

1) BID INVITATION AND GENERAL CONDITIONS

A. Sealed bid responses for furnishing the items and quantities listed in the attached specifications are hereby being requested from your company. You are asked to return the bid form page(s) with your response.

B. All bids or proposals are sealed and delivered to:

Buchanan Community Schools
ATTN: DEANNA RUSSELL/JORDAN LYNCH
401 W Chicago St.
Buchanan Mi, 49107

on or before **5/5/2023**, and will be opened and read in an open session at Buchanan Community Schools Business Office, at 3PM on 5/5/23. The envelope containing the bid should be marked on the outside "SEALED BID – BAND UNIFORMS". All bids received after the hour and/or date established above will be returned to the sender unopened.

2) DEVIATIONS FROM SPECIFICATIONS

A. Any deviation from these specifications must be documented on the enclosed deviation form. It is the intent of the school for the uniform to be manufactured strictly adhering to these construction and design specifications and deviations are not expected. If deviations are not documented fully, the bidder may be disqualified.

B. It is the intention of the buyer to offer equal opportunity to all bidders. The use of company names when referring to styles are for descriptive purposes only and are not intended to be restrictive. Materials and items referred to in these specifications are available to all firms.

3) BUYER'S RIGHTS

The buyer reserves the right to award the contract to the Bidder offering the best value, and not necessarily to the firm bidding the lowest price. The reputation of the manufacturer and representative, over-all appearance, style and fit of the uniform, quality of trims and accessories, plus special features a particular manufacturer may have that make the uniform more practical or serviceable will be major factors in awarding the contract. Right is reserved by the Buyer to accept or reject any or all proposals, and waive informalities.

4) SAMPLE REQUIREMENTS

A. All bidders must submit a sample uniform together with their proposals. The sample submitted must show basic construction, style and fabric. Any differences must be listed and explained on the Deviation Form enclosed for your convenience. Where special construction features are specified, these must be furnished with the bid showing the manufacturer's version of the feature. All major items being proposed must have a sample presented for comparison.

B. All bidders must submit liberal sized swatches of the materials to be used in the final product in the color and mill-weight as listed in the Uniform Specifications that are as follows - Coat Specifications (Pages C1-C12), Jumpsuit/Bibber Specifications (Pages J1-J5) and Shako Construction Specifications (Pages S1-S4).

5) AREA REPRESENTATIVE

Bidder must agree to provide a factory-trained representative to handle all details of the order. Said representative will be responsible for designing, measuring and servicing the order throughout the initial purchase and on a continuing basis. Bidders must list name, address and telephone number of the representative in their response.

6) CUSTOMER INSTRUCTION MANUAL

The successful bidder will supply a booklet containing a printout showing each uniform in sequence from smallest size to largest. The printout will indicate wearer identification number, original wearer and key measurements of uniform, i.e. height, weight, hat, chest, waist and outseam. The successful bidder will also supply recommended dry cleaning instructions for the uniforms and all accessory items; specifying precise details on care and cleaning that are to be utilized in future upkeep and maintenance of the items in this bid.

7) SHIPPING

Each uniform is to be thoroughly inspected before shipment. Imperfections shall be corrected before the uniforms are shipped. Uniforms are to be shipped complete with hangers (plastic) in containers. Each wardrobe container shall be marked on the exterior to indicate the wearer number of each uniform enclosed. The uniforms will be ready to wear without cleaning or pressing. In the case of damaged shipment, it shall be the responsibility of the receiver to make an appropriate written notice when signing the carrier documents. The receiver shall inventory the damage and advise the uniform manufacturer in detail. Accessories such as sashes, drops, etc., as well as trousers, will be bulk packed unless otherwise specified.

8) FABRIC SPECIFICATIONS

Dacron/Wool blend fabrics must be cold water and alcohol sponged, dedicated and inspected. The Certification of Proof of Sponging provided with this proposal should be completed and returned with your bid. Since this process is critical in the avoidance of excessive shrinkage, failure to submit this certification in writing will be cause for disqualification of the bidder.

Examine all specifications carefully. It is the intent of the buyer to audit each sample for strict compliance to the specifications. These specifications encompass methods and materials yielding only the highest quality garment, through specifying only the highest quality materials, components, accouterments and designate only time-proven tailoring of the highest standard. Make note that some methods and materials have been judged inferior and unacceptable and are so noted herein. These standards are so stated to ensure a garment having a functional lifetime

retention period of at least 8 to 10 years, with normal care and maintenance being exercised.

A. WOOLEN MATERIALS: Mill and Mill-Weight are listed in the Uniform Specifications with required shades. When specified, this refers to Premium Quality 100% all wool fine wale whipcord:

1. Having been specially treated with the exclusive double dyeing process using CHROME BOTTOM DYES, applied in the most effective manner known, ensuring color consistency in lot after lot.
2. London cold-water sponged and live steam shrunk, meeting United States Standard Shrinkage Specifications of not more than 1%.
3. Treated with water-repellent finish by the immersion method, thus imparting water repellency by yielding to not less than a 100-spray rating, and insuring additional resistance to wear by abrasion. Spraying treatment is not acceptable.
4. Treated with nationally known and recognized process ensuring COMPLETE GUARANTEE against moth or silverfish damage. This process must be applied by the immersion method and no spray-on treatments will be acceptable.

B. DACRON-WOOL MATERIALS: Mill, Mill-Weight and specific shades are found in the Uniform Specifications. This material, when specified, refers to material containing 55% Dacron Polyester and 45% Wool. As with all woolen materials, this will be first quality with no flaws or imperfections allowed. This material must be finished with S.E.T. or Zepel scientifically engineered Crease Retention and Stain Resistant treatments, thus protecting the material against both oil and water-based stains, as well as assuring the best possible crease retention. The material is to be permanently moth-proofed and guaranteed in the same manner as the all-wool material above. Water repellency to be ensured by proper treatment.

C. POLYESTER MATERIALS: Mill, Mill-Weight and specific shades are found in the Uniform Specifications and as with all-wool and dacron wool materials, will be first quality with no flaws or imperfections. The material is, by its nature, a water and stain repellent fabric, thus eliminating the need for a special treatment. Because there is no wool content, moth-proofing this fabric is not necessary.

IMPORTANT: ALL BIDDERS are to submit, along with their bids, a certificate stating that the fabrics used in the manufacture of the uniforms will be exact materials called for in the specifications and will be FIRST QUALITY. This certificate must be signed by an official of the Company. BIDDERS NOT FURNISHING THIS CERTIFICATE WILL BE DISQUALIFIED. NO FABRIC DEVIATIONS ACCEPTABLE.

DEVIATION FORM

NOTE: The Buyer will not accept the general statement:

“ALL UNIFORMS WILL BE CONSTRUCTED USING OUR STANDARD MANUFACTURING PROCEDURES WHICH ARE EQUAL TO, IF NOT BETTER THAN THOSE CALLED FOR IN THE SPECIFICATIONS.”

Any, and all, deviations in construction **MUST** be documented below. Any bid submitted without the detailed deviation documentation will be rejected.

Does your uniform deviate from attached specifications?

_____ YES

_____ NO

If yes, indicate below any and all deviations from the specifications:

AUTHORIZED SIGNATURE

NON-COLLUSIVE BIDDING CERTIFICATION

By submission of this bid or proposal, the bidder certifies that:

- A. This bid or proposal has been independently arrived at without collusion with any other bidder or with any competitor;
- B. This bid or proposal has not be knowingly disclosed and will not be knowingly disclosed, prior to the opening of the bids, or proposals for this project, to any other bidder, competitor or potential competitor;
- C. No attempt has been or will be made to induce any other person, partnership or corporation to submit or not to submit a bid or proposal;
- D. The person signing this bid or proposal certifies that he has full informed himself regarding the accuracy of the statements contained in this certification, and under the penalties being applicable to the bidder as well as to the person signing in its behalf.

COMPANY SUBMITTING BID

AUTHORIZED SIGNATURE

TITLE

BID FORM

TO: Buchanan Community Schools

ATTN: Deanna Russell/Jordan Lynch

We have reviewed the attached specifications and unless deviations are listed, will supply uniforms and accessories, as specified.

Quantity	Item	Unit Price	Extended Price
100	Shakos		
100	Coats		
100	Jumpsuits		
6	Drum Major Shakos		
6	Drum Major Plumes		
6	Drum Major Coats		
6	Drum Major Jumpsuits		
106	Garment Bags		
106	Shako Boxes		

TOTAL

_____ % Prepayment Discount

F.O.B. Destination

Freight Included

Net After Discount

(To receive prepayment discount, *payment MUST be submitted with order*)

TERMS:

If awarded the contract, we agree to ship a sample uniform within 30 days and to ship the entire order within approximately 150 calendar days after approval of sample and receipt of necessary details and measurements.

Company:

Address:

DATE:

Telephone:

Signed By/Title

Certification of Proof Of Sponging

This is to confirm that _____ will be having any and all Dacron/Wool Blend fabric sponged, pre-shrunk, and decated.

The above treatment is necessary to stabilize such goods, prevent excess shrinkage, and to improve the luster, hand, and finish of the fabric. Upon completing such a process, shrinkage will be well within industry tolerance.

If you have any questions regarding anything within the bid packet, please feel free to reach out to:

Deanna Russell

dcussell@buchananschools.com

OR

Jordan Lynch

jlynch@buchananschools.com

STYLING SPECIFICATIONS

Buchanan High School Band – Buchanan, MI

BANDSMAN COAT

FABRIC: 11-11.5oz 100% Synthetic, Xtreme-Dri Fabric

STYLE: Fully constructed, waist length canopy coat with center back zip, back cut straight and centerpoint notch in front.

BACK CLOSURE: Back butted black nylon zipper that zips down.

SPECIAL DETAILS: Black full coat lining. Coat will have special $\frac{3}{4}$ " thick firm foam shoulder pads that come with nylon tricot covering. Sleeves will have freedom of movement and are adjustable with snap tape on two sides of the inner sleeve.

FRONT TRIM: Front of coat on the right will be Xtreme Dri Fine Wine Maroon fabric. There is an insert seam that starts at the right shoulder/neck and slightly rounds all the way down to a point past the left coat bottom.

Left of insert seam will be Xtreme Dri Divine White fabric with sublimation Right side to show white and streaking left into Raven Black. There should be NO GREY midsection when transferring to black. There will be 5 solid black lines that are slightly slanted across coat front. Centered on each stripe will be a silver sparkle stripe.

There is a 1" black stripe centered on the insert seam and outlining the left coat panel. On this black stripe at the end of each of the 5 sublimated black stripes will be one 30L Nickel Dome button that is sewn on.

BACK & TAIL TRIM: Back of coat of Xtreme Dri Raven Black. No Trim.

COLLAR: Collar of Xtreme Dri Raven Black. Square comfort collar that opens in the back. No mylar, no collar liner and no hook and eye. Each layer of fabric fused with heavy fusing and reinforced with two layers of pellon and two rows of $\frac{1}{2}$ " stiff horsehair braid sewn inside collar.

SHOULDER STRAPS: Shoulder straps of Xtreme Dri Raven Black. Straps will be rectangular with no trim. Each strap buttons down with 1 30L Nickel Dome button.

UPPER SLEEVE TRIM: Right sleeve of Xtreme Dri Fine Wine Marron and the left sleeve of Xtreme Dri Raven Black. Fully lined 50/50 sleeves that have "Freedom of Movement" and are adjustable length using snap tape. On both sleeves set in arc of Plain Black "BUCHANAN". Right sleeve of black direct swiss. Left of Madiera #1385

BANDSMAN JUMPSUIT

FABRIC: 11-11.5oz 100% Synthetic, Xtreme-Dri Raven Black Fabric

THE JUMPSUIT WILL HAVE THE FOLLOWING FEATURES:

Front zipper	XX
Back zipper	
Adjustable side zippers	
Browne outlet	XX
FOB wallet pocket	XX
French fly	
Heavy Lycra side gussets	
Hip pocket	
Side pockets	
Built-in suspenders	XX
Hemmed	

SPECIAL DETAILS: Racerback jumpsuit with 18" Legs with 1 ¼" suspenders of jumpsuit fabric. NO waist darts in front. Waist darts in back. Additional piece of black elastic in back of suspenders. Nylon slides on suspenders. 4 way reinforced crotch. Taped fly at front zipper with two snaps at top of zipper. Snap tape in on the back side of seam allowance on the outseam and it is on the front side of the seam allowance on the inseam. Snaps will be placed 1" apart.

BANDSMAN HEADGEAR

STYLE: Flat top shako

PLUME HOLDER: Center front

VISOR: Black

TOP MATERIAL: Xtreme Dri Raven Black

SIDE MATERIAL: Xtreme Dri Raven Black

BANDS: Bottom only of Xtreme Dri Raven Black

ORNAMENT: (3) ¼" stripes of Silver Glamorous that start from the left side seam to the middle of the shako. Longest is the top stripe and tapering down. There is one 30L Nickel Dome tack back button at the end of each stripe. Stripes to be at the same angle as the coat front.

CHINSTRAP: Black with nickel buckle. Hook on back of shako to secure chinstrap upright when needed.

FRONT CHAIN: Silver front strap

SIDE BUTTONS: 45L nickel dome

DRUM MAJOR COAT

FABRIC: 11-11.5oz 100% Synthetic, Xtreme-Dri Fabric

STYLE: Fully constructed, waist length canopy coat with center back zip, back cut straight and centerpoint notch in front.

BACK CLOSURE: Back butted nylon zipper that zips down.

SPECIAL DETAILS: Full coat lining. Coat will have special ¾" thick firm foam shoulder pads that come with nylon tricot covering. Sleeves will have freedom of movement and are adjustable with snap tape on two sides of the inner sleeve.

FRONT TRIM: Front of coat on the right will be Xtreme Dri fabric. There is an insert seam that starts at the right shoulder/neck and slightly rounds all the way down to a point past the left coat bottom.

Left of insert seam will be Xtreme Dri fabric with sublimation to match band coat design. There will be 5 solid lines that are slightly slanted across coat front. Centered on each stripe will be a silver sparkle stripe.

There is a 1" stripe centered on the insert seam and outlining the left coat panel. On this stripe at the end of each of the 5 sublimated stripes will be one 30L Nickel Dome button that is sewn on.

BACK & TAIL TRIM: Back of coat of Xtreme Dri fabric. No Trim.

COLLAR: Collar of Xtreme Dri fabric. Square comfort collar that opens in the back. No mylar, no collar liner and no hook and eye. Each layer of fabric fused with heavy fusing and reinforced with two layers of pella and two rows of ½" stiff horsehair braid sewn inside collar.

SHOULDER STRAPS: Shoulder straps of Xtreme Dri fabric. Straps will be rectangular with no trim. Each strap buttons down with 1 30L Nickel Dome button.

SLEEVES: Right sleeve of Xtreme Dri fabric and the left sleeve of Xtreme Dri fabric. Fully lined 50/50 sleeves that have "Freedom of Movement" and are adjustable length using snap tape. On both sleeves set in arc of Plain Block "BUCHANAN" of direct swiss.

DRUM MAJOR JUMPSUIT

FABRIC: 11-11.5oz 100% Synthetic, Xtreme-Dri Fabric

THE JUMPSUIT WILL HAVE THE FOLLOWING FEATURES:

Front zipper	XX
Back zipper	
Adjustable side zippers	
Browne outlet	XX
FOB wallet pocket	XX
French fly	
Heavy Lycra side gussets	
Hip pocket	
Side pockets	
Built-in suspenders	XX
Hemmed	

SPECIAL DETAILS: Racerback jumpsuit with 18" Legs with 1 ¼" suspenders of jumpsuit fabric. NO waist darts in front. Waist darts in back. Additional piece of elastic in back of suspenders. Nylon slides on suspenders. 4 way reinforced crotch. Taped fly at front zipper with two snaps at top of zipper. Snap tape in on the back side of seam allowance on the outseam and it is on the front side of the seam allowance on the inseam. Snaps will be placed 1" apart.

DRUM MAJOR HEADGEAR

STYLE: Flat top shako

PLUME HOLDER: Center front

VISOR: Silver

TOP MATERIAL: Xtreme Dri Divine White

SIDE MATERIAL: Xtreme Dri Divine White

BANDS: Bottom only of Xtreme Dri Divine White

ORNAMENT: (3) ¼” stripes of Silver Glamorous that start from the left side seam to the middle of the shako. Longest is the top stripe and tapering down. There is one 30L Nickel Dome tack back button at the end of each stripe. Stripes to be at the same angle as the coat front. Top and bottom of each stripe to be outlined in black.

CHINSTRAP: White with nickel buckle. Hook on back of shako to secure chinstrap upright when needed.

FRONT CHAIN: Silver front strap

SIDE BUTTONS: 45L nickel dome

ADDITIONAL ITEMS

GARMENT BAG: 600 Denier “PROTECTOR” bag with one color school imprint

SHAKO BOX: Must be Shako-Mate

DRUM MAJOR PLUME: 8” Maroon French Upright with silver mylar and nickel cup

COAT SPECIFICATIONS

Hard and Soft Collar

1. GENERAL

Due to the unique requirements of a band coat (relative to the number of different wearers, minimum care received, wearing conditions and life expectancy), special patterns, materials, design and construction methods must be applied.

2. PATTERNS

- A. Coat patterns are special band uniform patterns with additional “ease” to allow for freedom of movement, wearing of clothing underneath and the convenient re-issue from year-to-year. Fashion or standard patterns do not allow enough room. Merely up-grading to oversized patterns will result in an unsightly and cumbersome fit.
- B. Computer generated patterns will provide proper fit for all male and female band members, with no restrictions or limitations as to chest size. Likewise, sizes will be assigned in needed “lengths” from XXS through XXL. Coats will be patterned for EACH even numbered chest size, rather than just generic S, M, L, etc.
- C. Patterns are to be marked and graded using a computerized system to insure accuracy and updated patterns.

3. SIZING

- A. Measurements will be taken by a factory-trained representative.
- B. Sizes are analyzed by a sizing computer system assigning the closest standard proportion size to each wearer in order to permit re-issuing in subsequent years and to provide a reasonable fit for the initial wearer.
- C. In the event the initial wearer cannot wear a standard proportion size, a special pattern will be employed to insure a reasonable fit.

4. COAT

- A. Coat linings are cut from a separate set of patterns designed to fit each specific coat size and style. Linings are not cut from coat shell patterns then cut down to try and fit.
- B. Linings are “FIRST” quality polyester twill, non-toxic, perspiration resistant and preshrunk to washable standards. Linings will have no less than 124 x 72, 150 Denier in both the warp and fill, meeting government specifications.

NOTE: “Patterned” linings of mens fashions fabrics are not durable in the heavy duty uniform usage.

- C. The coat lining has a ½” vertical pleat running up the center back. This allows fullness, fit and comfort to the overall performance of the coat.
- D. In the armhole area, the coat lining is machine stitched to an ensemble including the outer coat fabric, shoulder pad and sleevehead. Hand sewing or felling does not provide the durability required for armhole construction.
- E. Linings are sewn to the coat bottom edge, and reinforced with pre-shrunk tailoring tape. Straight cut long coats will have an additional ½” lining pleat all around the coat bottom.

5. BRAID (see #25-B)

Only first quality braid shall be used for trim. Braid trim ¼” or wider, is sewn down with two rows of stitching on looped trims as well as straight line. In addition, looped trim is reinforced with a layer of non-woven fabric, permanently bonded to the inside coat fabric surface to inhibit puckering tendencies.

6. BUTTONS

High-quality metal buttons shall be used where specified and they shall be attached by sewing, ring and washer or toggle and washer.

7. BUTTONHOLES

All coat buttonholes are made with a CUT-FIRST automatic buttonhole machine. The hole is cut first, the edges covered with gimp, then completely sewn to “close” the buttonhole. The buttonhole back is secured and closed with bartack reinforcement. Gimp is 100% cotton glazed #8 and approximately 8 oz., color matched to the buttonhole thread.



8. ZIPPERS

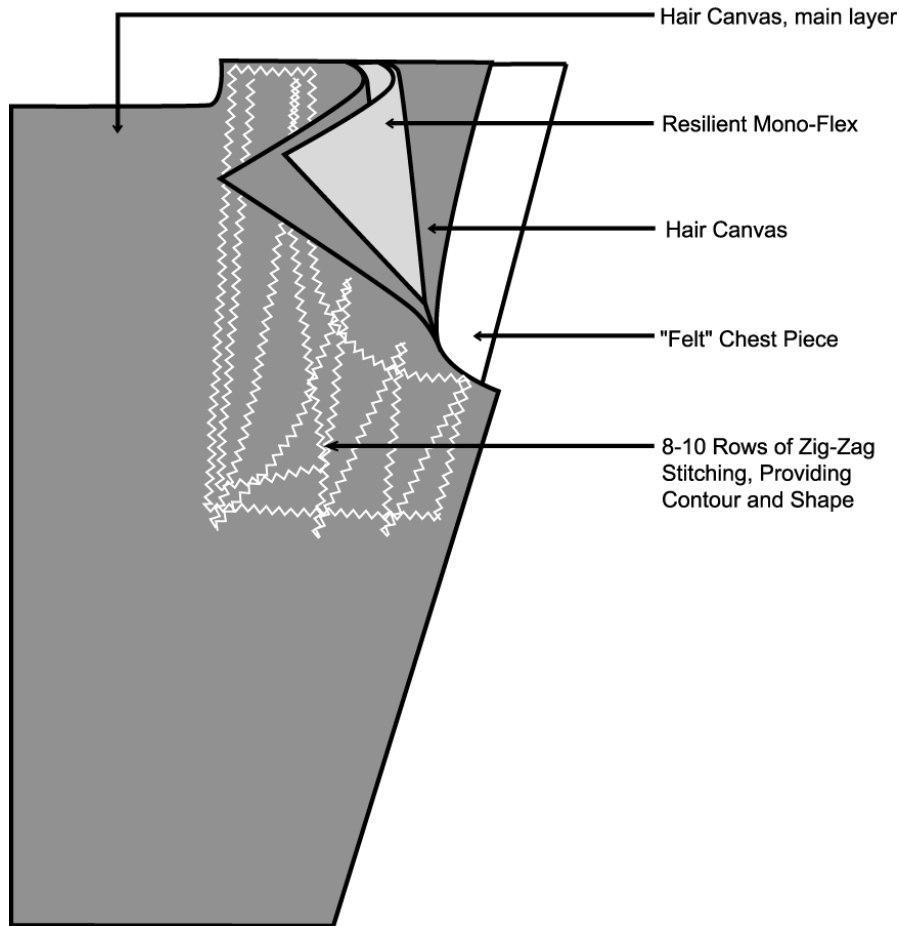
- A. Zipper to be heavy duty YKK, 9/16” tape, autolocking pull-slide of brass, or equal.
- B. Coat zipper tape shall be bar-tacked top and bottom and sewn to the surface of the facing, not sandwiched in between shell fabric and facing.

9. INTERLINING

- A. The interlining has optimum four-layer construction. More than four layers creates “STIFFNESS” in the coat fronts, resulting in difficult and uncomfortable arm lift maneuvers in marching bands. Less than four layers results in flimsy construction and therefore a rumpled appearance and reduced durability. In keeping with individual patterns for coat shell fabrics and the linings, higher quality control and an elevated level of haircloth quality is obtained by these multi-layered interlinings being patterned, cut and assembled “IN HOUSE” at the uniform manufacturers facility. This

basic construction practice enhances the fit and comfort of the individual uniform (as opposed to “making do” in purchasing these multilayered ensembles and cutting them down to fit the “hundreds” of patterns required for each coat style and chest size).

Coat Front Interlining



- B. The main layer of the interlining is a Hymo haircloth. This “hair canvas” is 35% genuine natural hair, 47% rayon and 18% polyester fibers. It is sanforized and double pre-shrunk with A.V.S. water repellent application. This canvas is 100% soakable with no shrinkage nor loss of rigidity. The layer extends the complete length of the coat front, from shoulder seam down to the coat bottom.
- C. The second layer is a resilient 27.6% rayon/72.4% polyester canvas “MONO-FLEX” chest piece 4.2 oz in weight. Its dimensions are 6” wide x 6 ¾” long and extends downward from the upper chest area.
- D. The third layer is another piece of hair canvas (as per “B” above) 8” wide and 12” long, extending downward from the upper chest area, and completely covering the MONO-FLEX.

- E. The fourth layer is a ¼” thick padding of 3.6 ounce 100% polyester non-woven material that is soakable and non-shrinkable. This white chestpiece pad extends approximately 6” below the armhole.

NOTE: In white coats and other light color fabric shades, a piece of thin Poly-sil white curtain is added to prevent “shadowing” of the haircloth interliner through the outer coat fabric.

- F. This entire multilayered interliner shall be sewn together with a series of eight to ten rows (depending on chest size) of zig zag stitching spaced approximately 1” apart. This is the optimum number of rows as recommended by the garment industry standards. Too many rows will reduce the flexibility, comfort and fit. Too few rows will limit durability and lifetime.
- G. The interliner is then secured to the coat shell fabric and coat lining, in the neckhole, armhole, bottom front and along the coat closure edge. A tailoring tape is included in these seams for added durability. The interliner is NOT sewn into the shoulder seam nor the side of the coat. This allows flexibility and “give” to the entire coat front construction.

NOTE: All tailoring tape is 100% PIMA cotton and triple cold water shrunk.
Fused front interliners are not acceptable.

- H. On soft collar concert/blazer coats the lapel portion of the canvas shall be padded to the lapel section of the coat with a series of multi-rows of blind stitching at close intervals no more than ¼” apart. This section shall be hand shaped and a ¾” cotton bridle tape shall be applied by two rows of blind stitch to insure body contour, permanent lapel shape and reinforcement to prevent stretching.

NOTE: The above construction is a time proven, traditional procedure. Under no circumstances are the haircloth and sewing operations to be substituted with a fusing or gluing operation. Certain areas of the coat should have a small reinforcement piece of pella fused to the outer fabric. These will be designated and detailed later; they serve as essential parts in the overall durability and appearance of the garment. However, as previously stated, the large chest pieces and foundation interlining must NOT be fused.

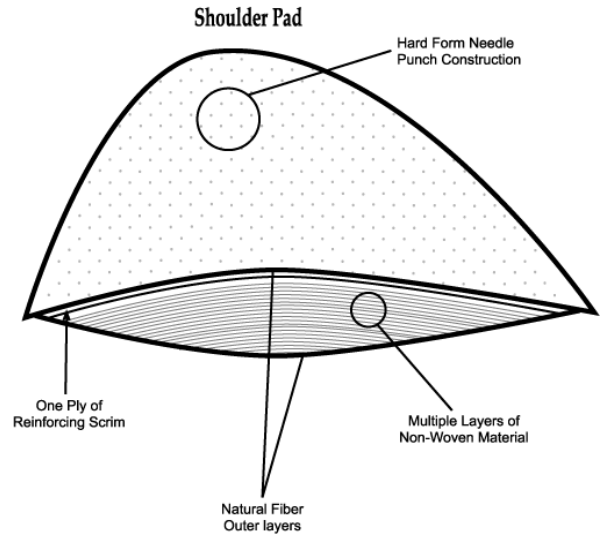
10. ARMHOLES

- A. Armholes shall be oval shaped and allow sleeve to be pitched forward 3-4 degrees to maximize comfort and ease of movement with minimum distortion to the coat.
- B. The armhole shall be reinforced with ¼” pre-shrunk cotton tape all around to prevent stretching in the armhole.
- C. The entire armhole shall employ machine lock stitching. Hand or machine “felling” will not be accepted.

11. SHOULDER PADS

- A. Shoulder pads shall be high quality, dry-cleanable and non-absorbent.
- B. Shoulder pad size shall be minimum 9” long x 4 ½” wide on regular width coat styles. Special “extended width” shoulder coats will have a larger shoulder pad measuring 9” long x 6 ½” wide.

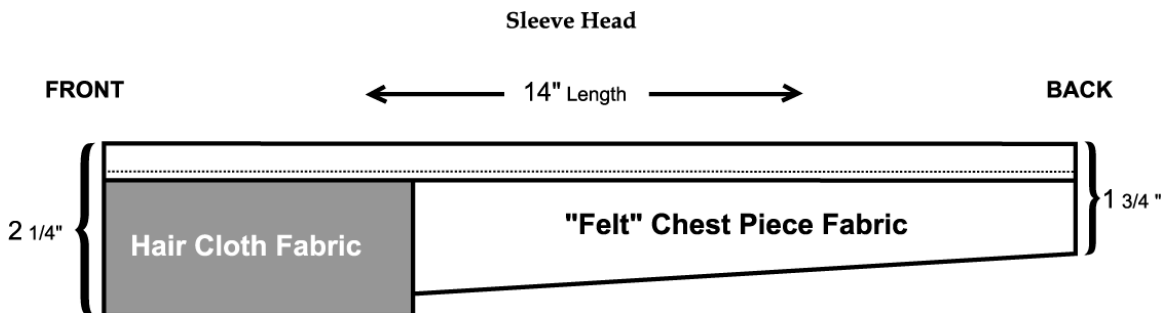
C. Shoulder pads are a “hardform” construction, consisting of several layers of non-woven material. The layers are permanently attached together with a “needlepunch” process. Among the layers, near the top side, is a reinforcing ply of scrim, which adds dimensional stability to the assembly. A final layer of natural fiber is applied as a covering. The shoulder pads are guaranteed for the lifetime of the garment. Dry cleaning is recommended, but the shoulder pad is also compatible with water.



D. Shoulder pads consisting merely of PIMA cotton covered with a porous fabric and held together with loose basting stitches, will not endure the many years of dry cleaning, exposure to the elements and the demands of marching band wear. The tendency is for a “wadding” of the cotton core. This type of shoulder pad is NOT acceptable.

12. SLEEVE HEADS

This provides fullness and shape to the top of the sleeve as it is sewn to the coat body. It consists of a separate strip of material used for the white chestpiece pad of the interliner (9E). The sleeve head has a length of 14” and is equally positioned over the shoulder, to the front and back of the upper sleeve seam. The finished width is 2 ¼” at lower front, and tapers to a 1 ¾” width at lower back. The construction consists of a ¾” turnback on the armhole edge, and has a seam spaced ½” from the edge. Sewn into the lower front portion of the white pad strip, is a 2 ½” x 4 ½” piece of “haircloth” as described in the Interliner section (9B). The result of this “IN HOUSE” manufactured sleeve head is a substantially improved “body” in the entire sleeve/shoulder area, particularly when lettering or other embroidery trim is specified.



13. SLEEVE STITCHING

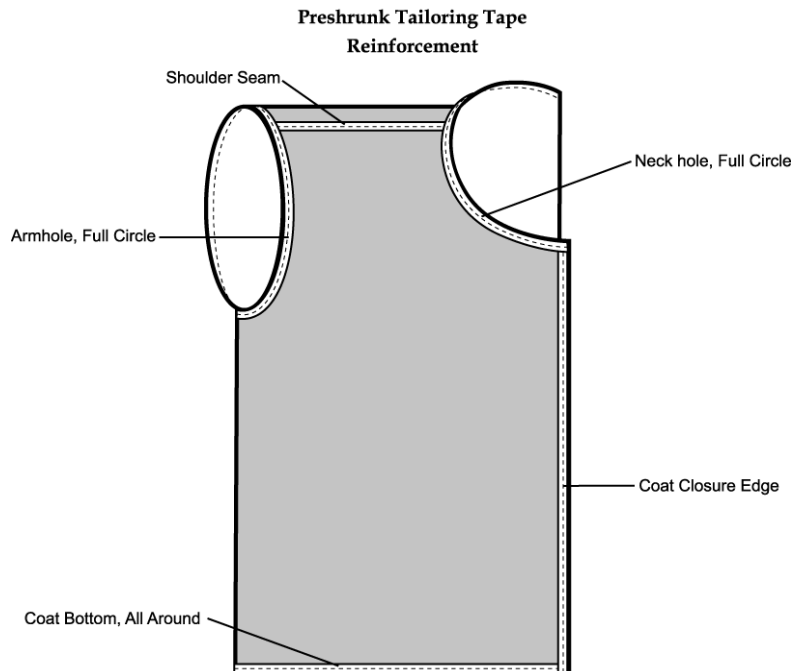
- A. Sleeves shall be set with machine lock stitch to insure proper distribution of fullness and durability.
- B. Fullness shall be sheered in by top-feed sewing machines.

14. ARMHOLE LINING FINISH

- A. The bottom of the sleeve armhole shall be lock-stitched through two layers of lining, two layers of fabric and armshield.
- B. The top shall be sewn through the coat lining, sleeve fabric, sleeve head, shoulder pad and shoulder strap with lock stitching.
- C. The entire armhole has tailoring tape all around.
- D. "Felling" by hand or machine is not acceptable when closing the armhole.

15. TAPING

- A. All seams in high stress areas are reinforced with tailoring tape to prevent stretching, and add durability to the seam. These tapes are pre-shrunk.
- B. Areas of this taping procedure include the following:
 - 1. All around the neck opening where collar joins the coat.
 - 2. Coat closure edges and completely around the bottom.
 - 3. Complete circumference of the armhole.
 - 4. Shoulder seams from collar (neck opening) to sleeve seam - except canopy coats.



16. POCKETS

- A. All inside pockets shall be constructed with a pocket welter and shall be reinforced with a non-woven fabric.
- B. Pocketing material shall be 80/20 poly cotton, 100% poly fill, pre-cured finish, 3.05 YPP, 78/54 twill weave.
- C. Upper and lower welt of the inside breast pocket is to be 100% polyester material and pellon backed.
- D. Pocket bag shall be constructed on one piece of pocketing with no open seams at the bottom.
- E. There shall be a tack at each end of pocket opening through all layers of pocketing. Tacks shall be concealed.
- F. Pockets made of lining or lightweight material shall not be acceptable.

17. SLEEVE CUFF TURN UP

- A. Sleeves cuffs will have an approximate 2 ½” turnup, which incorporates both the coat sleeve fabric and lining. This turnback includes a 3/8” binding at the top edge.
- B. Sleeve length alterations are accomplished by removing the blindstitch and re-sewing at the desired length.

18. SLEEVE CUFFS

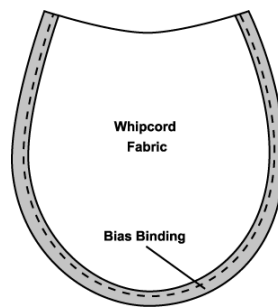
- A. Sleeve cuffs without trim in the cuff area are reinforced with a 5” width of non-woven material, bonded permanently to the inside of the coat fabric. As the sleeve is then turned back to form the let-out feature, this non-woven layer is equally divided to finish 2 ½” in the outside cuff edge, and 2 ½” on the inside. This procedure provides body to the sleeve cuff bottom edge, and maintains a full rounded finish.
- B. Sleeves with extensive cuff trim (appliques, inserts, looped braid designs, embroidery) are given the same reinforcement layer of non-woven material, but this layer is extended an additional 12” up toward the elbow area. This addition prevents puckering tendencies created by use of fabrics, braids, etc. which each have different coefficient of stretching.
- C. Shoulder lettering and embroidered logo trim have a reinforced backing layer on the inside of the sleeve.

19. ARMSHIELDS

- A. The armshield is engineered to minimize the long-term effects of perspiration over the lifetime of the garment. Perspiration consists of moisture, salts, weak organic acids

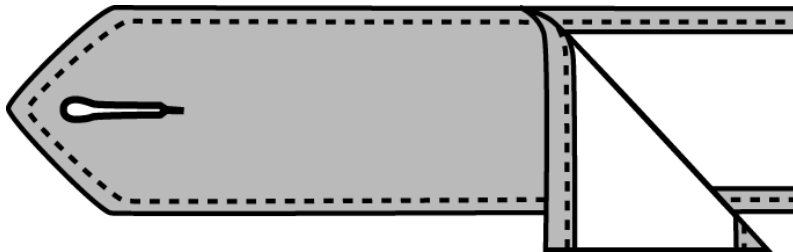
and body oils. A whipcord fabric having WICKING properties is specified for use as the armshield. (“Felt-like” fabrics that retain perspiration are not in the best interest of the garment). In addition to the wicking property, this whipcord shield has soil release, high permeability for airflow, and exhibits rapid evaporation.

- B. The armshield is approximately 4” x 4” in dimension, bound with double folded bias rayon on both sides and the bottom, then machine sewn into the armhole.
- C. Tensile strength and resistance to abrasion are additional advantages of whipcord armshields as compared to a “felt-like” material. The minimum abrasion quality is 10,000 on the STROLL FLAT test.



20. SHOULDER STRAPS

- A. Both the upper and lower layers of the shoulder strap are innerlined with permanently bonded, non-woven material. This four layer ensemble is secured with an inside hidden stitch then top-stitched all around the edge, set in approximately ¼”. These layers are die-cut to insure exact conformity in shape and size, throughout the lifetime of the garment.
- B. Buttonholes are the CUT-FIRST style, having all raw edges reinforced with gimp, then solid stitching as described earlier in the Buttonhole section (item 7).



21. STANDING HARD COLLAR

- A. Collars are one of the highest stress areas in the coat. The following construction process and features are the standard for the industry. Deviations and shortcuts will exhibit a lesser quality. The collar and matching removable collar liner are cut from

curved patterns. This allows a front “drop” to fit the downward front slope of natural human body configuration. These items are NOT to be cut in a straight pattern.

B. From the inner collar lining to the outer coat fabric, there is a total of six layers in this quality collar construction. From inboard to outboard, these layers are:

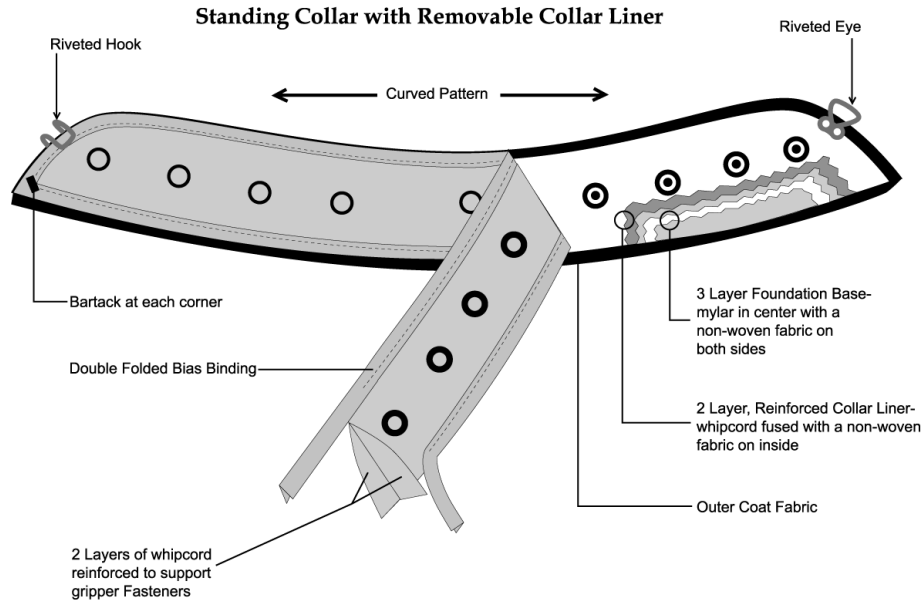
1. Collar lining of whipcord fabric-same as the Armshield section (item 19) for durability, wicking and tensile strength.
2. Non-woven material, permanently bonded to inside of collar lining, allowing a double layer for reinforcing the nine gripper fastener posts.
3. The next three layers consist of the heavy-duty mylar foundation base, which has a layer of non-woven, permanently bonded fabric to **EACH** side of the mylar. This triple layer foundation base is bound all across the top edge with a double folded, non-woven fabric tape, with stitching through and through.
4. The sixth layer is the outer coat fabric, which is that portion of the collar being readily visible.

C. The remaining three layers of the collar assembly consists of collar lining, bonded non-woven reinforcing layer and the outer coat shell fabric. These layers are sewn to the top edge of the triple layer foundation base. The outer coat fabric layer is cut to allow a double beaded fold over, along the top edge of the collar.

NOTE: All stitching and seams are “internal” and NOT visible.

D. A heavy duty, nickel hook and eye hardware set, is permanently riveted through the inner five layers of the collar assembly (omitting the outer coat fabric), the hook at the right front with the eye at the left. This hardware is set at an angle to establish “tension” which keeps the hardware in a closed position, secured by its own weight.

NOTE: The entire sewing operation in the construction of the collar is “machine-sewn”. Hand sewing simply cannot insure the required durability.



22. COLLAR LINER (REMOVABLE)

- A. This removable liner is constructed of two layers of whipcord fabric having a double folded bias binding tape all around the entire liner. A bartack is added at each end. This liner fabric is the same as used to make the armshields and collar lining. That is, it has properties of soil release, wicking, durability and breathability. The positioning of the gripper snap sets, provide for the liner to extend 1/8" above the top edge of the collar. This affords protection from perspiration, cosmetics, etc. getting into the collar fabric.
- B. There are nine, nickel plated gripper fastener rings set into the removable collar liner. These are positioned to match nine gripper fastener posts built into the inside collar lining. The collar and liner are patterned having the top edge of the collar with a smaller circumference arc than the bottom edge of the collar. This results in an engineered curve to the collar ensemble, to better fit the shape of the neck and chest "drop" of the human body.
- C. Each collar liner is cut from its own sized pattern, to fit the intended coat size. Since the collar liner is washable, a "laundry-proof" permanent number is imprinted on the inside back portion of the liner. The number matches the identification number of the coat.

23. "WRAP" COAT COLLAR

The standing collar on the wrap style coat is "soft", in that there is no inner layer of stiff mylar. This collar generally measures 1 3/4" finished width. The inside lining is a coat shell whipcord having a permanently bonded layer of non-woven fabric to reinforce the collar. The outer layer of the collar is also a coat shell whipcord, having a reinforcing layer of monoflex (resilient canvas of 27.6% rayon/72.4% polyester – 4.2 oz. weight) stitched in. This results in a

reinforced “soft” collar having four layers. All exposed edges are turned inward with an invisible row of stitching. A visible row of topstitching is added all around the edge. There are no exposed, rough edges.

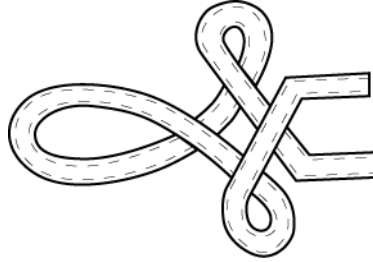


24. SOFT COLLAR

- A. Soft collar lapel coats shall have $\frac{3}{4}$ " non-bias bridle tape blind stitched to the canvas and through the back side of the outer shell of the garment so the lapel will roll and stay in a permanent position. The bridle tape will be worked in approximately $\frac{1}{2}$ " to give proper curvature over the chest area.
- B. Lapel coats are to have not less than seven (7) rows of blind stitching, catching the canvas and outer shell, applied under curved tension, giving fullness to the lapel for proper roll and permanent shape.
- C. Non-bias $\frac{1}{4}$ " cotton tape shall be applied on the leading edge extending from the base of the collar down the front and around to the edge of the canvas.
- D. One-half inch 2-way fusible tape shall be used to secure facing to coat front for added stability and appearance.
- E. The under collar is to be made of a double-thickness under-collar cloth.
- F. All edges shall be topstitched (with the exception of satin lapels) through and through, from the facing edge through coat front lapels and collar to the opposite edge. Topstitching shall be $\frac{1}{8}$ " from edges as with welt pockets and pocket flaps.

25. COAT TRIM

- A. All trim must be sewn to the outer coat fabric before the lining and interlining are joined to the coat. Trim sewn through the interlining and lining is not acceptable.
- B. Braid trim of $\frac{1}{4}$ " or wider is sewn down with two rows of stitching. This includes looped trims as well as straight line. In addition, looped trim is reinforced with a layer of non-woven fabric, permanently bonded to the inside coat fabric surface, to inhibit puckering tendencies.



26. SPECIAL COAT STYLES

- A. Certain coat styles will require a “Memory Recovery” system across the upper back and shoulders. This includes coat backs with bi-swing pleats in each upper back sleeve seam, and an inverted pleat style having a bi-folded expansion “pocket” in the center back seam, at the upper shoulder level. The seamless canopy style coat also requires this “Memory Recovery” system, due to the under construction across each shoulder.
- B. The Memory Recovery system is a 2 ½” wide panel of heavy duty light weight elastic, made of 90% (70 denier) nylon and 10% (140 denier) Spandex. It is sewn into each sleeve seam in the coat back area, and extends fully across the coat back. When the wearer of this coat style is in an arms down position, the system is relaxed. During an arm lift maneuver the entire coat back experiences stress and pulling across the shoulders. The Memory Recovery system brings the various fabrics, folds and coat parts, back to the original “EASE” position when arms return downward. This entire process prevents unsightly bulging. The durable elastic panel is included in the manufacturers warranty.

27. SEAMS

The center back seam and side body seams shall be 5/8”. Seams are to be plain with a minimum of 1 ½” total outlet in the side body seams and ¾” in the back seams. Coat is to be completely machine stitched except in areas where tailoring or appearance necessitates other methods. The ends of all seams and stitching shall be back-stitched not less than ¼”. Thread breaks of all stitch types must be secured by stitching back from break ½” to 1”. Coat is to be tailored with a four-piece back, comprised of a center back seam and two additional back body seams curving from sleeve seam downward and running out the coat bottom. Two-piece backs are also available as a buyers option, for a “sack” style coat.

28. THREAD

There shall be different types of thread used in various operations depending upon the need for strength, fullness, elasticity and smoothness. Padding of lapels and sewing of the bridle tape is to be done with three-cord cotton mercerized thread. Other sewing operations use perma cord size 50, two-cord thread. All threads used are to be heat resistant, vat dyed, sunfast, dry cleanable and moisture proof. In areas of multiple color trim panels, a monofilament thread may be indicated. This thread is a 330 denier and has a .008 diameter rating. The manufacturers warranty includes all threads used throughout the uniform construction.

JUMPSUIT/BIBBER SPECIFICATIONS

1. GENERAL

Jumpsuits/bibbers are special marching band construction and design, and shall not employ fashion tailoring techniques, materials or patterns that will not withstand the rigorous end use of band uniforms. Fashion pocketing, waistband material and construction, lightweight snaps and hooks are not acceptable.

2. PATTERNS

- A. The patterns and style must be in keeping with the end use of marching, with maximum capability to be adjusted for fitting a variety of wearers from year-to-year.
- B. They must have ample room for movement and be nonrestrictive for marching, in the seat, thigh and ankle area. The dimensions of a jumpsuit/bibber for a 38 regular male, shall not be less than 20 1/2" circumference at cuff and 26" at thigh.
- C. There are both male and female patterns.
- D. There are two (2) rear waist darts to reduce fullness from the seat to the waist. Seat shaping is accomplished by the pattern, not extended waist darts. Front darts are optional.

3. FRONT CLOSURE

- A. There are two stainless snaps at the top of the fly. Jumpsuits/bibbers with merely one (1) snap at closure are unacceptable.
- B. The fly zipper is brass "Y.K.K." with a double locking slide. There is a metal stop at the base of the fly zipper. The fly teeth will extend completely up under the waistband to prevent the slide from coming off the top of the zipper. Short zippers with teeth not extending under waistband are not acceptable.
- C. The outside fly consists of the outer shell fabric, an inner layer of shell fabric, and a middle reinforcing layer of non-woven fabric. The lateral edge of shell fabric on the inside of this fly assembly is completely bound with a polyester bias tape.
- D. The inside fly is constructed with a layer of outer shell fabric having two layers of "four way" fabric sewn to the inside. The "four way" material is 80/20 polycotton, 100% poly fill, 3.5 yards per pound, with a pre-cured finish. This inside fly extends down into the four-way crotch and finishes approximately 1 1/4" beyond the four-way. This fly lining is stitched down on both edges, to prevent "rolling".

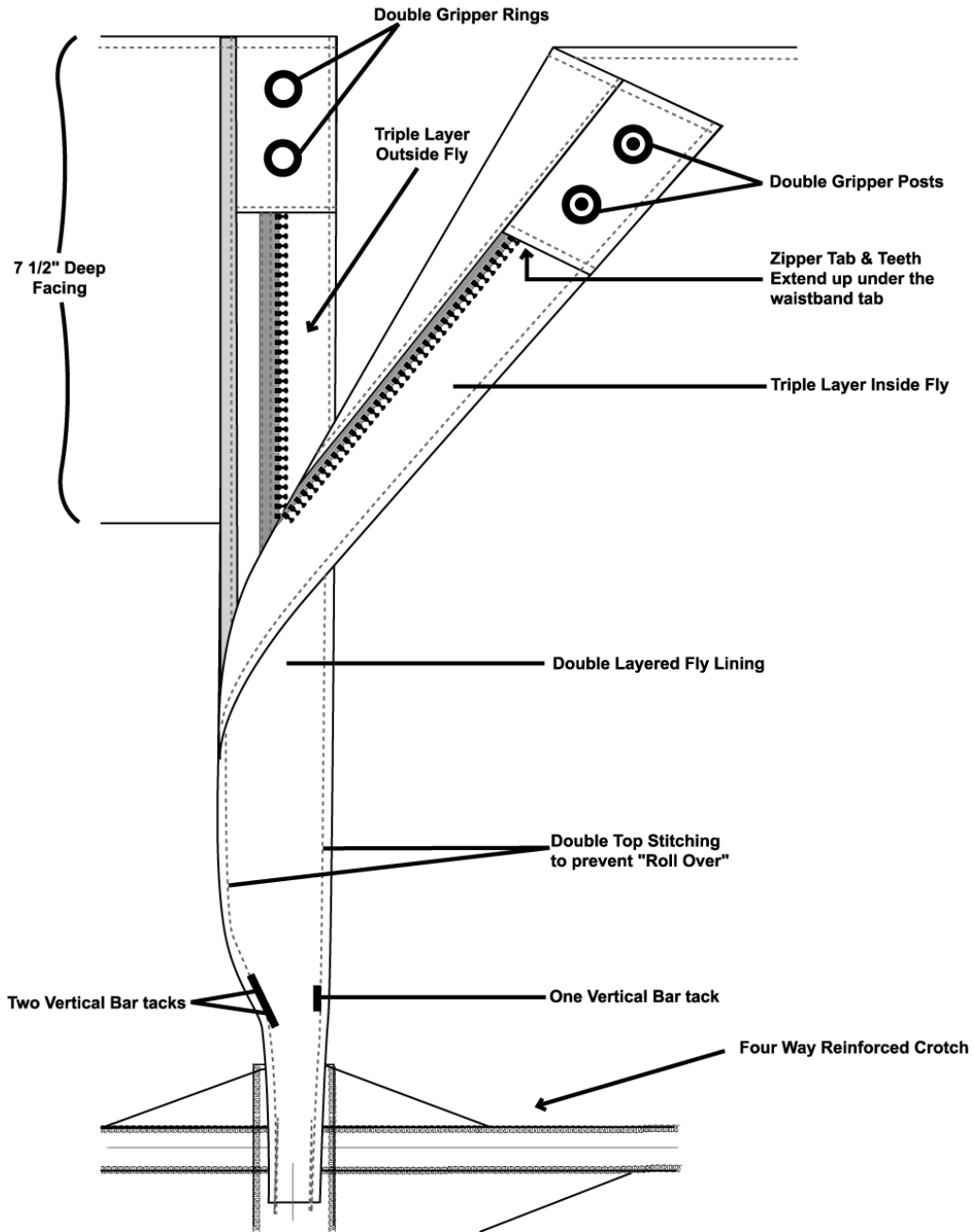
NOTE: Both the outside fly and the inside fly have three layer construction.

- E. There are two vertical bar tacks on the inside fly lining and one vertical bar tack on the outside of the base of the fly 3/4" up from the bottom of the fly. The purpose of the

outside bar tack is to eliminate stress on the zipper track and to prevent tearing when the trousers are being put on. This bar tack is vertical to insure maximum number of stitches on the seam, and positioned to be not noticeable.

- F. The outside, three layered front fly measures 1 $\frac{3}{4}$ " in width. The inside, three layered front fly measures 2" in width.

Jumpsuit/Bibber Inside View



4. CROTCH REINFORCEMENT

- A. There is a "four-way" crotch reinforcement consisting of 80/20 poly cotton, 100% poly fill, 3.5 yard per pound, pre-cured finish fabric.

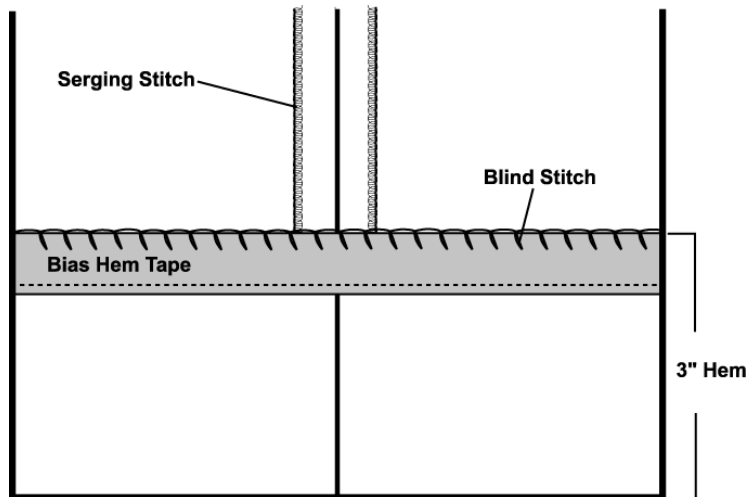
- B. There are four, two ply sections, one on each side of the intersection of the fly, seat seam and inseams.
- C. Crotch area is clean finished with no pieces extending from top of inseams.

5. POCKETS

- A. Pants pocketing is high grade; acceptable for use by government agencies, 80/20 poly/cotton, 100% textured poly fill, pre-cured finish, 3.5 yards per pound.
- B. Pockets are “bag” construction, consisting of one piece of pocketing turned and stitched. There are no seams at the bottom of the pocket and no exposed serging stitches.
- C. If standard exposed hip pockets are used, they shall be double welt construction and reinforced with interlining.

6. CUFF HEM – “EASY ALTER”

The bottom of the trouser leg has a 3” turnback on the inside, including a binding of flat polyester bias hem tape. This tape is a total width of 1 ½” before being applied to the trouser cut edge. It is folded over the cut edge and sewn down leaving a finished width of ¾”. This hem is now blindstitched back to the inside of the trouser leg.



7. SEAMS

- A. The center back, seat seam is sewn with two rows of locked chain stitching. There is a 3” Browne outlet along this center back seam.
- B. Inseams are sewn with a highly durable expansion stitch, allowing flexibility in this stress area. These seams are constructed with 5/8” seam allowances, and are of the “flat” style. Outseams are double folded over with the edges sewn together.

NOTE: Jumpsuits/bibbers with the expandable gusset option are constructed with the inseam having the “flat” style seam with 5/8” allowance.

8. TRIM

- A. All jumpsuit/bibber stripes shall continue the full length of the leg through the turn-up and are covered with tape at the raw edge of cuff.
- B. Stripes are set no more than 1/8” from side edge of adjustable “V” to minimize stripe distortion.
- C. All straight fabric stripes are double thickness to prevent shadowing and pressing marks.
- D. Trim shall be centered on and will cover the side seam for aesthetics and seam reinforcement.

9. PERMANENT SUSPENDERS

- A. Suspenders are made of whipcord fabric. Color shall match jumpsuits/bibbers. Nylon webbing shall not be used because the adjusting slide will not remain in set position under tension from movement.
- B. Suspenders are two-ply, topstitched, and have interlining for body. This will insure the adjustable slide remaining in set position; suspenders will dry clean as well as jumpsuit. Each suspender strap will have a 3” piece of heavy duty elastic inserted for additional comfort.
- C. All hardware is unbreakable nylon as used in parachutes and life vests; unbreakable, unbendable and not subject to tarnishing or rusting. It will not cause undue abrasion on jumpsuit during dry clean tumbling.
- D. Suspenders are self faced and interlined with pella.

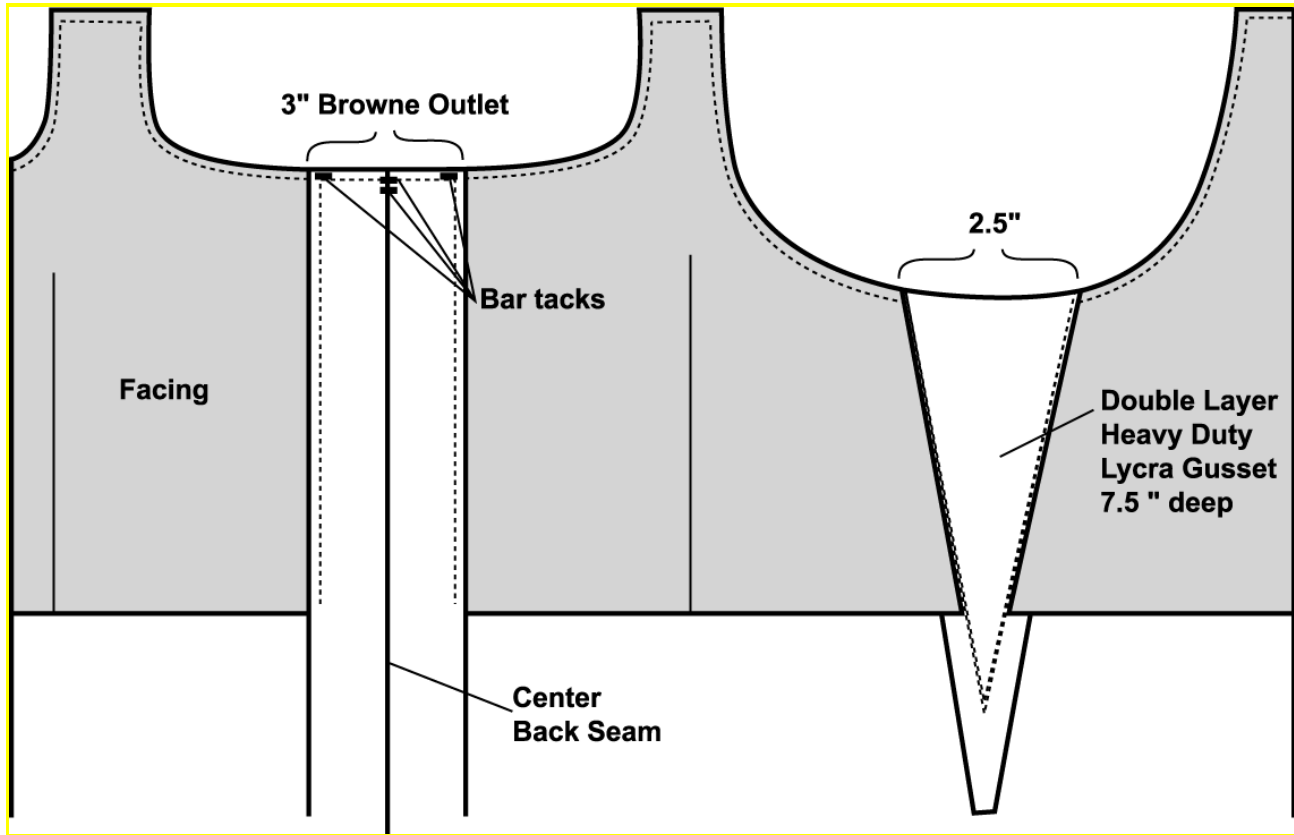
10. PERIMETER SERGING

- A. All exposed “raw” edges not covered with tape are serged with a “serging stitch of no less than 10 per inch, tight to edge, to prevent fraying.
- B. Serging thread is polyester.

11. UNDERARM GUSSETS

When an underarm gusset is specified for adjustability features, a heavy duty two-layer color matched lycra wedge is sewn into the upper portion of the pant outseam. This gusset is cut into an elongated diamond shaped pattern 19 ½” long and 3 ½” at its widest point. The two elongated points are matched together, allowing the double layer of lycra to be sewn into a proportionate V shaped notch. This results in a gusset, double layers, 2 ½” wide at the top of the jumpsuit in the “underarm” area, and extending downward to a finished length of 7 ½”.

This adjustable feature will allow up to 3" larger fit around the torso. The manufacturers warranty includes this lycra feature.



12. UPPER FACINGS

Inside upper facings are essential in providing body and dimensional stability to the curved cut all around the upper edge of the jumpsuit/bibber trouser, extending upwards to accommodate the shoulder strap. The following dimensions are standard:

Center Back Seam	7 ½" Deep
Underarm	5" Deep
Back Shoulder Strap Extension	11" Deep
Front Shoulder Strap Extension	9" Deep

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).

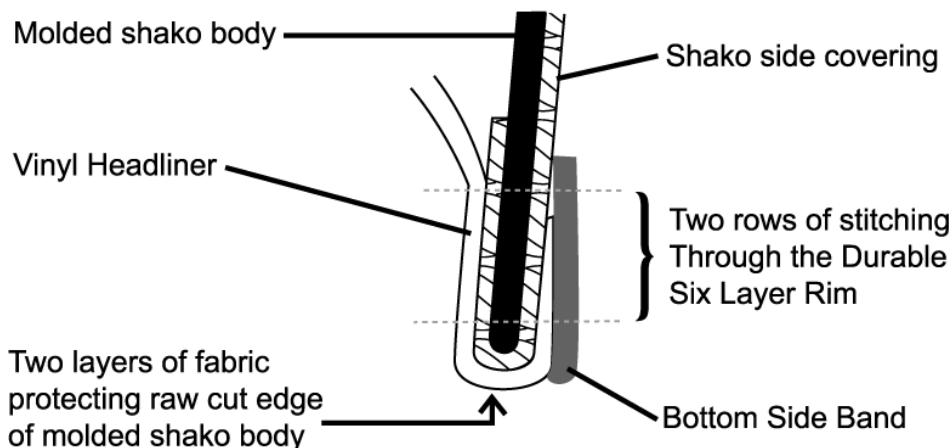
2. BODY

- 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

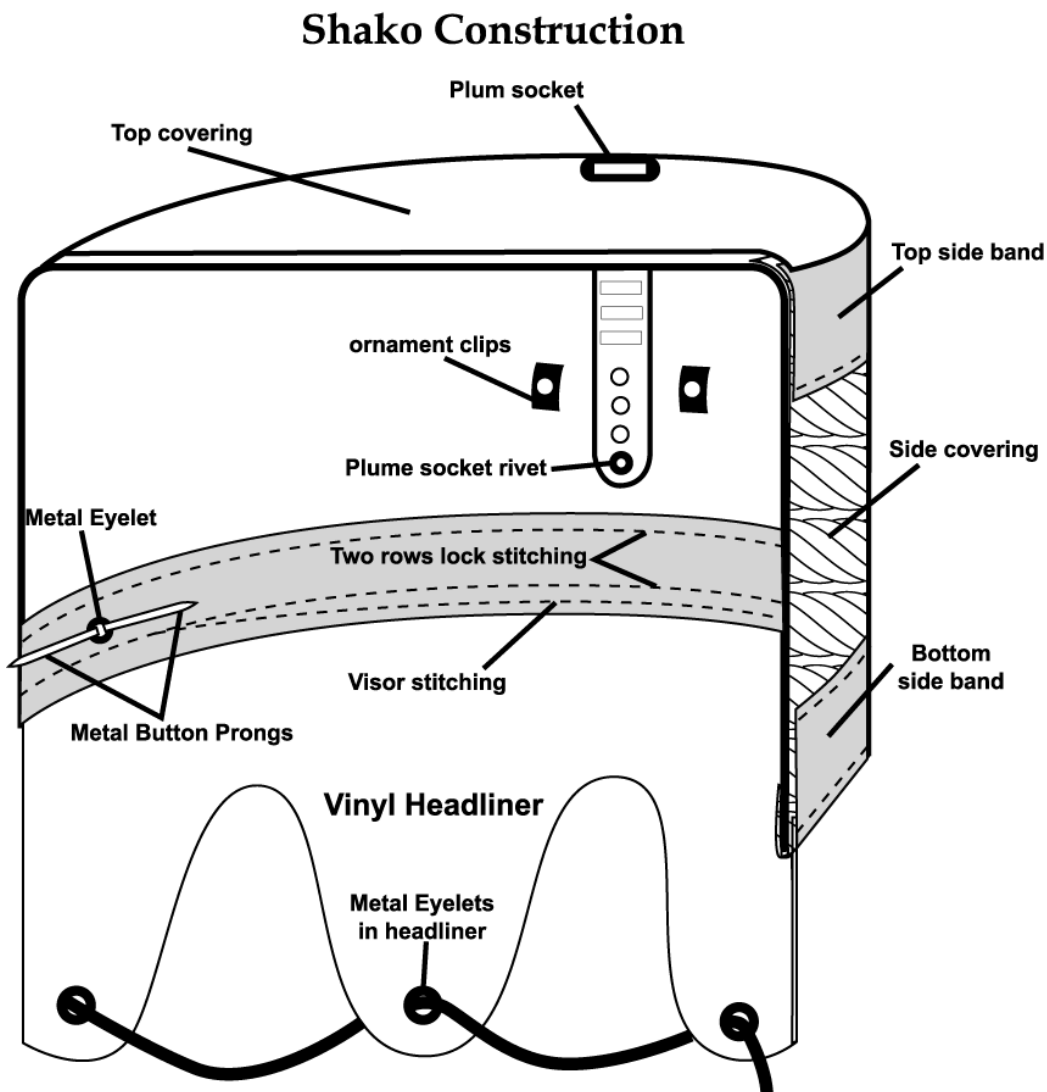
- A. The fabric side covering is pulled down to the bottom edge of the shako body, then is turned back 1 1/2" up inside the shell. Two rows of stitching secure the side covering to the molded shell. Thread weight to sew covers shall be super-strong nylon thread, at least .007 in diameter. This sewing 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

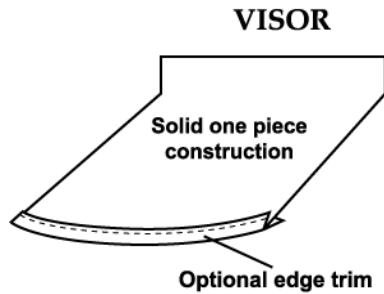
- A. Headliner shall be cloth backed, expanded vinyl with embossed finish. There are six scallops with metal eyelets to receive drawstring for adjustability.
- B. Headliner is turned and sewn with No. 12 cord, lock stitched in such a manner as to allow for adjustability. Stitches shall not contact wearer's 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.



- 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.

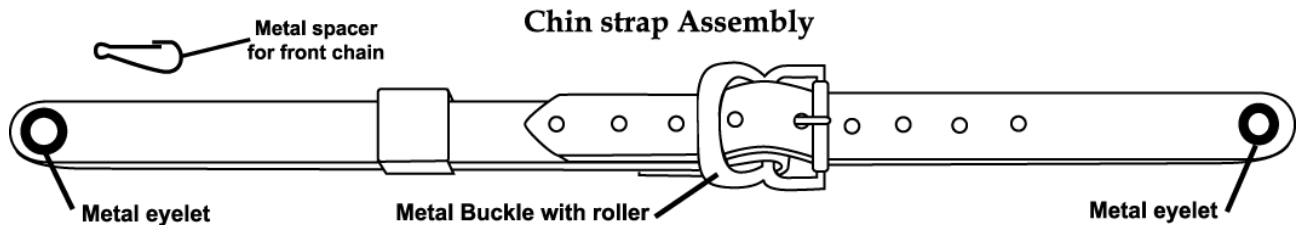
5. VISOR

- 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.

Shako & Helmet Carry Case Specifications

Headwear carry case is “Shako-Mate” or equivalent.

MATERIAL: Co-Poly Polypropylene. This material is heat resistant to prevent melting and cold resistant to prevent breakage due to the material becoming brittle.

DIMENSIONS: 12” x 12” x 8” to accommodate headgear and various accessory items.

HANDLE: The handle is rounded with the latch placed behind the handle. Boxes with the handle on top, preventing ease in removal from stacked position, are unacceptable.

Shako-Mate has a black pebble grain finish to compliment appearance and prevent scratching.

Shako-Mate is stackable to allow for storage. Stacking nodes are to be on underside of container with receiving units on top.

Inside of Shako-Mate will be reinforcement flanges to allow for stability and to aid in stacking.