SAVANNAH R3
SAVANNAHR3.COM
Dr. Eric Kurre
Superintendent
Brian Hansen
Asst. Superintendent
816-324-3144
408 West Market St.
Savannah, MO 64485

BID INVITATION: BAND UNIFORMS

SAVANNAH HIGH SCHOOL

SAVANNAH MISSOURI

****

GENERAL INFORMATION AND INVITATION

- ***DEVIATION FORM***
- ***FABRIC CERTIFICATION***
- ***STYLE & DESIGN SPECIFICATIONS***
- ***COAT CONSTRUCTION SPECIFICATIONS***
- ***TROUSER/JUMPSUIT CONSTRUCTION SPECIFICATIONS***
- ***SHAKO/SHAKO CASE CONSTRUCTION SPECIFICATIONS***

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:

Dr. Eric Kurre, Superintendent
Savannah R3 Schools
408 West Market
Savannah, MO. 64485

on or before **January 20, 2023 at 1:00pm** and will be opened on January 20, 2023 at 408 West Market, Savannah, Missouri at 1:00pm. 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.

C. The district is planning on awarding the contract at the scheduled board meeting on February 9, 2023.

D. Delivery on or before July 21, 2023

E. Payment processed on July 1, 2023, or after acceptance whichever is later.

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.

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 out seam. 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 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, decated 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 insure 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, insuring 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 not acceptable.

4. Treated with nationally known and recognized process insuring 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 insured by proper treatment.

C. POLYESTER MATERIALS: 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 BIDDDERS 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 :_____

SIGNATURE:_____

TITLE:_____

SAVANNAH HIGH SCHOOL

SAVANNAH, MISSOURI

We have reviewed the bid specifications and unless deviations are listed, we will supply all uniforms and accessories as required by the bid specifications. Any deviations not declared could be grounds for disqualification.

QUAN.	***ITEM***	***UNIT PRICE***	***EXTENDED PRICE***
120	***SHAKOS***	***$_____***	***$_____***
120	***SHAKO CASES***	***$_____***	***$_____***
120	***SHAKO WRAPS***	***$_____***	***$_____***
120	***PLUMES***	***$_____***	***$_____***
120	***COATS***	***$_____***	***$_____***
120	***SIDE/HIP DRAPES***	***$_____***	***$_____***
120 pr.	***BIB TROUSERS***	***$_____***	***$_____***
120	***GARMENT BAGS***	***$_____***	***$_____***
2	***PLUME CASES W/CARTS***	***$_____***	***$_____***
1	***LEAD BANNER***	***$_____***	***_____***
TOTAL	***FOB SCHOOL***	***$_____***	***$_____***

TERMS:_____PREPAYMENT DISCOUNT:_____

If awarded the contract, approval sample to ship within _____days and ship entire order within approximately _____calendar days after receipt of all details.

COMPANY_____SIGNTURE_____

ADDRESS_____TITLE_____

CITY/STATE_____DATE_____

SAVANNAH HIGH SCHOOL

SAVANNAH, MISSOURI

STYLE & DESIGN SPECIFICATIONS

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ALL ITEMS ARE TO INCLUDE BAR CODING

FABRIC: *No substitutions allowed. Xtreme Dri Raven Black, Vegas Gold and white. Glamour.... Coat Fusion construction. No Deviations on fabric or construction allowed*

SHAKO: *Flat top shako totally covered with black vinyl. 1 plume holder sockets on top center front. Black visor, chinstrap and front strap with black side buttons. Ornament in front seen on inverted triangle of gilt Mylar outline with gold Vegas stripe.*

SHAKO WRAP:

Wrap to slide down over existing shako. Wrap designed to come to a tall point in front off set to the right with diagonal slope to left side. Left half of shako Vegas Gold and right side black. Diagonally across front 5 diagonal rows of equal width butted up against each other. Top row with 3rd and 5th rows sublimated starting faded black/gray at top gradually changing to Vegas Gold. The second, 4th and 6th row sublimated white gradually turn into black.

SHAKO CASE: *12" X 12", made of Co-Poly Polypropylene with pebble grained finish. Rounded handles with latch placed behind handle. Case to include stacking nodes.*

PLUME #1 :*14" black French Upright with Gilt Mylar****.***

COAT: *Fusion****.*** *Waist length front, waist length back with shoulder caps off of both shoulders, standing military Comfort collar all in black no trim. Both sleeve cuffs feature easy alter snap adjustment.*

Left front section Vegas gold fading into black at the side with black left shoulder cap with Vegas gold underneath side. Left chest area school logo black abstract letter" S" ' with 3 Vegas gold banners through the middle. Left sleeve top half white with 2 , 1 ½"horizontal stripes of grey evenly spaced Lower half of sleeve black. Right side black with 8, 1" diagonal stripes across the front all butted together. The top, 3rd, 5th and 7th rows grayish black gradually changing o Vegas gold. All other rows grayish/ black changing to solid black.

Right shoulder cap white with underneath side black. Right sleeve sublimated top half Vegas gold to black at the bottom. No trim.

***GAUNTLET CUFFS**: 8" WITH 1" VELCRO closure on the side with accordion pleated closure.. Cuff black with top contrasting fin of Vega Gold*

SIDE/HIP DRAPE: Drape to be removable and snap underneath left bottom of coat. Two color drape with bottom black and top layer sublimated black at top changing to Vegas gold at bottom.

***BIB TROUSERS:** . Xtreme Dri Raven black. A 3" outlet in the rear seam, nylon fasteners with fabric suspenders, black surgical elastic at the back bottom of suspenders for flexibility in standing and sitting, 7 ½" top facing, 4 way crotch reinforcement, taped front fly with brass zipper and two gripper snap closure, waist darts in back, easy alter snap tape adjustable hems . Sewn down perma-crease. Wallet size pocket on inside left facing.*

***GARMENT BAGS**: "Protector" heavy duty.Black nylon with full width accessory pocket, Ident-A-Peek window and one color imprint.*

***DRUM MAJORS**: Same design as band with complimentary colors.*

***PLUME CASE** holds63 plumes per case in nylon case include cart,*

***LEAD BANNER** : TBD with awarded vendor./*

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COAT SPECIFICATIONS

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. These specifications speak directly to the requirements of construction, which allow for professional washing OR dry cleaning of the garment.

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 XXXL. Coats will be patterned for EACH even numbered chest size (ex. 38, 40, 42, etc.), 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 under the direction of 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.

4. FABRIC

A. The shell fabric is Xtreme Dri polyester/synthetic, providing enhanced air permeability that differentiates it from generic polyester fabrics.

B. Xtreme Dri lifts moisture away from the wearer, which keeps the body cooler in warm weather and warmer in cold weather. It is ***stain resistant***, ***tear resistant***, ***odor resistant***, ***quick drying***, ***colorfast***, and ***will not pill***. Xtreme Dri is different than the standard polyesters that have been available to the band uniform industry, including, but not limited to 1933 (a.k.a. 4892), 420, 960, 6248, 4030 and 460. Standard polyester fabrics are not acceptable substitutes for Xtreme Dri.

C. Since Xtreme Dri is a proprietary exclusive fabric, any vendor may bid on what they consider their best available polyester for the project. However, any and all deviations must be thoroughly documented.

5. LINING

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 Aerocool polyester/taffeta 97GR/Yd, woven to absorb and evaporate moisture rapidly by capillary effect. The absorption, diffusion and evaporation system of this lining is designed to maintain cool body temperature and excellent comfort for the wearer.

C. In coat styles that do not utilize a back zipper, the coat lining has a 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.

6. BRAID (see #25-B)

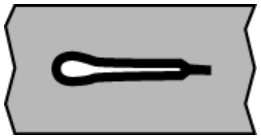
Only first quality washable braid shall be used for trim. Braid trim ¼" or wider, is sewn down with two rows of stitching on looped trims as well as straight line. In addition, looped trim is reinforced with a layer of non-woven fabric, permanently bonded to the inside coat fabric surface to inhibit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

7. BUTTONS

High-quality, rust resistant metal buttons shall be used where specified and they shall be attached by sewing, ring and washer or toggle and washer or tack-back. The buttons shall not alter the washable capabilities of the garment.

8. 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.



9. ZIPPERS

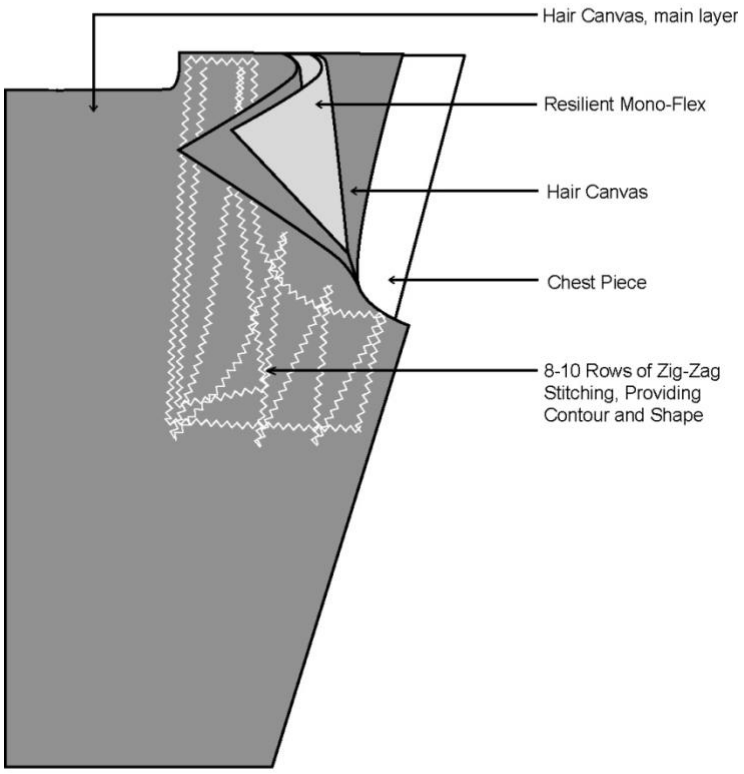
A. The style is YKK, heavy duty of color matching VISLON. The zipper is auto-locking and has a "separating" feature for maintenance and durability.

B. Zipper tapes are standard 9/16" width, sewn down with locked safety stitching and bar tacked at each end.

10. INTERLINING

A. The interlining has optimum four-layer construction. More than four layers create 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 manufacturer's facility. This basic construction practice enhances the fit and comfort of the individual uniform (as opposed to "making do" by 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



Coat Diagram 1

B. The main layer of the interlining is a Hymo haircloth. This "hair canvas" is a blend of polyester, viscose rayon and genuine natural hair, which gives it soft resilience. This canvas is 100% washable with no shrinkage or 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 interlining through the outer coat fabric.

F. This entire multilayered inter-liner 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 of 100% PIMA cotton, triple cold water shrunk, is included in these seams for added durability. The interlining 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: The above construction is a time proven procedure. Under no circumstances are the haircloth and sewing operations to be substituted with a fusing or gluing operation.

11. 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.

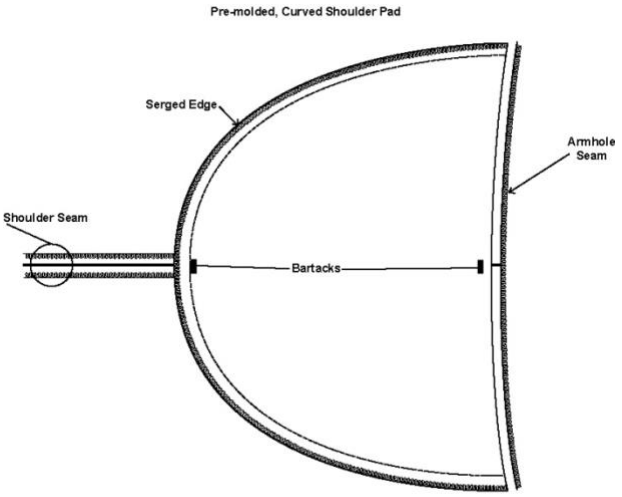
C. The entire armhole shall employ machine lock stitching. Hand or machine "felling" will not be accepted.

D. The underarm portion of the armhole will have a bi-swing gusset allowance that allows freedom of movement.

12. SHOULDER PADS

A. Shoulder pads shall be high quality foam, covered all around with a lightweight polyester lining, serge stitched around the curvature of the pad and are washable or dry cleanable.

B. Shoulder pad size shall be minimum of 5” x 9” on regular width coat styles.

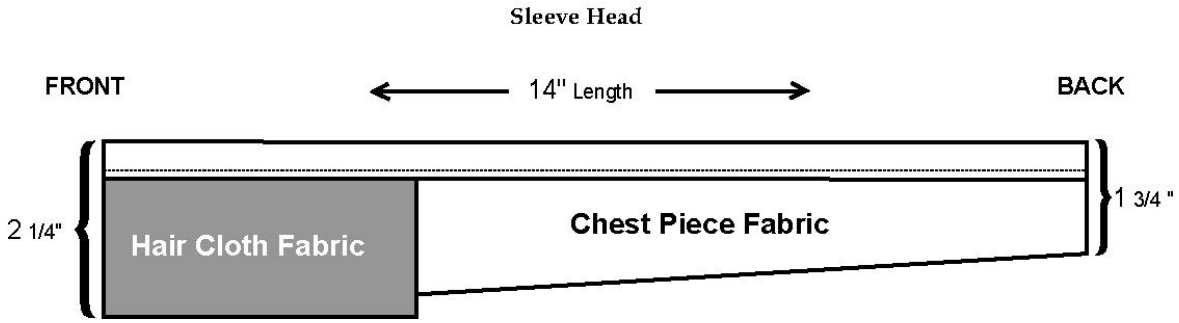


Shoulder Pad View

13. SLEEVE HEADS

The sleeve head 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 chest piece pad in the interlining (10E). 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 Interlining section (10B). 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.



14. 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.

15. 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.

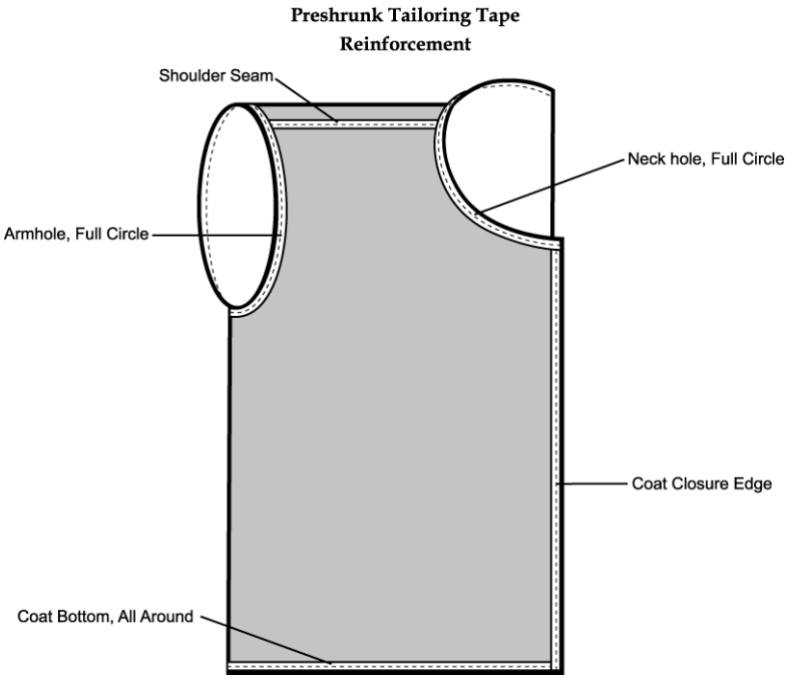
16. TAPING

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.



17. 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 welts of the inside breast pocket are 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.

18. SLEEVES

A. Sleeves cuffs will have an approximate 4" turn up, which incorporates both the coat sleeve fabric and lining. This turn back includes a 3/8" binding at lower cuff edge.

B. The forward and trailing sleeve seams in the 50/50 sleeve pattern are equipped with a series of gripper snap rings and post hardware. Two posts, spaced 1" apart, are applied to the lower sleeve cuff edge, at both seams in each sleeve. Six ring style fasteners are positioned starting 2 ½" up from the cuff edge and are spaced 1" apart. Coats are shipped fully steam pressed, but without a crease at sleeve cuff bottoms.

C. Sleeve cuffs with extensive cuff trim (appliques, inserts, looped braid designs, embroidery) are reinforced with non-woven material, bonded permanently to the inside of the coat fabric extending up toward the elbow area. This addition prevents puckering tendencies created by use of fabrics, braids, etc. which each have a different coefficient of stretching.

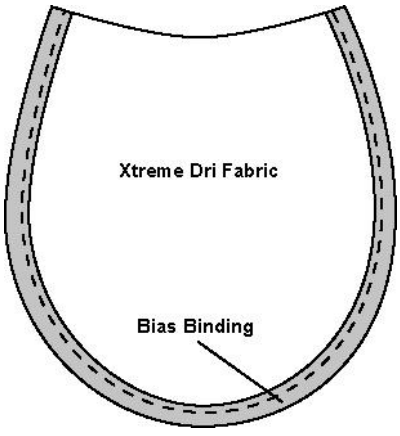
D. Shoulder lettering and embroidered logo trim have a reinforced backing layer on the inside of the sleeve.

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. Xtreme Dri 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 Xtreme Dri 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.

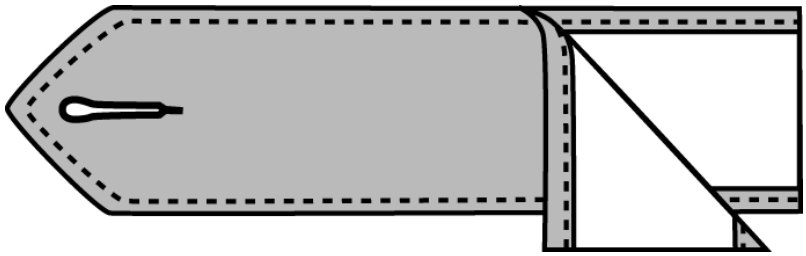
C. Tensile strength and resistance to abrasion are additional advantages of Xtreme Dri armshields as compared to a "felt-like" material. The minimum abrasion quality is 10,000 on the STROLL FLAT test.



20. SHOULDER STRAPS

A. Both the upper and lower layers of the shoulder strap are interlined 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 8).



21. STANDING COMFORT COLLAR

A. The collar is one of the highest stress areas in the coat. The collar is cut from a curved pattern. This allows a front "drop" to fit the downward front slope of the natural human body configuration. This item is NOT to be cut in a straight pattern.

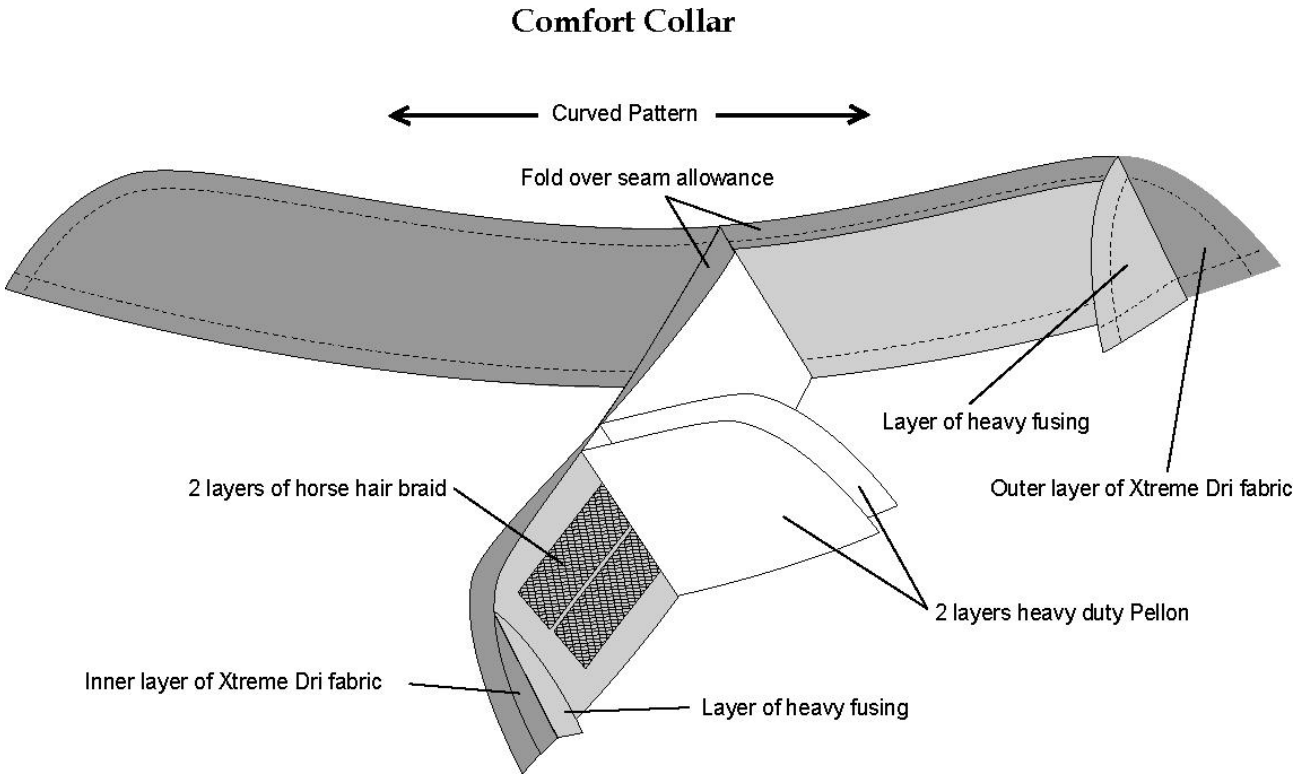
B. There are a total of eight layers in this comfort collar construction.

1. The collar lining of Xtreme Dri fabric, as described in the fabric section (item 4), has a non-woven material, permanently sewn and bonded to the inside.
2. Sewn directly to the inboard surface of this tandem collar lining construction, centered on the lining and running the circumference of the collar are two layers of 3/8" horse hair braid reinforcement.

3. The outer collar shell, also made of Xtreme Dri, has a non-woven material permanently sewn and bonded to the inside.

4. Both the collar lining construction and the outer collar shell construction are sewn to two base layers of heavy duty Pellon forming the finished comfort collar.

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



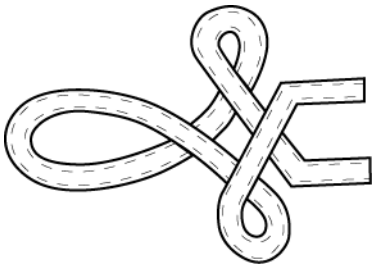
22. "WRAP" COAT COLLAR

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 ¾” finished width. The inside lining is Xtreme Dri fabric having a permanently bonded layer of non-woven fabric to reinforce the collar. The outer layer of the collar is also Xtreme Dri fabric 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.

23. <u>COAT TRIM</u>

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. Washable braid trim of ¼” 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.



24. SPECIAL COAT STYLES

A. Seamless canopy coat styles will require a "Memory Recovery" system across the upper back and shoulders 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 manufacturer's warranty.

25. SEAMS

The center back seam and side body seams shall be 5/8". Seams are to be plain with a minimum of 1 ¼" - 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.

26. THREAD

Threads used throughout the garment will be TEX 40 size, 29/2 gauge and 4.56 lb. tensile strength. All threads used are to be heat resistant, vat dyed, sunfast, dry cleanable pre-shrunk 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 manufacturer's 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.

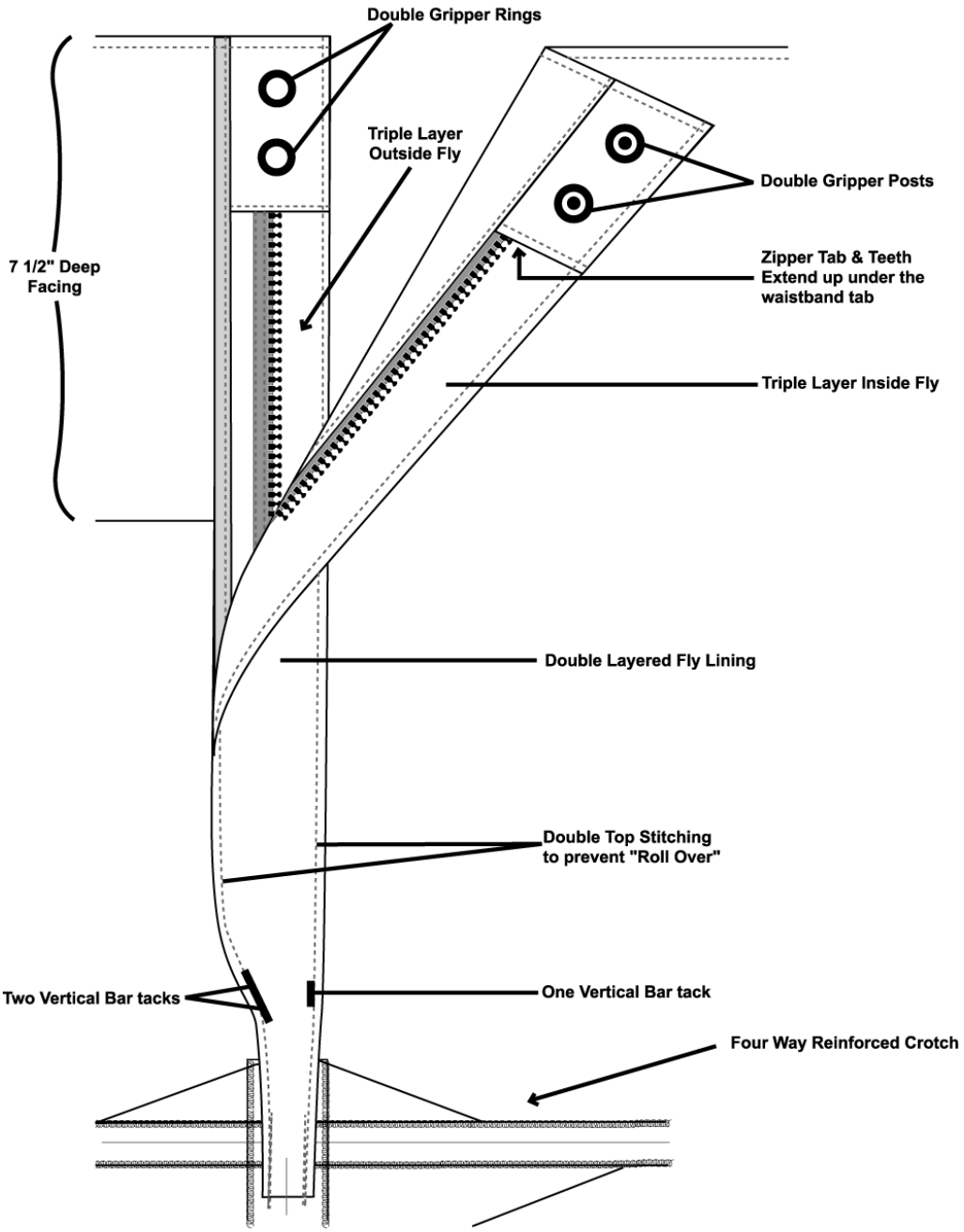
D. The inside fly is constructed with a layer of outer shell fabric having two layers of "four way" fabric sewn to the inside. The "four way" material is 80/20 polycotton, 100% poly fill, 3.5 yards per pound, with a pre-cured finish. This inside fly extends down into the four-way crotch and finishes approximately 1 ¼" 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 ¾" 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 ¾" in width. The inside, three layered front fly measures 2" in width.

Jumpsuit/Bibber Inside View



4. <u>CROTCH REINFORCEMENT</u>

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

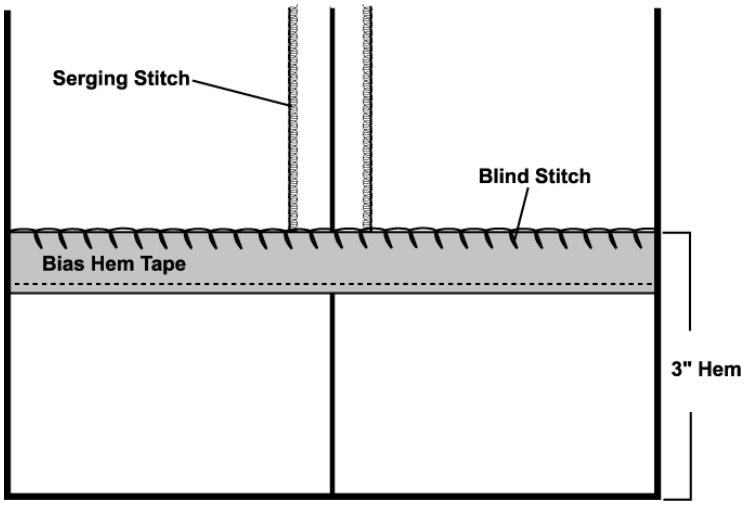
A. Pants pocketing is high grade; acceptable for use by government agencies, 80/20 poly/cotton, 100% textured poly fill, pre-cured finish, 3.5 yards per pound.

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.

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 pellon.

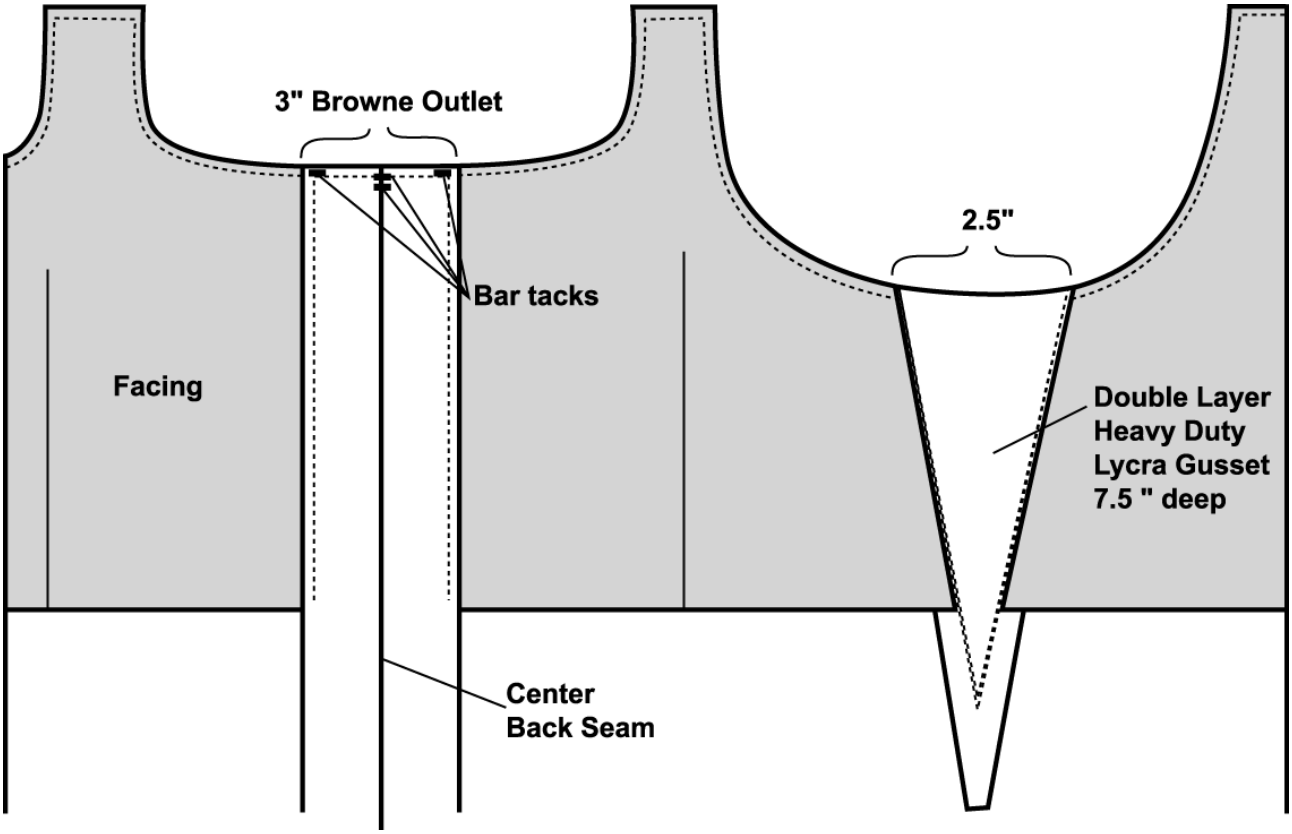
10. PERIMETER SERGING

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. <u>UPPER FACINGS</u>

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

It is important that the shakos be made by the manufacturer of the uniforms. This will insure that all the manufacturer's quality control practices will be followed. The practices include (but are not limited to), workmanship consistent with uniform, fabric matching, and timely delivery.

2. BODY

A. Shako body is vacuum-formed high impact styrene .135" gauge white plastic and has high rubber content to prevent cracking. Body is pliable and flexible to conform to wearer's head, in an "oval" shape, rather than circular or round.

B. There is a separate shell size for each head size.

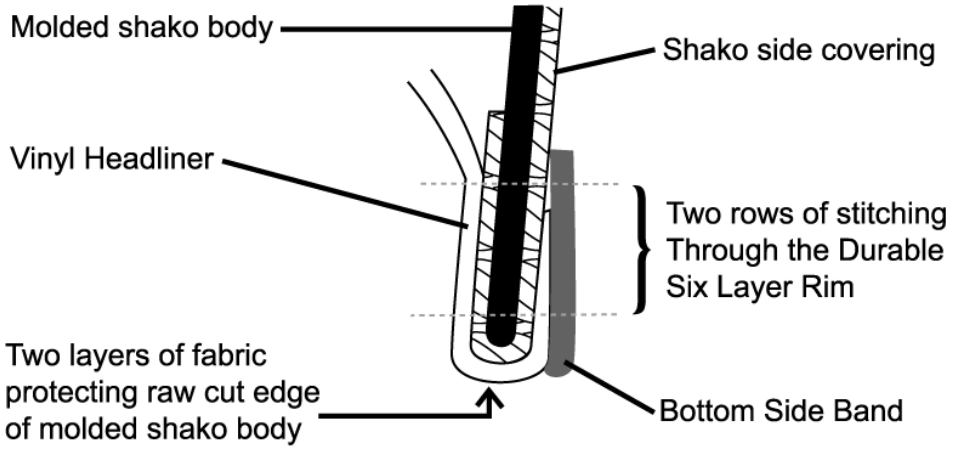
C. Each hat has a clear ident-a-peek pocket in the inside top with the size imprinted in ¼" letters for ease of issue. Each ident-a-peek contains a card to identify the wearer. A size sticker is also applied to the inside top.

3. COVERING

A. The fabric side covering is pulled down to the bottom edge of the shako body, then turned back 1 ½" up inside the shell. Two rows of stitching secures the side covering to the molded shell. One row is polycore poly wrap thread, lock stitched. The second row is Telex 135 poly tex thread, also lock stitched. 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 TURNBACK and VINYL HEADLINER TURNBACK.

Shako Cross Section



4. <u>HEADLINER AND SPECIAL FEATURES</u>

A. Headliner shall be cotton 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 a lockstitch in such a manner to allow for adjustability.

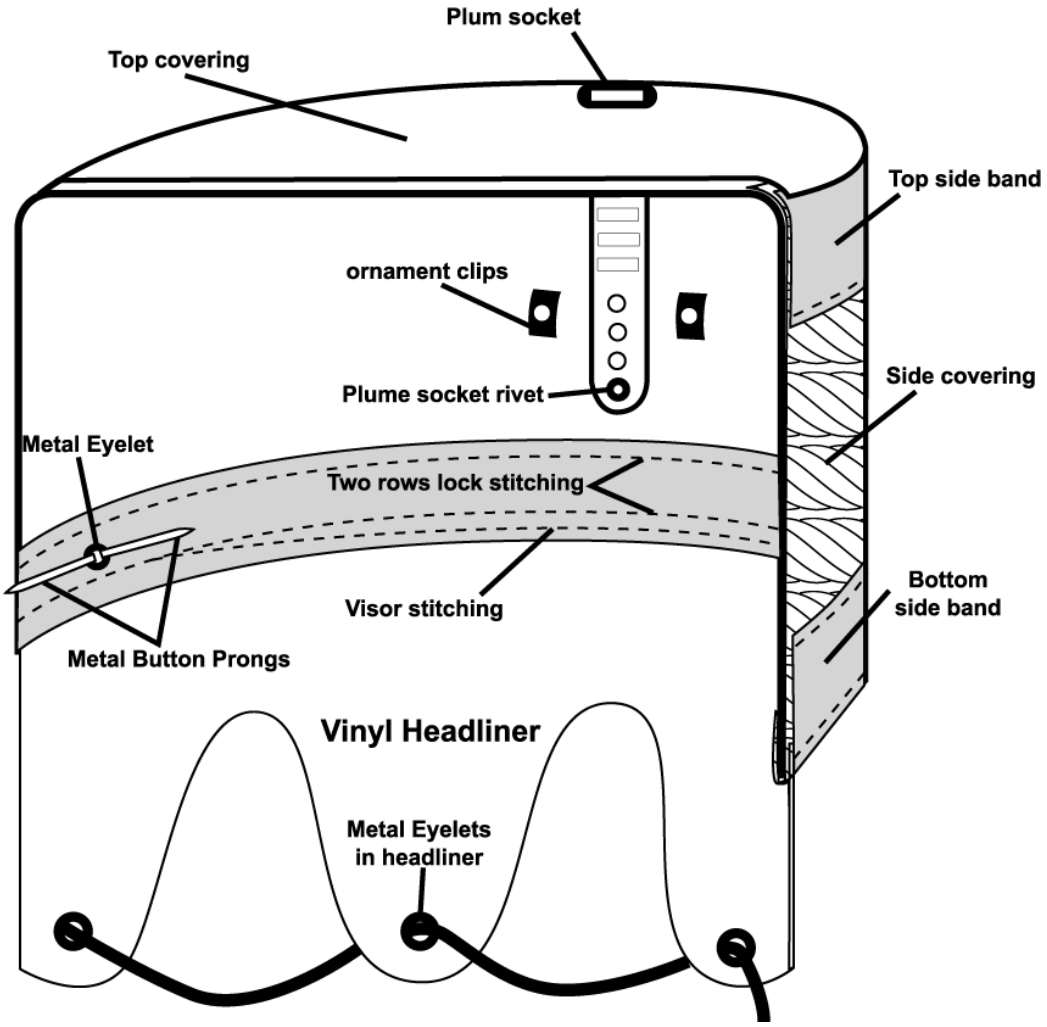
C. Headliner extends around the bottom edge of the plastic body, and stitched through. This results in two layers of material (outer fabric and vinyl headliner) to secure and protect the bottom edge of the shako shell body.

D. There is a metal eyelet on each side of the hat body where the button prong passes through plastic.

E. High density polyethylene plume sockets are included and riveted to the body.

F. A metal spacer is used to affix the front chain to each side button.

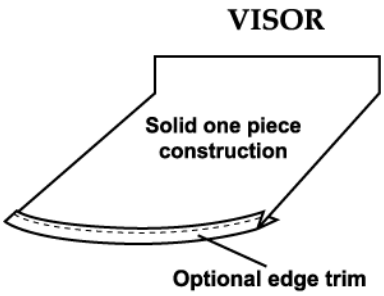
Shako Construction



5. <u>VISOR</u>

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 low-temperature toughness, stain proof, fade and discoloration proof, impervious to ultraviolet light (sunlight).

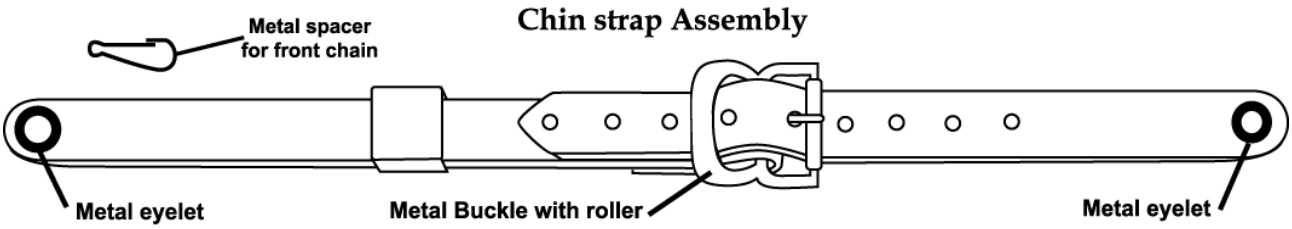


6. CHINSTRAP

A. Chinstrap is ¾" pliable plastic with metal buckle and roller, and has a ½" keeper.

B. There are metal eyelets at chinstrap ends where button attaches (to prevent strap from being torn by button shank).

D. There is a ¾" 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 face plate. Side buttons are metal with spread prongs. Plastic buttons are not acceptable.

SHAKO, HELMET AND BAND ACCESSORY CARRY CASE SPECIFICATIONS

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

MATERIAL: High Impact Polystyrene. This material is heat resistant, which prevents melting, and cold resistant, which resists breakage due to the material becoming brittle.

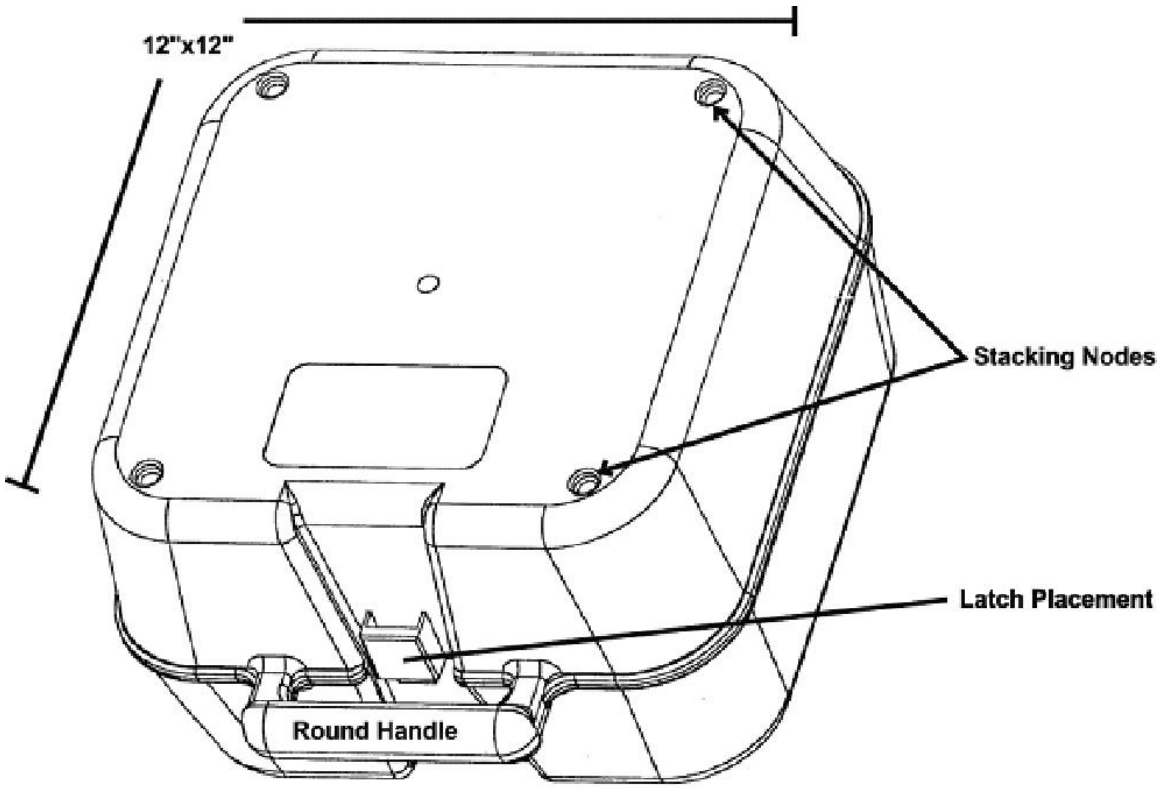
SIZE: 12” by 12” to accommodate headgear and plume as well as various accessory items. Smaller boxes that prevent plume and accessories from being stored are not acceptable.

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.

A) Carry case has a pebble grain finish to compliment appearance and prevent scratching.

B) Inside of box has reinforcement flanges to allow for stability, and aid in stacking when containers are stacked in open position.

C) Carry case is stackable to allow for storage. Stacking nodes are to be on underside of container with receiving units on top.


12"x12"
Stacking Nodes
Latch Placement
Round Handle