

SHAKO CONSTRUCTION SPECIFICATIONS

1. GENERAL

The materials, component items and the finished hat shall meet or exceed the minimum requirements as specified. The range of sizes is to follow national standard men's hat sizes as follows: XXS (6-3/8) thru XXL (8).

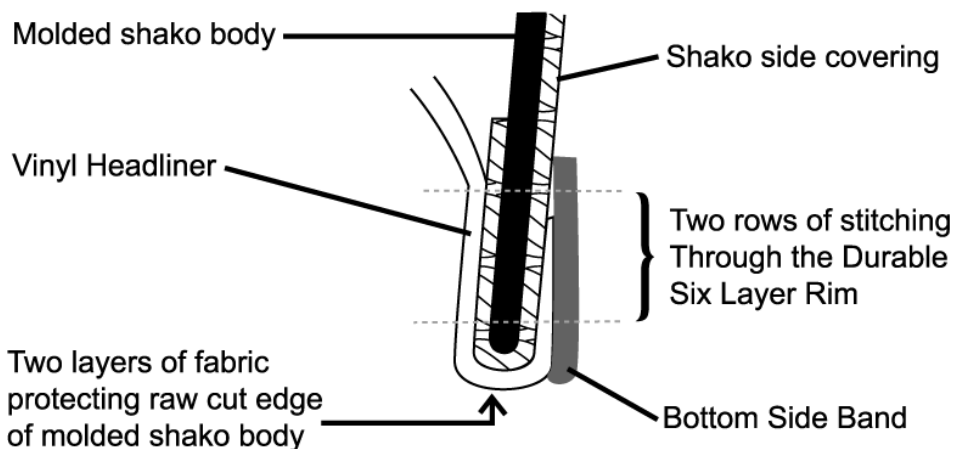
2. BODY

- A. Shako body shall be made of ABS (Acrylonitrile Butadine Styrene) material, gray in color. This material will be G. S. Grade for Hi-Impact properties and maximum resistance to ultraviolet light.
- B. There is a separate shell size for each head size.
- C. Each hat will have a woven label indicating size and offering cleaning instructions attached to the sweatband. An identification number sticker is also applied to the inside top of the hat body.

3. COVERING

- A. The fabric side covering is pulled down to the bottom edge of the shako body, then is turned back 1 ½" up inside the shell. Two rows of stitching secure the side covering to the molded shell. Thread weight to sew covers shall be super-strong nylon thread, at least .007 in diameter. This sewing operation extends all around the entire bottom edge of the molded shako body.
- B. The two rows of stitching described in section A. above, secure a total of six layers for maximum durability. These layers, from the outside to inside, are: BOTTOM SIDE BAND, VINYL HEADLINER, SIDE COVERING, MOLDED SHAKO BODY, SIDE COVERING TURN BACK and VINYL HEADLINER TURN BACK.

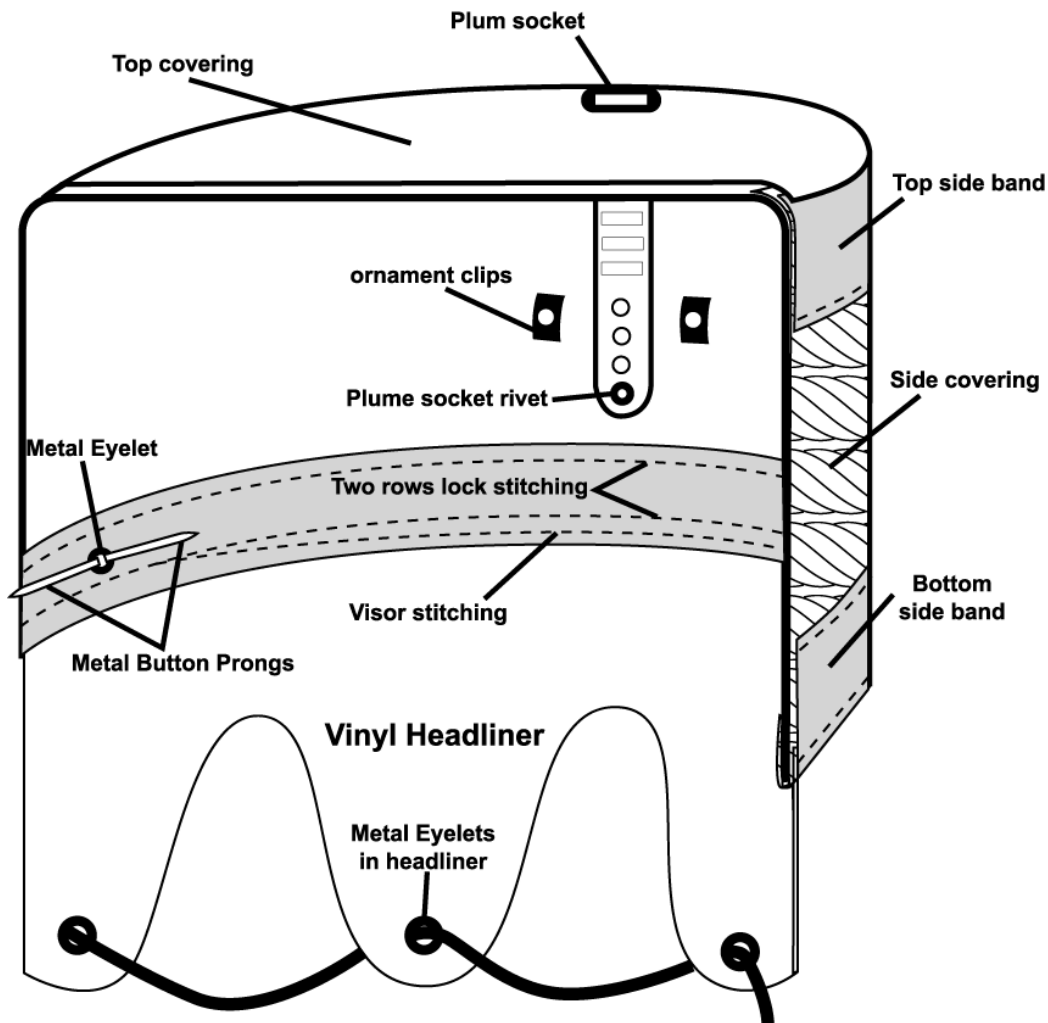
Shako Cross Section



4. HEADLINER AND SPECIAL FEATURES

- A. Headliner shall be cloth backed, expanded vinyl with embossed finish. There are six scallops with metal eyelets to receive drawstring for adjustability.
- B. Headliner is turned and sewn with No. 12 cord, lock stitched in such a manner as to allow for adjustability. Stitches shall not contact wearer's head. Headliner shall be perforated with flow-through ventilation holes.
- C. Headliner extends around the bottom edge of the plastic body, and stitched through. This results in two layers of material (outer fabric and vinyl headliner) to secure and protect the bottom edge of the shako shell body.
- D. Headband shall have reinforcing metal grommets at lace holes.

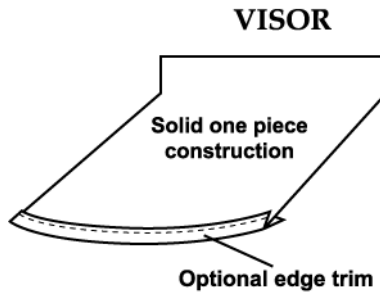
Shako Construction



- E. High density polyethylene plume sockets are included and are riveted to the body.
- F. A metal spacer is used to affix the front chain to each side button.

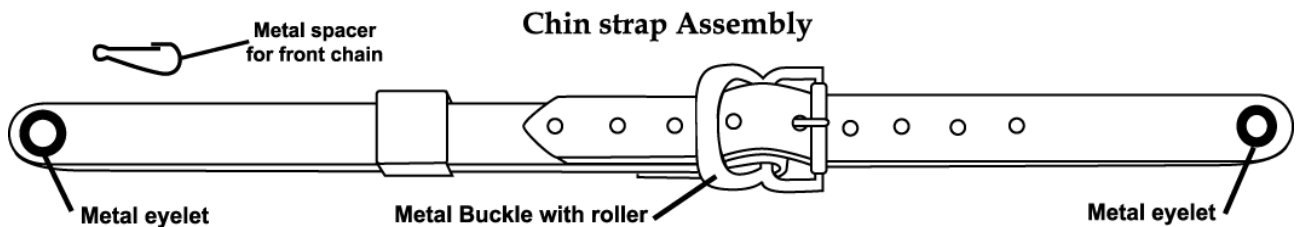
5. VISOR

- A. Visor is non-breakable one-piece plastic, not laminated. It is secured to the shako body with lock-stitch safety sewing.
- B. Visor color is molded through entire body of visor. The material is an engineering grade copolymer with a low-temperature tolerance. It is stain proof, fade and discoloration proof, and impervious to ultraviolet light (sunlight).



6. CHINSTRAP

- A. Chinstrap is 3/4" pliable plastic (Ethyl Vinyl Acetate) with metal buckle and roller, and has a 1/2" keeper.
- B. A reinforcing rib will extend completely around each end of the strap.
- C. There is a 3/4" nickel-plated brass chinstrap hook at the rear of the shako, attached with a metal clip.



7. **BUTTONS**

- A. Side buttons are three-piece metal.
- B. Buttons consist of prongs, base plate, and faceplate. Side buttons are metal with spread prongs. Plastic buttons are not acceptable.