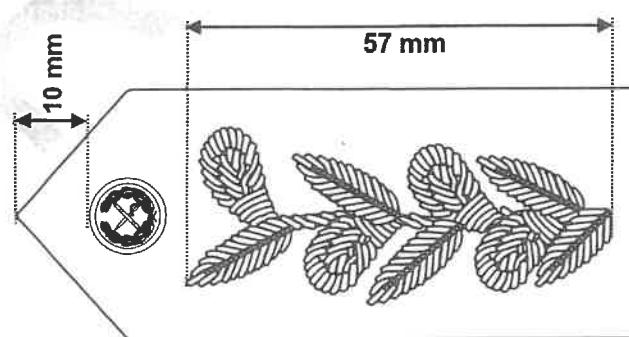
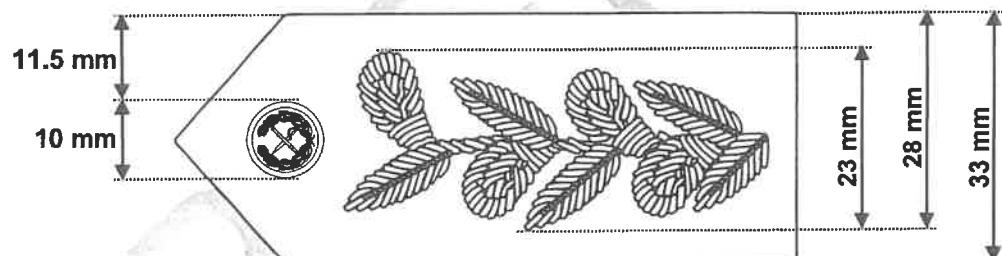


9.2 Dimensions of Miniature gorget patch

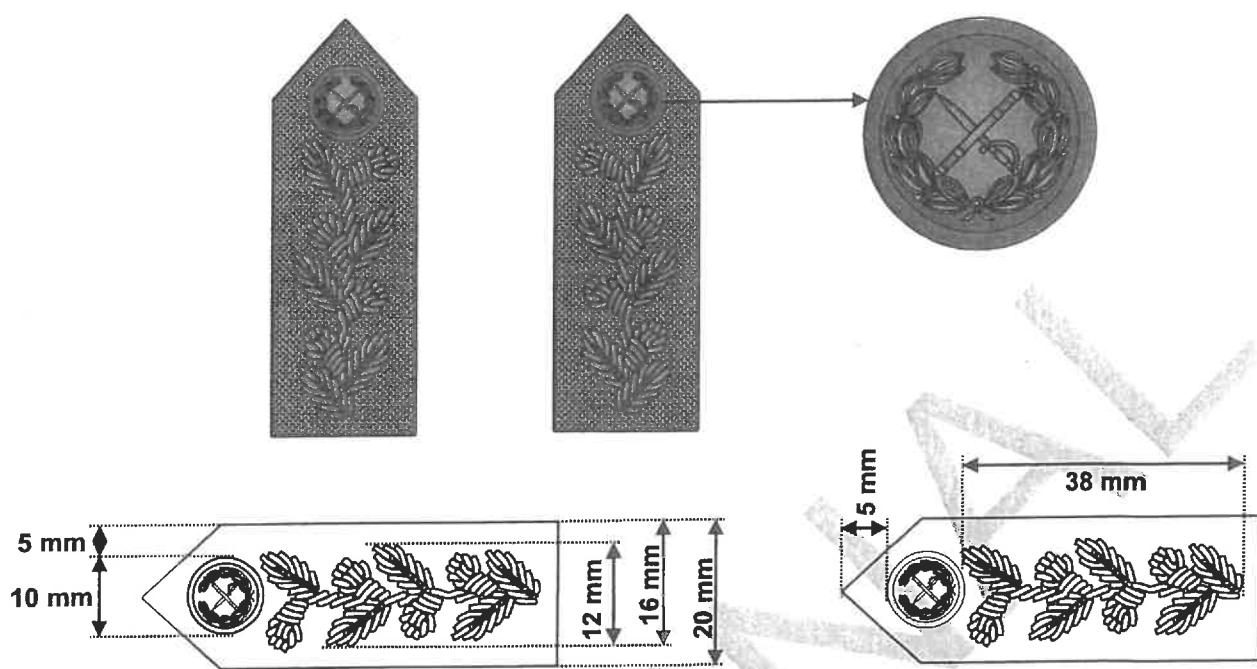


10. Decorative designs

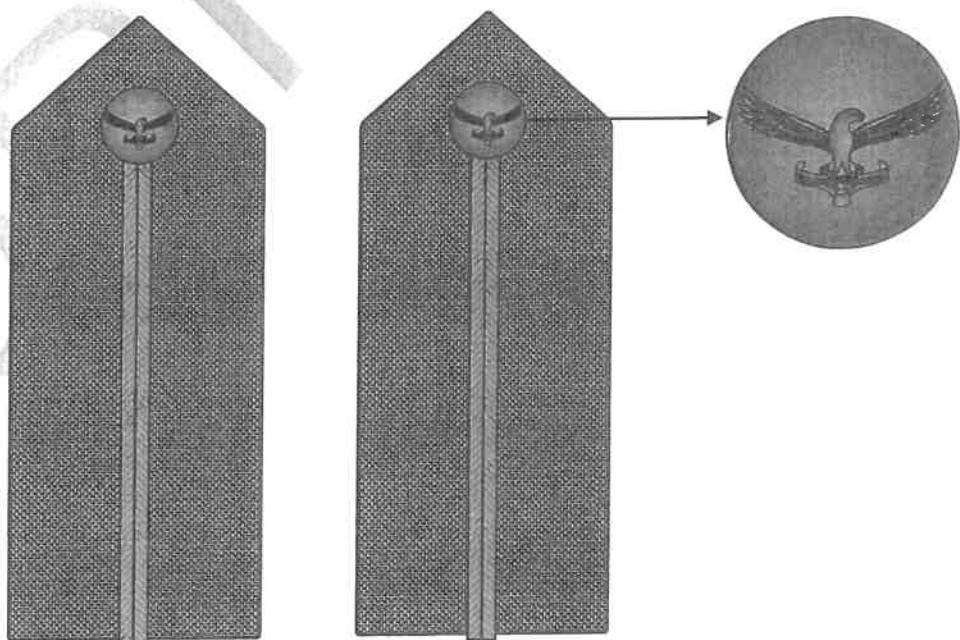
10.1 General, Regular: Gold wire embroidery



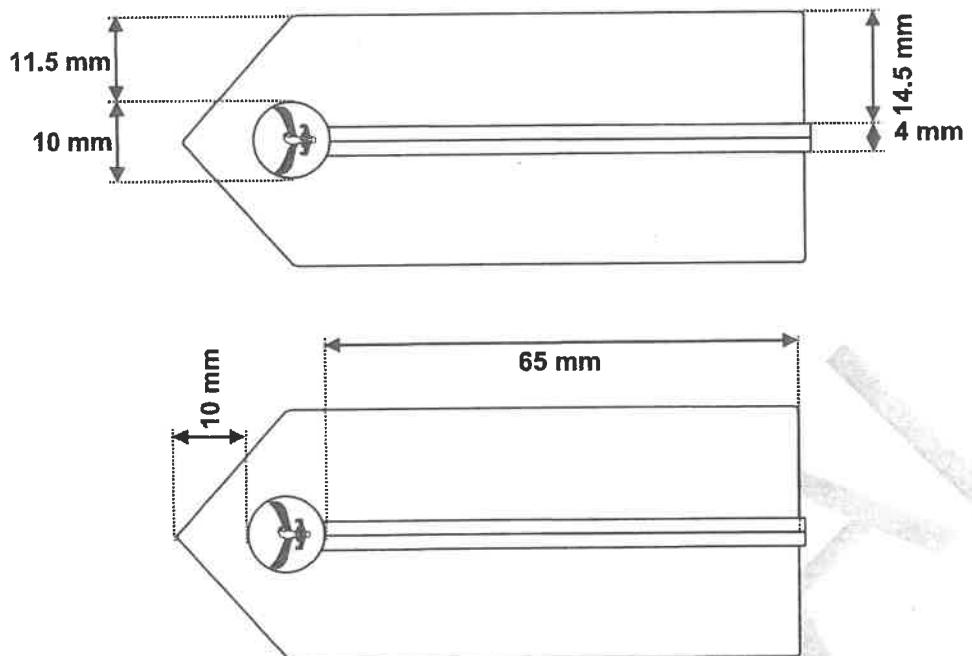
10.2 General, Miniature: Gold wire embroidery



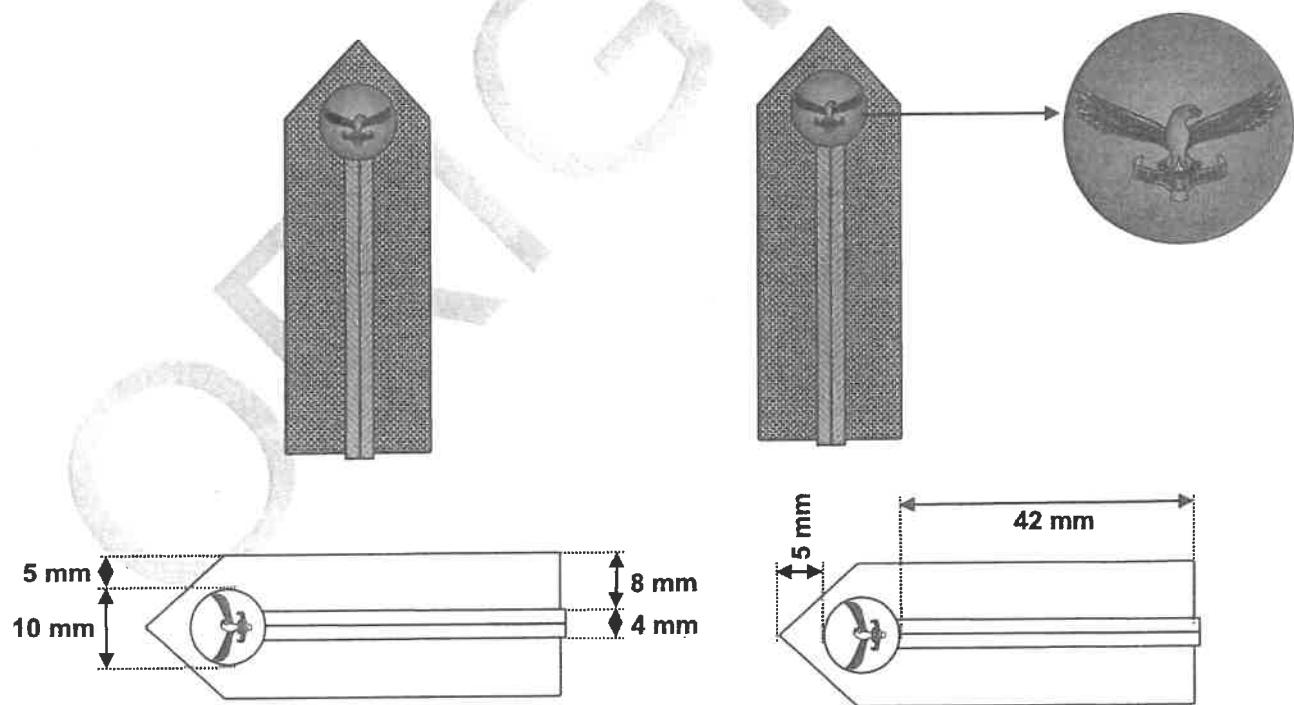
10.3 Staff Qualified Colonel, Regular: Piping braid



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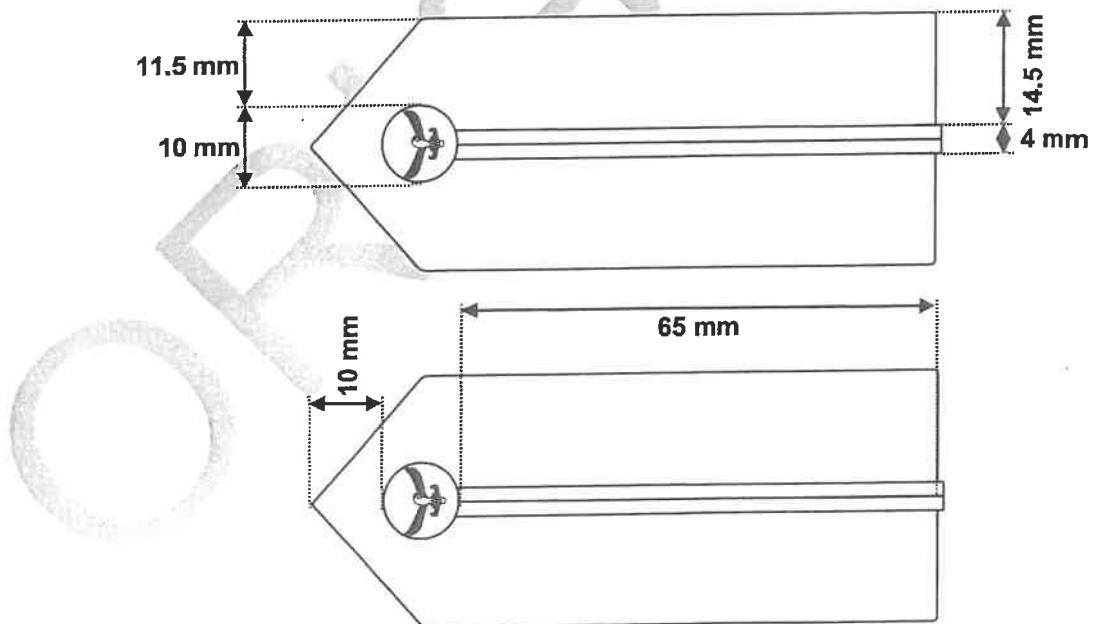
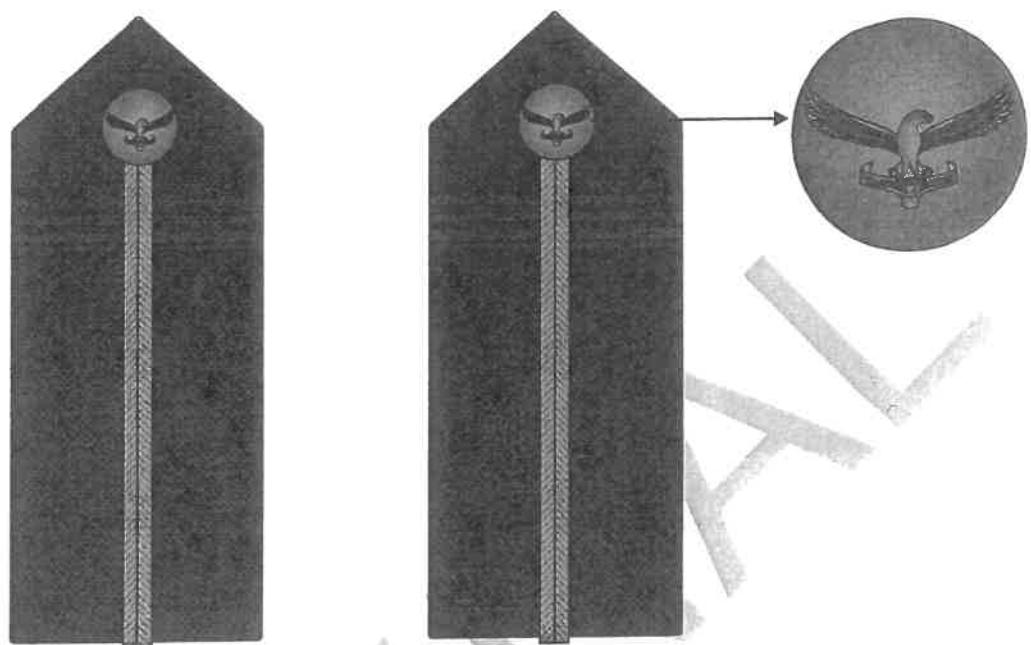


10.4 Staff Qualified Colonel, Miniature: Piping braid

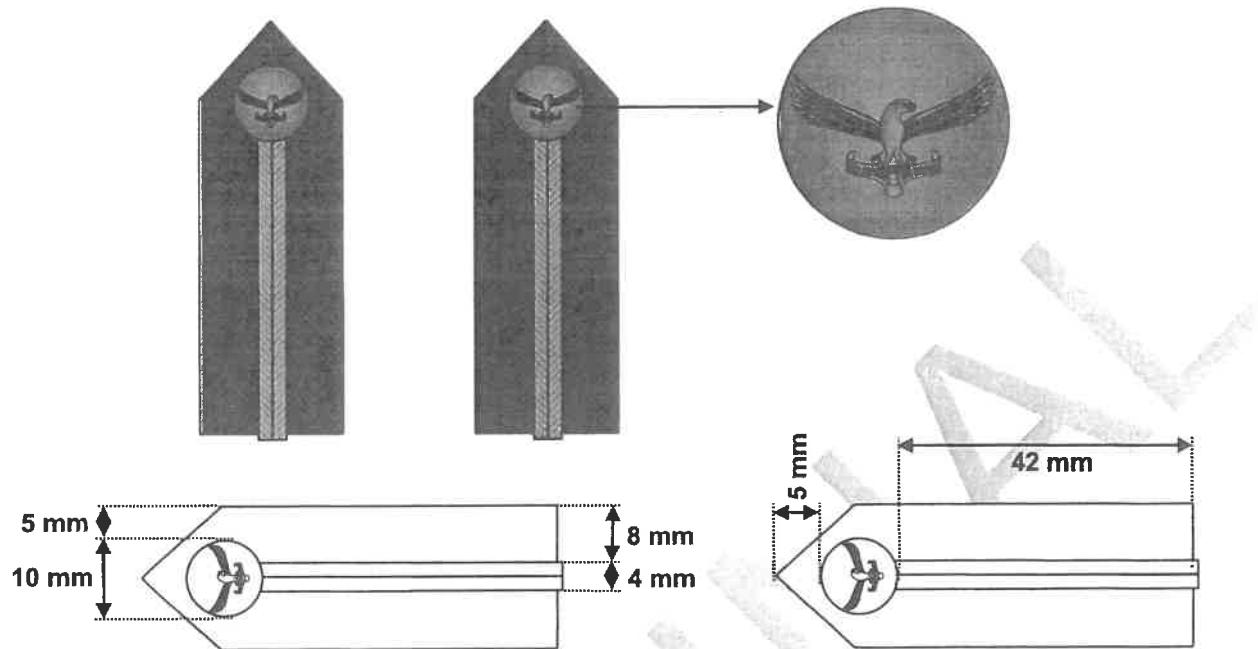


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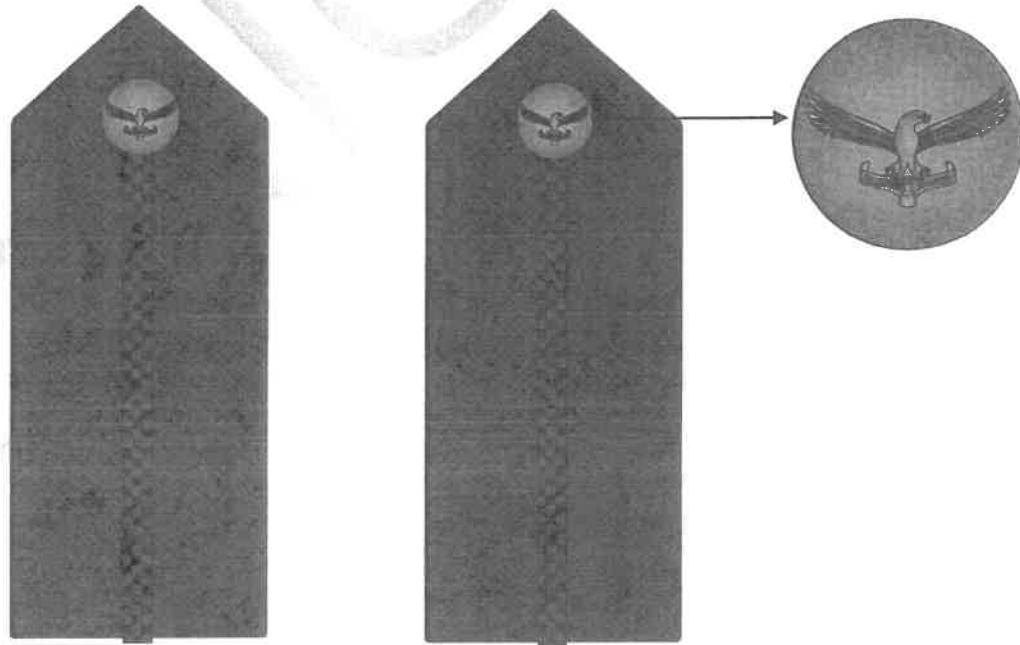
10.5 Colonel Chaplain, Regular: Piping braid



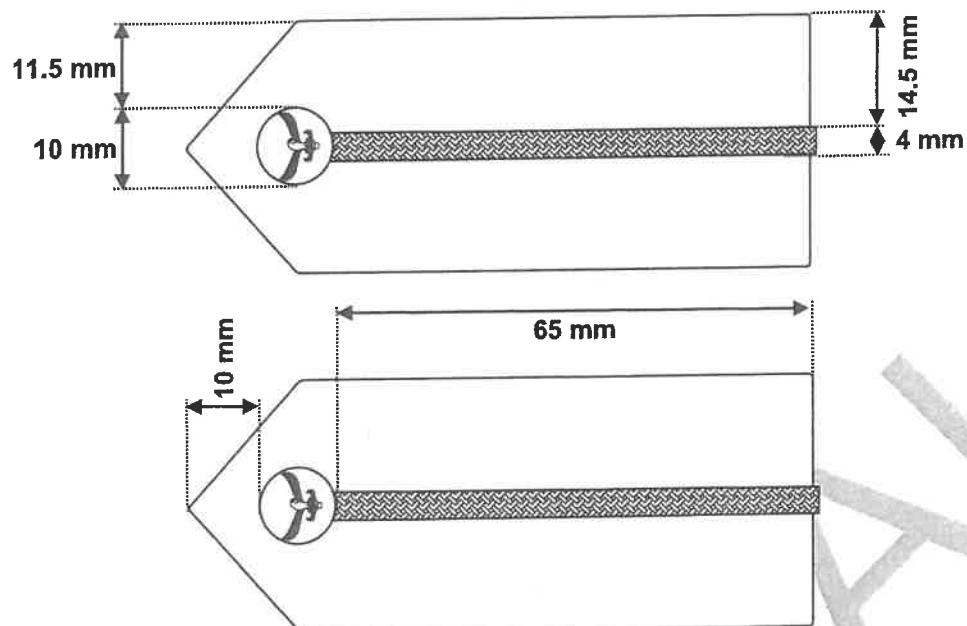
10.6 Colonel Chaplain, Miniature: Piping braid



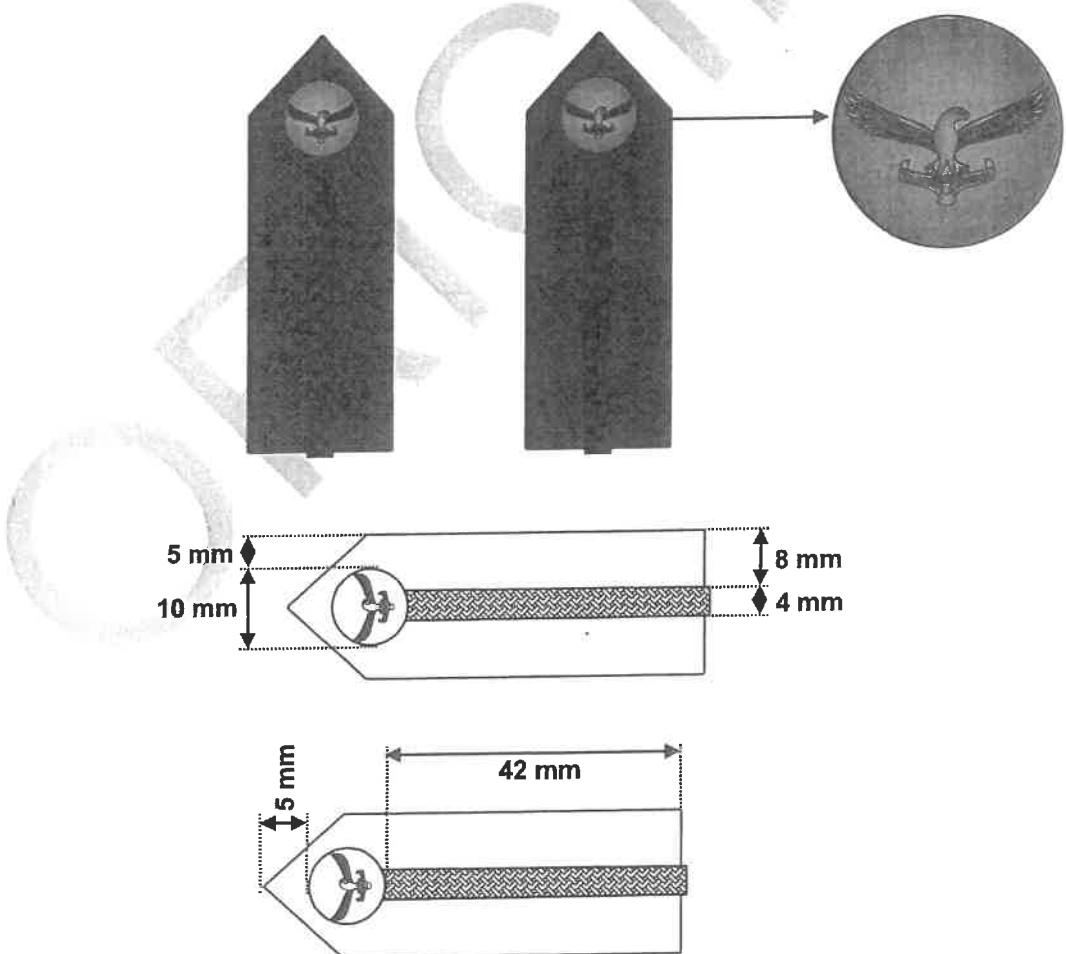
10.7 Non-staff Qualified Chaplain, Regular: Flat braid



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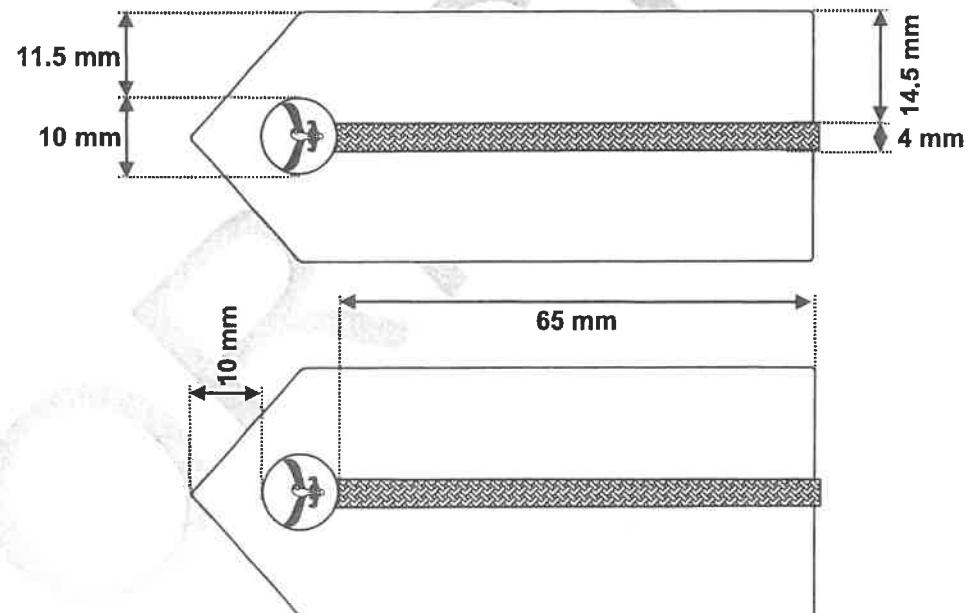
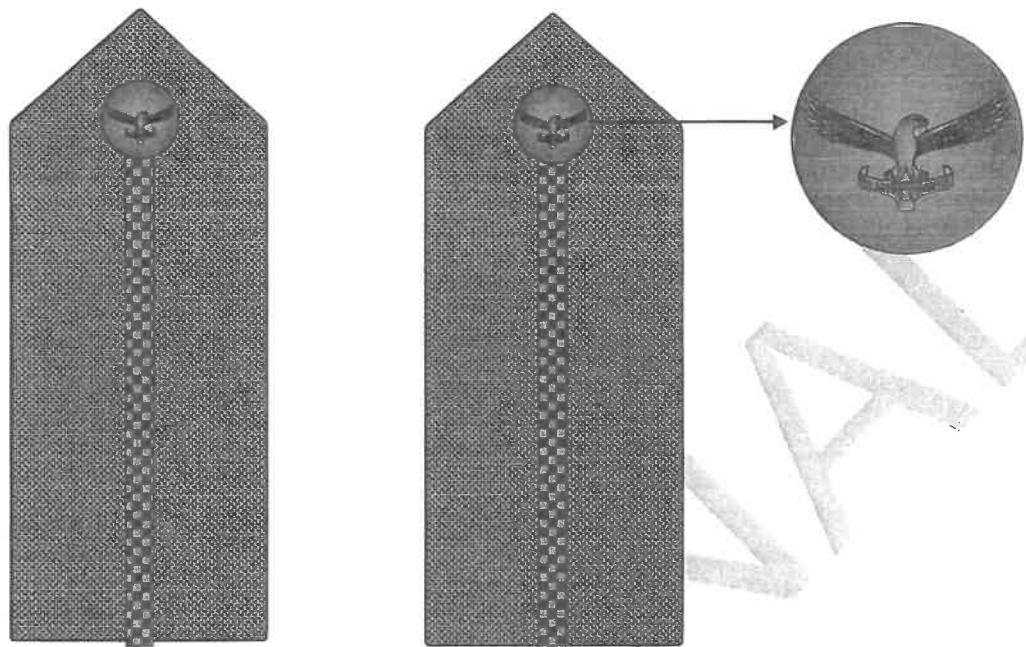


10.8 Non-Staff Qualified Chaplain, Miniature: Flat braid

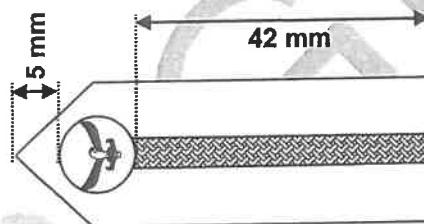
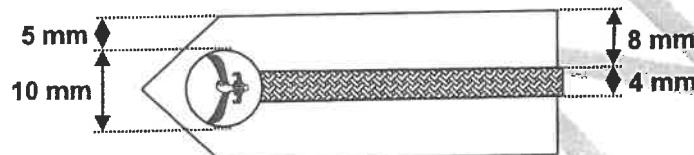
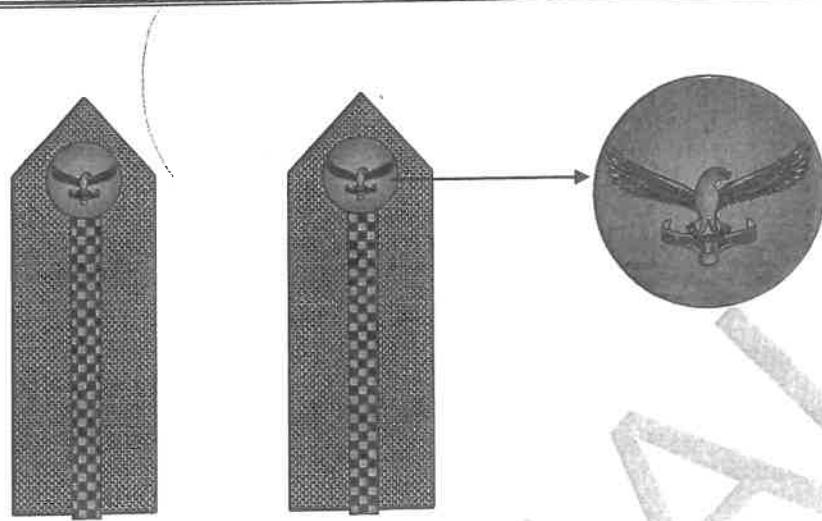


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10.9 Non-staff Qualified Colonel, Regular: Flat braid



10.10 Non-staff Qualified, Miniature: Flat braid



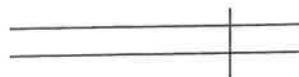
11. Stitches, Seams and Stichings

11.1 Stitches

All stitches: hand-felling stitch

11.2 Seams

Seams: seam type SSA



Superimpose two or more plies of material and seam with the appropriate number of rows of stitches positioned at the specified distance(s) from the aligned edges.

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11.3 Number of stitches

The determination of sewing stitches per unit length will be done in accordance with SANS 5278
"Sewing stitches per unit length"

seams: 40 ± 4 per 10 cm

12. Packing and marking of packaging

12.1 Packing

12.1.1 The gorgets shall be:

- delivered in a commercially dry condition
- so packed that they will not be damaged in transit or in storage
- packed as given in table 6

Table 6 - Packaging

1 PACKAGING MATERIAL ^a		2 CONTAINING ^b
A.	Small plastics envelope	1 pair gorget patches and four clutches
B.	Bulk plastics envelope with pull and press opening and closure	Envelopes of A
C.	Bulk container for transit	Envelopes of B
C.1	Large quantities: acceptable bulk containers that comply with the requirements of SALM 108	
C.2	Small quantities: bulk containers to have a maximum height of 278 ± 3 mm	
^a Of suitable size and shape.		
^b Of the same designation.		

12.1.2 Gorgets:

- of the same designation to be packed together in a bulk container (unless quantities ordered are such that packing together of the same designation only is not justified)
- of different designations may also be packed together to accommodate the last part of an order or contract

12.2 Marking of packaging

12.2.1 Plastics envelopes:

Each plastics envelope to be clearly marked with the following information:

- the designation, e.g. "Gorget patch, General, Regular"
- the National Stock Number
- the year of manufacture
- the manufacturer's name or trademark
- the order or contract number

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12.2.2 Bulk containers:

Each bulk container shall be labelled as given in paragraph 11.2 of SALM 108 "Corrugated board boxes for clothing".

12.3 Additional marking

When so required by the South African Air Force, gorgets, clutches, plastics envelopes or bulk containers (or any combination of these) to bear information additional to that specified above.

13. Normative References

The following documents contain provisions which, through reference in this text, constitute provisions of this specification. All documents are subject to revision and, since any reference to a document is deemed to be a reference to the latest edition of that document, parties to agreements based on this specification are encouraged to take steps to ensure the use of the most recent editions of the documents indicated below. Information on currently valid national, international and CKS documents may be obtained from Standards South Africa*.

CKS 129, Colours for textiles.

SALM 108, Corrugated board boxes for clothing.

SANS 346, Woven worsted fabrics.

SANS 1254, Fusible interlinings.

SANS 1362, Sewing threads.

SANS 5278, Sewing stitches per unit length.

SANS 10371, Terms and definitions for clothing.

SANS 10076-5, The assessment of defects in textile piece-goods and made-up articles, Part 5: Defects in woven woollen and worsted piece-goods.

* Standards South Africa: Tel. +27 (0) 12 4287911

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ANNEX A
(Normative)

Special conditions of tender

A-1 GENERAL

A-1.1 Unless otherwise stated, the South African Air Force or an appointed SANAS accredited inspection body shall be the inspecting authority.

A-1.2 Three pre-production sample gorget patch pairs (of each different rank and size ordered), shall have been inspected, tested and approved by the inspecting authority before bulk production is commenced. Each pair of these samples shall be accompanied by a trim chart containing a sample of each component material (as given in 6) and the relevant certificates. It shall be the duty of the manufacturer to give adequate notice to the inspecting authority of the availability of these samples.

A-1.3 The gorgets shall be subject to inspection during the course of manufacture. The inspector shall, during normal working hours, be given all reasonable facilities for carrying out his duties and shall have the right of entry into the contractor's factory and the factory or works of any subcontractor where work on gorgets supplied to this specification may be in progress

A-1.4 The contractor shall inspect the finished gorgets for compliance with the specification before submitting them to the inspecting authority for final inspection.

A-1.5 Before acceptance, the gorgets shall have been inspected and tested by the inspecting authority and found to comply with the requirements of the specification.

A-2 DOCUMENTATION

One container of each consignment shall be marked "DOCUMENTS" and in addition to the gorgets, shall contain the following:

- a) The packaging slip or delivery note;
- b) where applicable the inspection certificate(s);
- c) a copy of the invoice containing the following information:
 - the order number
 - the financial authority number
 - a full description of the consignment, i.e. NSN, quantity, etc

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ANNEX B

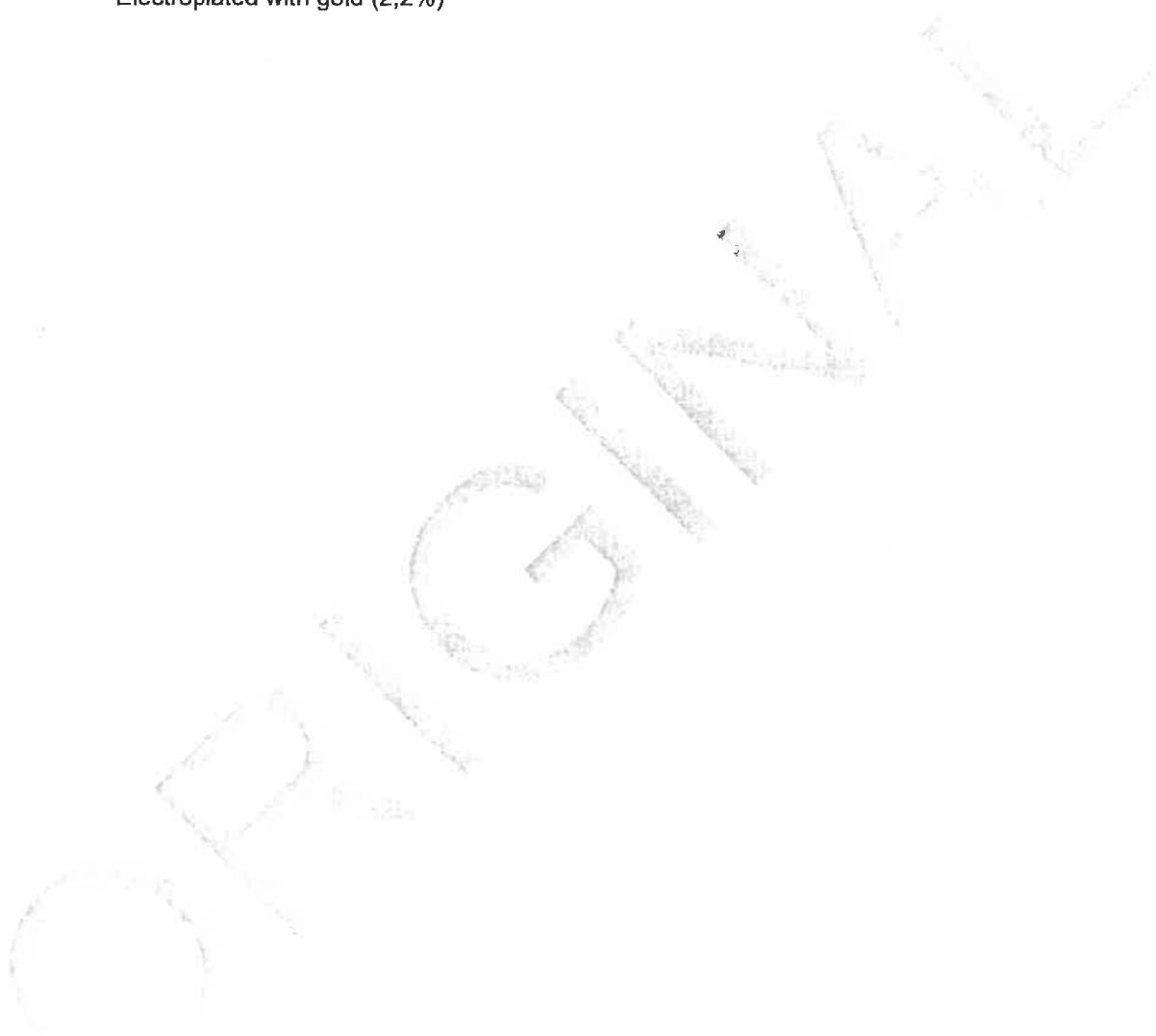
(Normative)

Additional information on the composition of the wire

Base alloy(white metal): Copper – 95%; Nickel – 5 %

Electroplated with silver (1%)

Electroplated with gold (2,2%)



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For office use only

HISTORY SHEET

VERSION	DATE	AMENDMENTS/HISTORY		
1		First release		
2	May 1997			
3	August 2008	<ul style="list-style-type: none"> a) Updated format and layout of spec. b) Add Annex B and C. c) Add miniature gorgets. d) Update colour references. e) Update embroidery wire references. f) Delete references to other Forces. g) Add reference to brass plate and prong fastening mechanism. 		
4	January 2011	<ul style="list-style-type: none"> a) Shorten length of prong on back to 8 mm (+1 mm) 		
5	July 2014	<ul style="list-style-type: none"> Add two new types of gorget patches Change clutch type Change braid/piping application 		
6	February 2019	<ul style="list-style-type: none"> Amend pin/prong length to be 10 mm long Amend Annex A and C Update normative references 		
7	April 2020	<ul style="list-style-type: none"> SAAF to supply outer material Delete Annex C (Since SAAF supply the fabric, the colour registration does not concern the gorget manufacturer) 		

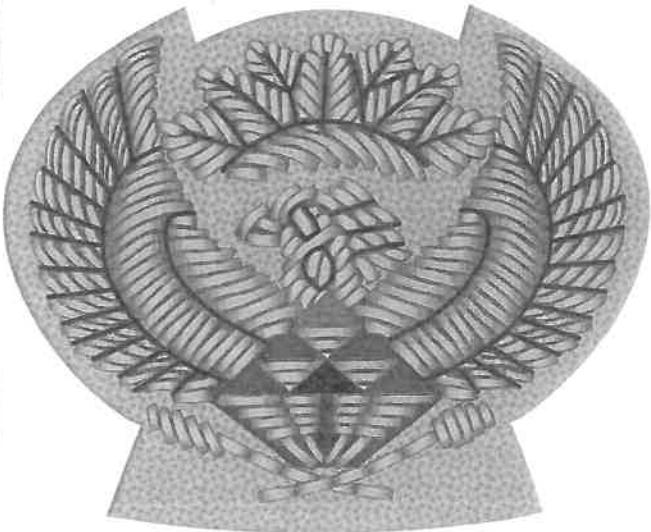
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PRIVATE SPECIFICATION

Prepared for the
South African Air Force



HAND EMBROIDERED CAP BADGES
For
General Officers
Chief Warrant Officers
Senior Chief Warrant Officers



SALM 581
Version 03.0/April 2012

1. Scope

This specification covers the materials, make and design of hand embroidered cap badges for personnel of the South African Air Force. The specification covers cap badges for ranks as given in table 1.

Table 1 – Cap badge variations

1 Rank	2 National Stock Number
Chief Warrant Officer & Senior Chief Warrant Officer	8445-18-187-6369
General Officers	8445-18-175-0275

2. Definitions and Abbreviations

For the purpose of this specification the definitions given in SANS 10371 "Terms and definitions for clothing" and the following shall apply:

acceptable: acceptable to the South African Air Force

assaying: the testing of a metal or ore to determine its ingredients and quality

inductively coupled plasma (ICP): precise and accurate multi-element analytical technique for the determination of trace elements in a variety of liquid and solid sample materials

nominal: subject to the tolerances normal to good manufacturing practice

NSN: National Stock Number as reflected as Item Number on a Government Order

SANS: South African National Standard

X-ray fluorescent spectrometry: is a non-destructive analytical technique used to identify and determine the concentrations of elements present in solid, powdered and liquid samples

3. Style

The style is as follows:

- ◆ melton base fabric
- ◆ fully lined (backed) with calico fabric
- ◆ non-woven filler sandwiched between the base fabric and lining
- ◆ fitted with two different embroidered designs (depending on rank)
 - gold wire
 - cotton embroidery thread

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4. Illustrations

Illustrations are not to scale and are for guidance only.



Figure 1 – Embroidered cap badge for General Officers



Figure 2 – Embroidered cap badge for Chief Warrant Officers/Senior Chief Warrant Officers

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5. Client Furnished Materials

No materials will be supplied by the South African Air Force.

6. Component Materials

The following materials shall be supplied and used by the manufacturer. Trim charts shall also be submitted by the manufacturer (see Annex A).

6.1 Base fabric

- ◆ be a woollen melton fabric
- ◆ nominal mass per area of 360 g/m² when tested in accordance with SANS 79 (or SANS 80 in case of a dispute)
- ◆ colour to be a match, in terms of SANS 10076-5, "The assessment of defects in textile piece-goods and made-up articles Part 5: Defects in woven woollen and worsted piece-goods", to colour No 509c-96¹ "SAAF Flight blue" of CKS 129 "Colours for textiles"

6.2 Backing fabric

- ◆ an acceptable black calico fabric
- ◆ of nominal mass per area 160 g/m² when tested in accordance with SANS 79 or 80 (as relevant)
- ◆ comply with the performance requirements as given in SANS 1401-7 "Woven cotton and similar household fabrics and articles Part 7: Cotton curtain lining"

6.3 Gold wire (for embroidery)

- ◆ shall be tubular
- ◆ type and finished used:
 - Matt or Bright tubular gold wire
 - Frisé tubular gold
 - Lamé gold
 - Jacerón
 - to be as given in section 10
- ◆ tubular wire to have a nominal outside diameter of 0,8 mm
- ◆ to be tarnish treated and the composition shall be as given in table 2
- ◆ colours to be acceptable matches to the relevant colours of the sealed samples held by the South African Bureau of Standards²
- ◆ content shall be tested by the following
 - assaying, X-ray fluorescent spectrometry, inductively coupled plasma (ICP)

Table 2 – Composition of gold wire^a

Metal type	Content %
Gold	2 (min.)
Silver	1
Nickel	5
Copper	92

^a See Annex B.

¹ See Annex C.

² South African Bureau of Standards: Tel. +27 (0) 12 4286281

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6.4 Filler

- ♦ acceptable non-woven filler

6.5 Thread for attaching the gold wire

- ♦ 100% polyester
- ♦ ticket No. 50
- ♦ colour to be an acceptable match to the colour with which it is used

6.6 Cotton embroidery thread

- ♦ 100% cotton hand embroidery thread
- ♦ colours to be as given in table 3

Table 3 – Colours of cotton embroidery thread ^a

1	2	3
Colour	CKS 129 Colour No	Colour Title
Red	2203c-96	National Flag Red
Black	2201c-96	National Flag Black
Green	2205c-96	National Flag Green

^aSee Annex C.

6.7 Thread for definition

- ♦ 100% polyester
- ♦ ticket No. 80
- ♦ colour to be black

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7. Workmanship

The embroidered badges shall be:

- ◆ cut, made and embroidered with first-class workmanship throughout
- ◆ of uniform and acceptable make, colour and finish
- ◆ durable at all times and no separation shall occur between the adhesive, base fabric and backing cloth

Embroidery shall be free from:

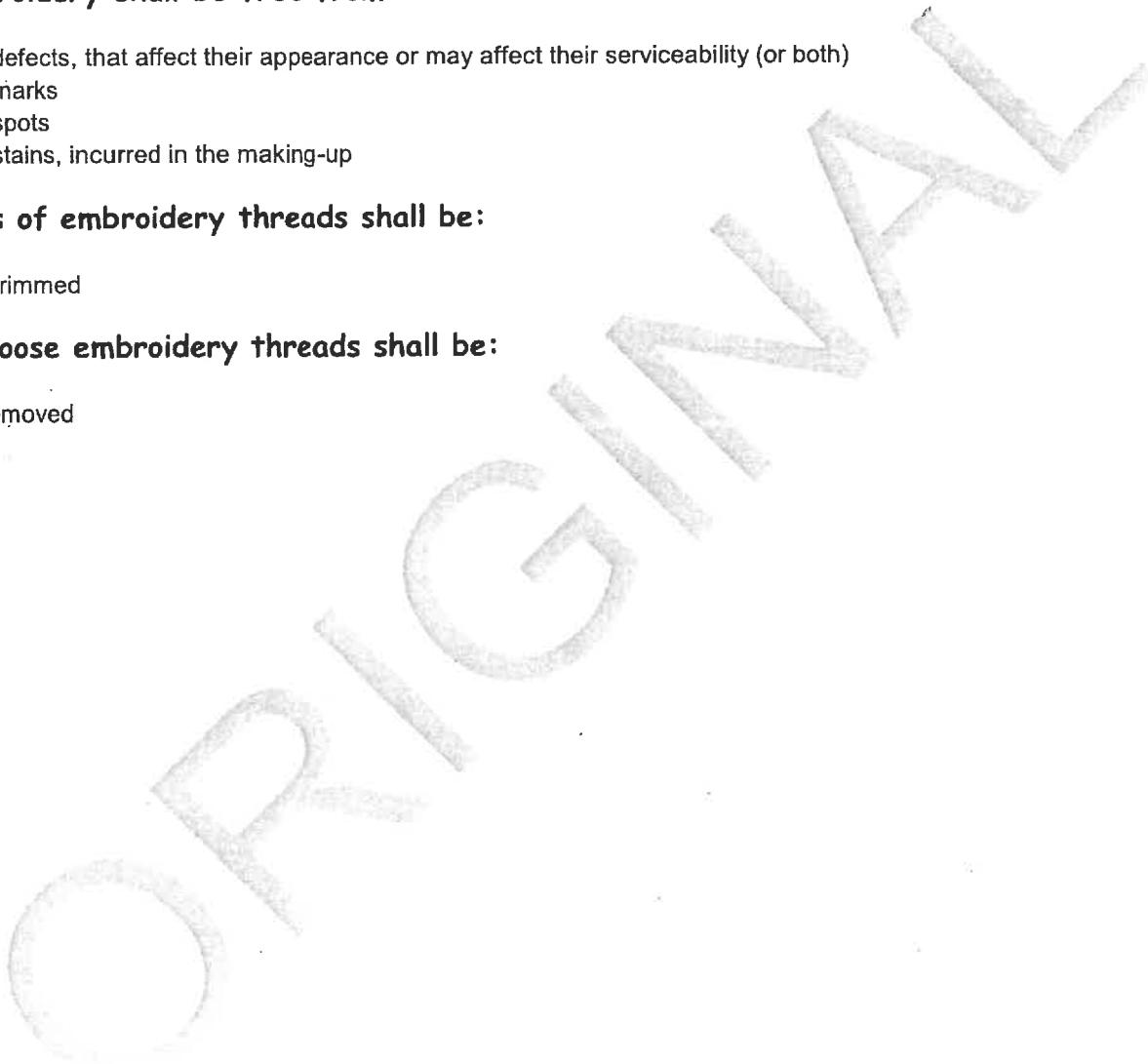
- ◆ defects, that affect their appearance or may affect their serviceability (or both)
- ◆ marks
- ◆ spots
- ◆ stains, incurred in the making-up

Ends of embroidery threads shall be:

- ◆ trimmed

All loose embroidery threads shall be:

- ◆ removed



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8. Sizes and dimensions

A tolerance of ± 2 mm applies to all measurements.

8.1 General Officers

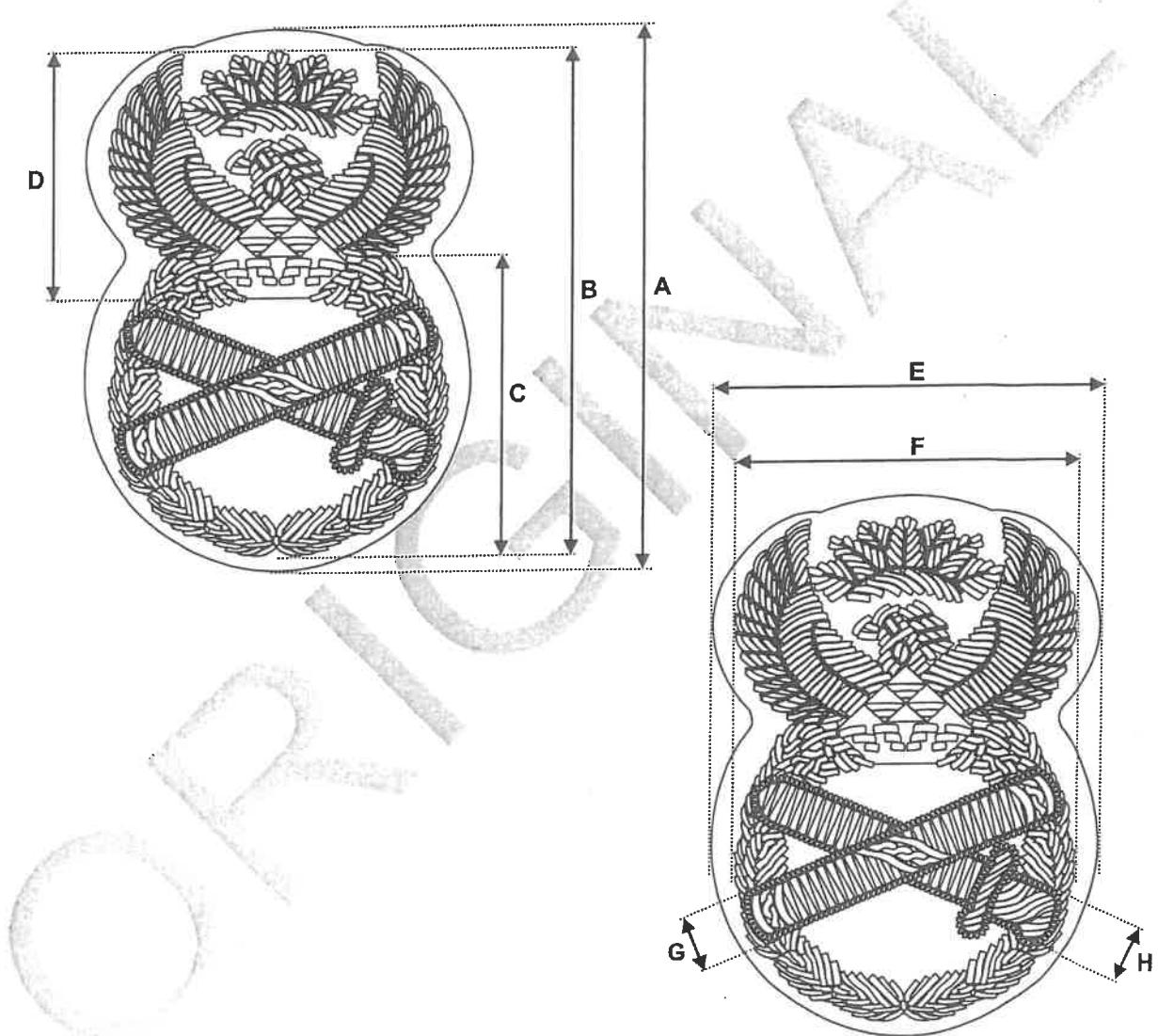


Table 4 – Dimensions of cap badge: General Officers

Item	A	B	C	D
Cap badge, General Officers	70 mm	64 mm	38 mm	32 mm
	E	F	G	H
	50 mm	43 mm	6 mm	5 mm

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8.2 Chief Warrant Officer/Senior Chief Warrant Officer

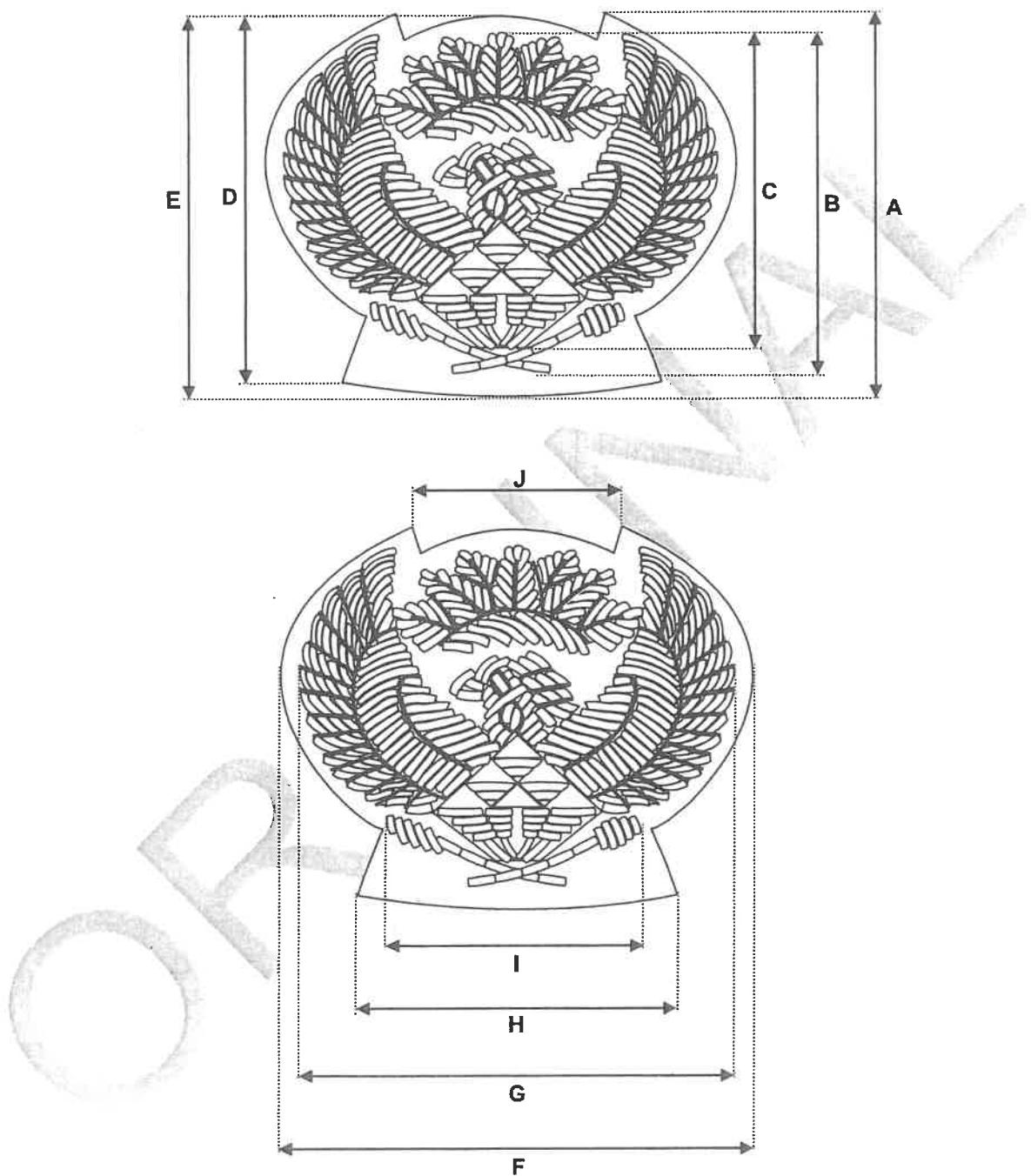


Table 5 – Dimensions of cap badge: Chief Warrant Officer & Senior Chief Warrant Officer

Item	A	B	C	D	E
Cap badge, CWO & SCWO	44 mm	40 mm	35 mm	41 mm	43 mm
	F	G	H	I	J
	51 mm	47 mm	33 mm	26 mm	25 mm

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9. Make

Illustrations are not to scale and are for guidance only, and unless inconsistent with the text, all measurements are nominal.

9.1 Construction requirements

Each badge shall be:

- ◆ made of base fabric
- ◆ fully lined with backing fabric
- ◆ fitted with filler in the centre
- ◆ embroidered with gold wire and cotton embroidery thread
- ◆ 100% proportionate in size to the relevant sealed sample

Base material and backing fabric shall be:

- ◆ bonded in such a way that the bonded unit:
 - has a uniform finish
 - is free from perforations, untreated areas and other imperfections (e.g. blisters and ripples)
 - can withstand dry-cleaning
- ◆ acceptably finished that no fraying shall occur along the cut edges

Adhesive used for bonding shall:

- ◆ not contain any constituent that may have a toxic or irritating effect on the skin
- ◆ be such that it adheres to both materials and will not under any circumstances emit an unpleasant odour

9.2 Lining and filler

Each badge shall be:

- ◆ fully lined with backing fabric
- ◆ partially interlined with filler
 - sandwiched between the base fabric and backing fabric
 - positioned behind the embroidered design to form a domed effect

9.3 Embroidered design

- ◆ centrally positioned on the base fabric
- ◆ to be hand embroidered
- ◆ design to be supplied in two variations as given in 9.3.1 and 9.3.2

9.3.1 General Officers

- ◆ to be made to the dimensions as given in section 8.1
- ◆ comply with the design as given in figure 1
- ◆ design elements to include the following:

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- **Crest of the South African National Coat of Arms**
 - positioned at the top of the badge
 - embroidered with matt and bright gold wire, Frisé gold and cotton hand embroidery thread
 - application of embroidery thread type and finish to be as given in section 10.1
 - pieces of gold wire and cotton embroidery thread shall be laid close together so that no base material is visible between the wire and thread respectively
- **laurel wreath**
 - positioned below the crest
 - to be attached to the side edges of the Protea at the base of the Crest
 - embroidered with tubular matt gold wire (see section 10.1)
 - pieces of gold wire thread shall be laid close together so that no base material is visible between the wire
- **sword and baton**
 - baton to cross and overlap the sword
 - to be centrally positioned, and superimposed on top of the laurel wreath
 - embroidered with tubular matt gold wire thread, Frisé gold, Lamé gold and Jaceron (see section 10.1)
 - the blade of the sword and baton shall be not be flat, but shall incorporate an additional component that shall be concealed by the gold Lamé to create a raised effect

9.3.2 Chief Warrant Officers & Senior Chief Warrant Officer

- ◆ to be made to the dimensions as given in section 8.2
- ◆ comply with the design as given in figure 2
- ◆ design elements to include the following:

- **crest of the South African National Coat of Arms**
 - positioned at the top of the badge
 - embroidered with matt and bright gold wire, Frisé gold and cotton hand embroidery thread
 - application of embroidery thread type and finish to be as given in section 10.2
 - pieces of gold wire and cotton embroidery thread shall be laid close together so that no base material is visible between the wire and thread respectively
- **spear and knobkierie**
 - spear and knobkierie to cross at the base of the protea
 - to be centrally positioned
 - embroidered with Frisé gold (see section 10.2)

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10. Component identification

The black colour-filled section indicates the application of the relevant component and colour.

10.1 General Officers



Base fabric:
Colour No. 509c-96 of CKS 129
"SAAF flight blue"



Polyester embroidery thread (for definition):
Colour No. 2201c-96 of CKS 129
"National flag black"



Cotton embroidery thread:
Colour No. 2203c-96 of CKS 129
"National flag red"



Cotton embroidery thread:
Colour No. 2205c-96 of CKS 129
"National flag green"

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Cotton embroidery thread:
Colour No. 2201c-96
"National flag black"



Gold Lamé



Matt Gold wire



Bright Gold wire

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Frisé Gold



Jaceron

10.2 Chief Warrant Officer/Senior Chief Warrant Officer



Base fabric:
Colour No. 509c-96 of CKS 129
"SAAF flight blue"



Polyester embroidery thread (for definition):
Colour No. 2201c-96 of CKS 129
"National flag black"

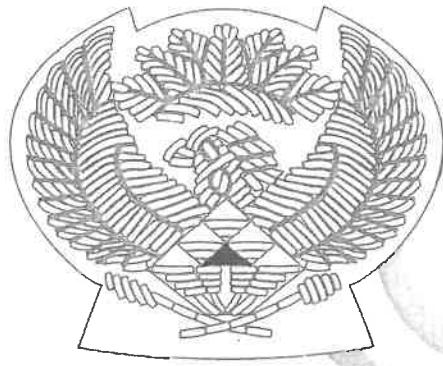
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Cotton embroidery thread:
Colour No. 2203c-96 of CKS 129
"National flag red"



Cotton embroidery thread:
Colour No. 2205c-96 of CKS 129
"National flag green"



Cotton embroidery thread:
Colour No. 2201c-96
"National flag black"



Matt Gold wire



Bright Gold wire



Frisé Gold

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11. Packing and marking of packaging

11.1 Packing

11.1.1 The badges shall be:

- ◆ delivered in a commercially dry condition
- ◆ so packed that they will not be damaged in transit or in storage
- ◆ individually packed in a plastics envelope with a pull and press opening of suitable size and shape, then packed in a bulk plastics envelope with a pull and press opening of suitable size and shape
- ◆ unless otherwise specified in the order or contract, the bulk plastics envelopes shall be acceptably packed for transit in acceptable bulk containers that comply with the requirements of SALM 108, "Corrugated board boxes for clothing"

11.1.2 Badges:

- ◆ of the same item description to be packed together in a bulk plastics envelope AND bulk container (unless quantities ordered are such that packing together of the same item description is not justified)
- ◆ of different item descriptions may also be packed together to accommodate the last part of an order or contract

11.2 Marking of packaging

11.2.1 Small plastics envelopes:

Small plastics envelope to be clearly marked with the following information:

- ◆ the item description
- ◆ the NSN
- ◆ the manufacturer's name or trademark
- ◆ the year of manufacture

11.2.2 Bulk plastics envelopes:

Bulk plastics envelope to be clearly marked with the following information:

- ◆ the item description
- ◆ the NSN
- ◆ the manufacturer's name or trademark
- ◆ the year of manufacture
- ◆ the quantity

11.2.3 Bulk containers:

Each bulk container shall be labelled as given in paragraph 11.2 of SALM 108 "Corrugated board boxes for clothing".

11.3 Additional marking

When so required by the South African Air Force, badges, individual plastics envelopes, bulk plastics envelopes or bulk containers (or any combination of these) to bear information additional to that specified above.

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12. Normative References

The following documents contain provisions which, through reference in this text, constitute provisions of this specification. All documents are subject to revision and, since any reference to a document is deemed to be a reference to the latest edition of that document, parties to agreements based on this specification are encouraged to take steps to ensure the use of the most recent editions of the documents indicated below. Information on currently valid national, international and CKS documents may be obtained from SABS Standards Sales*.

SALM 108, *Corrugated board boxes for clothing*.

SANS 79, *Textiles – Mass per unit area of conditioned fabrics*.

SANS 80, *Mass (oven-dry plus conventional allowance) per unit area of textile fabrics, free from non-fibrous material*.

SANS 1401-7, *Woven cotton and similar household fabrics and articles Part 7: Cotton curtain lining*.

SANS 10371, *Terms and definitions for clothing*.

SANS 10076-5, *The assessment of defects in textile piece-goods and made-up articles, Part 5: Defects in woven woollen and worsted piece-goods*.

* South African Bureau of Standards: Tel. +27 (0) 12 4287911

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ANNEX A

(Normative)

Special conditions of tender

A-1 GENERAL

A-1.1 Unless otherwise stated, the South African Bureau of Standards shall be the inspecting authority.

A-1.2 Three pre-production sample embroidered badges of each rank, shall have been inspected, tested and approved by the inspecting authority before bulk production is commenced. The sample embroidered badges shall be accompanied by a trim chart containing a sample of each component material (as given in 6) and the relevant certificates. It shall be the duty of the manufacturer to give adequate notice to the inspecting authority of the availability of the sample.

Note: In instances where a new tender has been awarded and the successful tenderer had previously manufactured embroidered badges according to the SAAF specification, the tenderer may apply for re-sealing of a previously submitted pre-production sample embroidered badge. The re-sealing will be allowed at the discretion of the South African Air Force and is applicable to pre-production samples not older than three years.

A-1.3 The badges shall be subject to inspection during the course of manufacture. The inspector shall, during normal working hours, be given all reasonable facilities for carrying out his duties and shall have the right of entry into the contractor's factory and the factory or works of any subcontractor where work on badges supplied to this specification may be in progress.

A-1.4 The contractor shall inspect the finished badges for compliance with the specification before submitting them to the inspecting authority for final inspection.

A-1.5 Before acceptance, the badges shall have been inspected and tested by the inspecting authority and found to comply with the requirements of the specification.

A-2 DOCUMENTATION

One container of each consignment shall be marked "DOCUMENTS" and in addition to the badges, shall contain the following:

- a) The packaging slip or delivery note;
- b) where applicable the inspection certificate(s);
- c) a copy of the invoice containing the following information:
 - the order number
 - the financial authority number
 - a full description of the consignment, i.e. National Stock Number, quantity, etc

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ANNEX B

(Normative)

Additional information on the composition of the wire

Base alloy(white metal): Copper – 95%; Nickel – 5 %

Electroplated with silver (1%)

Electroplated with gold (2,2%)

ANNEX C

(Normative)

CKS 129 Colours

Due to the fact that colours can change over a period of time, any colour standard which has been registered for a period of SEVEN YEARS or more shall be considered obsolete. These standards shall then be allocated an archived status (as opposed to current status) and re-registration shall be required.

NOTE: *Before fabric is sent to SABS for colour registration purposes, the successful tenderer shall confirm with SABS whether the submission of fabric is required or not.*

A. The following scenarios require a submission of three metres of fabric from the successful tenderer:

1. A colour standard is archived.
2. First time registration is required (CKS 129 colour number does not exist).
3. Colour swatch stock at the SABS is no longer available.

B. Requirements for the submission of fabric as identified in A:

1. The colour shall be as agreed upon between the South African Air Force and the successful tenderer.
2. The fabric shall be used to make new colour swatches which shall be the responsibility of the SABS.
3. The cost of the three metres of fabric shall be incorporated in the relevant tender submission.

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HISTORY SHEET

VERSION	DATE	AMENDMENTS/HISTORY	CHECKED	
			NAME	INIT.
1	May 2002	First release		
2	June 2010	<ul style="list-style-type: none"> a) Updated format and layout of spec. b) Add definitions and illustrations. c) Delete reference to withdrawn standard SANS 941. d) Amended gold wire composition. Add annex B. e) Add reference to filler. f) Change mass of base fabric and lining according to manufacturer's information. g) Change thread requirements according to manufacturer's information. 		
3	April 2012	<ul style="list-style-type: none"> a) Add badges for ranks Chief Warrant Officer and Senior Chief Warrant Officer 		

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