

Windbreakers, men's**1 Scope**

This specification covers the material, cut, make and trim of windbreakers, for use by male personnel employed by Transnet Limited.

Item No. 35/91588 Transnet

Notes:

1 The following requirements will be specified in tender invitations and in each order or contract:

The item(s) required (see 1)

The size(s) required (see 4.4)

The packing, if other than as specified (see 5.1)

Additional marking, if required (see 5.4)

Special conditions of tender (which cover the conditions of acceptance of the windbreakers) are given in annex A.

2 Normative references

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

CKS129, *Colours for textiles*.

CKS 627, *Fusible interlinings*.

SABS 1822 *Slide (zip) fasteners*.

SABS 1309, *Printed labels for textiles*.

SABS 1360-1, *Size designation of clothes - Part 1: Men's and boys' outerwear garments*.

SABS 1362, *Sewing threads*.

SABS 011, *Care-labelling of textiles and clothing*.

SABS 0101, *Standard nomenclature for stitches, seams and stitchings*.

SABS 0188, *Standard methods of garment measurement*.

3 Definitions

For the purposes of this specification the following definitions shall apply:

3.1 Acceptable: Acceptable to Transnet Limited.

3.2 Nominal: Subject to the tolerances normal to good manufacturing practice.

4 Requirements**4.1 Materials**

The following polyester-and-viscose fabric shall be supplied and used by the manufacturer.

Cloth twill colour: "navy" no 2105 c/1997 of CKS 129 65% polyester and 35% viscose

specifications: SABS 1387 – 11 / Latest / type RPR 66

4.1.1 General

The materials specified in 4.1.2 to 4.1.9 (inclusive), all of a colour that is an acceptable match to that of the outer material, shall be supplied and used by the manufacturer.

4.1.2 Lining

A polyester lining that complies with the requirements for type L61P of SABS 1387- 7.

4.1.3 Interlining

An acceptable fusible woven or non-woven interlining that complies with the requirements of CKS 627 for interlinings that are suitable for use in garments that may be dry-cleaned or washed or both.

NOTE - The selection of interlining of appropriate mass per unit area shall be determined by consultation with the suppliers of the interlining.

4.1.4 Wadding

A polyester wadding of nominal mass per unit area 85 g/m².

4.1.5 Slide fasteners

- a) **Front** One-way open end slide fasteners with plastic moulded elements that comply with the requirements of SABS 1822
- b) **Detachable warm liner** One-way open end slide fasteners with spiral elements that comply with the requirements of SABS 1822

4.1.6 Press-studs

Press-studs of an intrinsically corrosion-resistant chromed base metal of the male and female type. The inside diameter of the hole in the female section shall be at least 5 mm.

4.1.7 Binding tape

An acceptable bias binding tape of nominal width 10 mm.

4.1.8 Threads

4.1.8.1 Sewing thread

The threads shall comply with the relevant requirements of SABS 1362 and shall be as follows:

- a) **sewing and top-stitching thread:** a polyester and cotton core spun thread, or a staple polyester thread, ticket No. 80 (in both cases)
- b) **sewing and binding of warm lining:** a polyester-and-cotton core-spun thread, or a staple polyester thread, ticket No. 120 (in both cases).

4.1.8.2 Embroidery thread

The embroidery thread shall be as follows: A white 100% viscose machine embroidery thread.

4.2 Workmanship

The windbreakers shall be cut and made with first-class workmanship throughout and shall be free from defects that affect their appearance or can affect their serviceability (or both), and from marks, spots and stains incurred in the making-up. All seams shall be smooth and all stitching shall be uniform. Seams and stitching shall be free from twists, pleats and puckers and shall be extensible enough to obviate seam cracking and undue shrinkage in use. All ends of sewing that are not secured in seams or in other sewing shall be adequately back-tacked. All ends of sewing shall have been trimmed and loose threads removed. The windbreakers shall be of uniform and acceptable make, colour and finish, and the matching of the shades of the component parts of a windbreaker shall be such as to be acceptable.

4.3 Style

Each windbreaker shall be single-breasted with a collar, a back and a front yoke, a slide fastener front fastening, two welted side pockets, two inside breast pockets, adjustable cuffs and a detachable warm lining.

4.4 Sizes

The windbreakers shall be supplied in one (or more) of the size designations given in column 1 of table 1, as specified in the order or contract, and their measurements, determined in accordance with SABS 0188, shall conform to the relevant values given in columns 2-8. The patterns shall conform to the specification and to the sealed sample, and shall be drafted by the manufacturer.

Table 1 - Size range

1		2	3	4	5	6	7	8
Size designation 1)		Nominal garment measurements, cm						
		Chest	Back length	Back Width	Under arm sleeve	Depth of scye	Sleeve circ. ²⁾	Cuff circ.
Cm	inches							
72	28	94	74	37	43	26	41	27
77	30	99	74	39	43	26.5	42	28
82	32	104	75	41	44	27.5	43	28
87	34	109	75	43	44	28.5	44	29
92	36	114	76	45	44	29.5	45	29
97	37	119	76	47	45	30.5	46	29
102	38	124	77	49	45	31	47	30
107	40	129	77	51	45	32	48	30
112	42	134	78	53	46	33	49	31
117	44	139	78	55	46	34	50	31
122	46	144	78	57	46	35	51	32
127	48	149	78	59	47	35.5	52	32
132	50	154	80	61	47.5	36	54	33
137	52	159	80	61	48	36.5	56	33
142	56	164	81	63	48.5	37	58	34
147	58	169	81	63	49	37.5	60	34
152	60	174	82	65	49.5	38	62	35
157	62	179	82	65	50	38.5	64	35
162	64	184	82	67	51	39	66	36
1) Based on the chest measurement in centimetres of the intended wearer.								
2) Sleeve circumference measured \pm 30 cm from the crown of the sleeve								

4.5 Make

Note - Unless inconsistent with the text, all measurements are nominal.

4.5.1 Fronts

The foreparts shall be single-breasted (see figure 1), the front edges shall be butted and shall fasten with a slide fastener (see 4.1.5.). Each forepart shall consist of two parts, i.e. a yoke that extends from the shoulder seam to 50 mm above the base of the scye, and a lower section beneath it. The front and back yoke shall be top-stitched 7 mm from the edge. Each forepart shall have an inside breast pocket and a semi-vertical side pocket.

4.5.2 Logo

On the left forepart shall be the appropriate logo screen printed in white or embroidered in an acceptable thread

4.5.3 Pockets

4.5.3.1 Side pockets

Each forepart shall have a semi-vertical welted side pocket. The welts shall be of folded outer material and interlined with interlining (see 4.1.3). The finished length and width shall be 17,5 cm and 45 mm respectively. The free edge shall be top stitched 7 mm from the edge, the sides 2mm and 7 mm from the edge. Each end of each pocket mouth shall be stayed at the back. The pocket bag shall be of lining (see 4.1.2) and not sewn in with the hem.

4.5.3.2 Inside breast pockets

The pocket mouth shall be double jetted, constructed from outer material and of finished length 15 cm, positioned 30 mm below the level of the scye. The pocket bag shall be of lining (see 4.1.2) and the depth shall be 22 cm.

4.5.4 Back

The back (see figure 2) shall consist of two parts, i.e. a yoke that extends from the shoulder seam to 120 mm above the base of the scye, and a lower section beneath it.

4.5.5 Facings and linings

Each forepart shall have an outer material facing that shall be of finished width 45 mm at the shoulder seam shaped to 75 mm at the bottom hem. The stringer of a slide fastener (see 4.1.5) shall be inserted in the front edge seam, between the facing and the forepart. The slide fastener shall extend from the gorge seam of the collar to the bottom edge of the hem. The body and sleeves of the windbreaker shall be fully lined with lining (see 4.1.2) and the bottom of the lining shall have a pleat of at least 15 mm. In each forepart lining, there shall be an inside breast pocket (see 4.5.3.2).

4.5.6 Collar

The collar shall have a separate stand and fall, lined with outer material and interlined with interlining (see 4.1.3). The seam joining the stand and fall shall be folded into the stand section when finished. The stand and fall at the centre back shall be of finished width 35 mm and 60 mm respectively. The points of the collar shall be of finished length 75 mm. The free edges shall be top-stitched 7 mm from the edge.

4.5.7 Sleeves

The sleeves shall be plain two-piece sleeves lined with lining (see 4.1.2). The hind arm seam shall have at the cuff, 20 mm from the edge, a mitred adjustable tab of outer material fused with interlining (see 4.1.3) and lined with outer material. The finished tab shall be of width and length 50 mm and 85 mm respectively. The female section of a press-stud fastener (see 4.1.6) shall be attached to the base of the mitre. Two male sections of press-stud fasteners (see 4.1.6) shall be attached to the hind arm, 60 mm and 110 mm from the hind arm seam.

4.5.8 Detachable lining

The detachable warm lining shall consist of a back and two fronts of one layer of wadding (see 4.1.4) sandwiched between two layers of lining (see 4.1.2) that is quilted in a diamond shape of dimensions 50 mm by 50 mm. The armholes, fronts, bottom and neck shall be bound with binding tape (see 4.1.7). Each front shall have a faced slit of lining (see 4.1.2), so positioned for access to the inside breast pockets of the windbreaker. The detachable warm lining shall be attached to the windbreaker by means of a slide fastener (see 4.1.5).

4.5.9 Edges

The front and back yoke shall be top-stitched 7 mm from the edge. The free edges of the collar, front edges and cuff tabs shall be top-stitched 7 mm from their respective edges.

4.5.10 Hems

The bottom and sleeve hem shall be of finished width 40 mm, turned in and tacked at the seams. The bottom hem shall be interlined with interlining (see 4.1.3).

4.5.11 Hanger

A hanger of folded lining (see 4.1.2) of finished length 75 mm and width 10 mm, shall be securely attached below the collar stand at the centre back neck on the inside of each windbreaker.

4.6 Stitches, seams and stitchings

4.6.1 General

All sewing shall be in accordance with SABS 0101.

4.6.2 Stitches

Stitches shall be as follows:

side seams, shoulder, sleeve and sleeve insertion seams: any of stitch type 515 to 519; and
all other stitching: stitch type 301.

4.6.3 Seams

Seams shall be at least 10 mm wide and shall be as follows:

side seams, shoulder, sleeve and sleeve insertion: seam type SSa;

yoke seams: seam type SSa-2

front edges, collar and cuff tab: seam type SSae-2; and

attachment of pocket welts: LSq-2.

4.6.4 Stitchings

Stitchings shall be as follows:

hems: stitching type EFb-1; and

yoke edges: stitching type EFa-2

4.6.5 Number of Stitches

seams and top-stitching: 40 ± 4 per 10 cm;

buttonholes: 12 ± 1 per cm; and

buttons: 12 ± 1 per button.

5. Packing, care-labelling and marking

5.1 Packing

The windbreakers shall be delivered in a clean, dry and pressed condition and shall be so packed that they will not be damaged in transit or storage. Each windbreaker shall be neatly folded and packed in a plastic envelope of suitable size and shape and then, unless otherwise specified in the order or contract, packed for transit (in units of ten) in acceptable bulk containers. Only windbreakers of the same item number and size shall be packed together in a bulk container (unless quantities ordered are such that packing of the same item number and size only is not justified). Windbreakers of different item numbers and sizes may also be packed together to accommodate the last part of an order or contract.

5.2 Care-labelling

Each windbreaker shall have a woven or printed label that is permanently secured and that provides (in accordance with SABS 011) correct and appropriate care instructions. Printed labels shall comply with the requirements of SABS 1309. All care-labels and their markings shall be such that they outlast the garments.

5.3 Marking

5.3.1 Windbreakers

Each windbreaker shall have a woven fabric label that complies with the requirements of SABS 1309 securely sewn to the inside of the back neck. The label shall provide the following information printed in legible and indelible block letters of height at least 3 mm:

- The manufacturer's name or trade mark or both;
- the size designation;
- the date of manufacture;
- the item number; and
- the composition of the fabric.

5.3.2 Plastics envelopes

Each envelope shall be clearly marked with the size designation (as given in column 1 of table 1) and the item number of the contents.

5.3.3 Bulk containers

Each bulk container shall have a label securely attached to the outside. This label shall be visible when the containers are stacked and shall provide the following information:

- The manufacturer's name or trade mark or both;
- the designation, i.e. "Windbreakers, men's";
- the size designation;
- the quantity;
- the package number;
- the year of manufacture; and
- the item number.

Additional marking

When so required by Transnet Limited, windbreakers, envelopes or containers, or any combination of these three, shall bear information additional to that specified in 5.3.



Figure 1 - Front

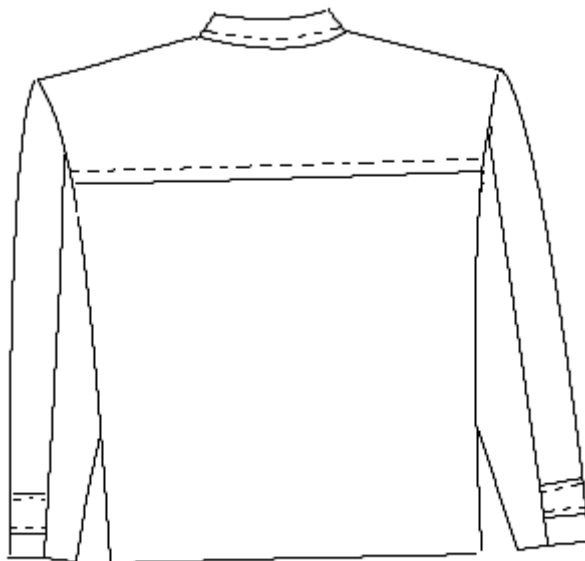
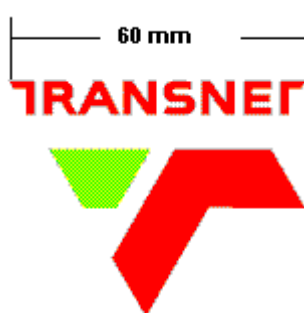


Figure 2 - Back

Annex A
(normative)

Special conditions of tender

A-1 Unless otherwise stated, Transnet Limited (or an officer or organization deputed by it), shall be the inspecting authority.

A-2 Two pre-production samples shall have been inspected, tested and approved by the inspecting authority before bulk production is commenced, and it shall be the duty of the manufacturer to give adequate notice to the inspecting authority of the availability of these samples.

A-3 The windbreakers 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 windbreakers supplied to this specification may be in progress.

A-4 The contractor shall inspect the finished windbreakers for compliance with the specification before submitting them to the inspecting authority for final inspection.

A-5 Before acceptance, the windbreakers shall have been inspected and tested by the inspecting authority and found to comply with the requirements of the specification.

I / We the tenderer hereby declare that the garments offered are and will be fully compliant to the Transnet specification

Yes / No _____ Company Name: _____ Signature: _____

REVISION HISTORY SHEET**Document** Quality Assurance**Effective
date****Subject** ADMINISTRATION, PREPARATION, MAINTENANCE AND
DISTRIBUTION18 JULY
1997**Controlling Officer:** R. Steynberg**Approving Officer:** C.J.V. du Plooy

Re v/No	Date approved	Nature of revision
1	January 1999	1. Add item No. 35/135112 Coallink 4.1 Change Item Nos. and add Item No. 35/135112 4.5.2 Add Coallink and Item No. 35/135112 Figure 3 Add Coallink logo
2	March 2004	1. Add item No. 35/155356 Transwerk 1 & 4.5.2 Remove No. 35/91867 Portnet 35/109876 PX 35/92128 Petronet
3	July 2005	1) 4.1.5 change to two different slide fasteners 2) 4.1.8 delete "Buttons" 3) 4.5.8 Changed method of attaching warm liner from buttons to slide fastener 4) 4.4 Add revised / increased size chart Remove No. 35/135112 Coallink
4	November 2005	1) Insert Petronet reference item 35/92128
5	December 2008	Remove reference no. 35/100903, 35155356 & 35/92128 Add Transnet logo
6	October 2010	4.1 Change cut make and trim to supply